

SURFACE TREATMENT
CHROME PLATING_ DECORATIVE
DSF 1.3.1

Definition:

DECORATIVE: EN ISO 1456: 2009

Components requiring enhanced aesthetics (bright finish) combined with good wear and corrosion resisting characteristics. Substrates may be steel, iron, zinc alloys, copper alloys, aluminium alloys and some plastics (BS ISO 4525:2003).

Coating Type:

DECORATIVE:

The substrate is prepared (surface etched & cleaned then masked with wax). The component first undergoes a copper, then nickel plating prior to the chromium. Aluminium components are first zinc coated, then copper, nickel & chrome.

Various finishing and buffing processes are used in preparing components for decorative chrome plating. The overall appearance of decorative chrome plating is only as good as the preparation.

Plating Thickness:

DECORATIVE: Typical thickness: 0,13µm -1,3µm

Pre-plated substrate surface finish: 0,8 Ra µm (turned) and 0,2Ra µm (ground)

Appearance:

The plated article shall be free from visible plating defects such as blisters, pits or un-plated areas. The plating will be smooth and adherent, clean and free from damage.

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DCR	7135	30040	44725						

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Description:

Nickel chrome plating (**Decorative**) is an electrolytic process. Components are bright nickel plated before a hard, thin plating of chrome is applied to protect the nickel.

The nickel provides the smoothness, most of the corrosion resistance & much of the reflectivity. The chrome adds a slightly 'bluish' hue, protecting the nickel against tarnish & corrosion.

Properties:

- Deposited direct on brass when non-magnetic properties are required.
- Can be deposited on stainless steel to increase corrosion resistance.
- Substrates include zinc, copper & aluminium alloys and some plastics.
- Mirrors underlying finish.

ASM (DEK) Applications:

Components that require a cosmetic (shiny), corrosion & wear resistant finish.

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