

**SUBJECT: Nickel – Cadmium Plating – Diffused (AMS 2416)**

1.0 Purpose: To establish an approved process, requirements and sources for nickel-cadmium plating, diffused.

2.0 Application: This specification shall be used when specified on a drawing or by written instructions from the Engineering Department.

3.0 Specification: The application , preparation , procedure , technical and approval requirements shall be identical to AMS 2416 (latest revision) except paragraphs 4.1 and 4.3 of procedure are amended to read:

4.1 Nickel Plating: Electroless nickel plate per MIL –C-26074, Type I.

4.3 Chromate Treatment: After rising and without drying, parts shall be treated by an approved chromate process which will prevent fingerprinting and staining. Parts shall then be rinsed.

and Paragraph 5.1.1 of Technical Requirements is amended to read:

5.1.1 Nickel Plate: Nickel plating thickness shall be specified as follows:

Class I - .0008-.0010 Thick

Class II - .0005-.0007 Thick

Class III - .0003-.0005 Thick

Drawing call out shall be as follows:

“Nickel – Cadmium Plate per IMC S 82 Class \_\_\_\_\_”

No thickness call out shall be used.

4.0 Approved Sources: See Quality Control Department approved vendor list.