

AEROSPACE MATERIAL SPECIFICATION

Submitted for recognition as an American National Standard

Plating, Brush, Nickel Low Stress, Hard Deposit

1. SCOPE:

1.1 Purpose:

This specification covers the engineering requirements and process controls for brush plating of hard, low stress nickel by electrodeposition. It should be used, in conjunction with AMS 2451, for low stress, hard nickel deposits.

1.2 Application:

This process has been used typically to provide wear resistance and to repair damaged, worn, or mismachined parts in applications requiring hardness, fatigue resistance, and service at temperatures up to 450 °F (232 °C) but usage is not limited to such applications.

1.3 Safety - Hazardous Materials:

See AMS 2451.

2. APPLICABLE DOCUMENTS:

See AMS 2451.

3. TECHNICAL REQUIREMENTS:

The requirements of AMS 2451 shall apply as herein amended.

3.1 Procedure:

3.1.1 Nickel shall be electrodeposited from a sulfamate nickel brush plating solution containing addition agents to produce the specified hardness in accordance with instructions from the solution manufacturer.

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