Society of Automotive Engineers, Inc.
TWO PENNSYLVANIA PLAZA, NEW YORK, N.Y. 10000

AEROSPACE MATERIAL SPECIFICATION

AMS 2410E
Superseding AMS 2410D
Issued 8-1-45
Revised 5-1-69

SILVER PLATING
Nickel Strike, High Bake

1. ACKNOWLEDGMENT: A vendor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase orders.

2. APPLICATION: Primarily to provide a bearing surface and to prevent galling or seizing of metal surfaces of parts made of corrosion resistant steel or other parts not deleteriously affected by high baking temperatures.

3. PREPARATION:

3.1 Unless otherwise specified, roughness of surfaces to be plated on parts other than nuts shall not exceed 80 microinches prior to cleaning.

3.2 Parts shall be chemically clean when immersed in plating solutions.

3.3 Electrical contacts between the parts and supporting wires or fixtures and between supporting wires and fixtures and bus bar shall be made in such manner as will ensure that neither chemical or immersion deposition nor electrical arcing or localized overheating will occur. If parts are to be plated all over, contact points between the parts and the plating fixture shall, except in the case of barrel plating, be located where specified on the drawing or as agreed upon by purchaser and vendor. If parts are not required to be plated all over, contact points shall be located in areas on which plating is not required or is optional.

4. PROCEDURE:

4.1 Unless otherwise specified, plating of parts shall be conducted in the following sequence, except that the nickel strike may be omitted in plating copper base alloys; process shall be approved by purchaser.

1. Nickel Strike
2. Silver Strike
3. Silver Plate

4.2 Unless otherwise specified, all parts except nuts shall be heated to 940 - 960 F (504.4 - 515.6 C) after plating and held at heat for not less than 20 min. and not more than 1 hr; temperature of the parts shall not be over 400 F (204 C) for more than 7 hr, and above 400 F (204 C) the heating and cooling medium shall be a neutral or reducing atmosphere or a neutral or non-oxidizing molten salt bath. If such heating would lower hardness below drawing limits or otherwise deleteriously affect the parts, heating shall be at the highest practicable temperature which will maintain specified properties.

5. THICKNESS:

5.1 Where "silver flash" is specified, plate thickness shall be approximately 0.0001 inch.

5.2 Thickness of plate other than flash shall be as specified on drawing. If machining of plated metal is required, plate thickness as deposited shall be sufficient to allow machining of all areas of plated surfaces to the dimensions specified on the drawing.