

Plating, Brush, Chromium  
Hard Deposit, Trivalent

#### RATIONALE

AMS 2451/5A is a Five Year Review and update of this specification.

#### 1. SCOPE

##### 1.1 Purpose

This specification covers the requirements for brush plating of hard chromium by electrodeposition.

##### 1.2 Application

This process has been used typically to improve corrosion and wear resistance, to cosmetically repair chromium deposits and to repair damaged, worn, or mismachined parts 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

See AMS 2451.

##### 3.1 Procedure

3.1.1 Chromium shall be electrodeposited from a trivalent chromium solution in accordance with processing instructions from the solution manufacturer.

##### 3.2 Properties

##### 3.2.1 Hardness

The hardness of the deposit shall be not less than 900 HK, or equivalent, except that this requirement does not apply to deposits specified as cosmetic.

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