


Process Name : Tri Nickel Process

Part Name/No :

Process Step/Operation	Symbol	Operation Steps	Temp	Time mins	Operations
10		Goods Inward Inspection	-	-	Check Incoming material qty Check for plating fitness
20		Polishing	<b>APPROVED</b> <i>By Daniel D at 3:24 pm, Jun 15, 2022</i>		As per Cust reqt.
30		Buffing Inspection	-	-	Check for buffing quality
40		Jigging	-	-	Fix 2no's per jig
50		Soak Cleaing	50°-70°	02-5 mins	Steelex K-20
60		Water Rinse	R.T	2-3Dips	Stationery water
70		Water Rinse	R.T	2-3Dips	Stationery water
80		Cathodic Cleaning	50°-70°	10-15 mins	Steelex K-20
90		Anodic Cleaning	50°-70°	3-5 mins	Ginbond -808
100		Water Rinse	R.T	2-3Dips	Stationery water
110		Activation	R.T	5-10 sec	Sulphuric Acid 10-15%
120		Water Rinse	R.T	2-3Dips	Stationery water
130		DM water	R.T	3-4 Dips	DM water
140		Semi Bright Nickel	50°-70°	40 Mintues	Plating process
150		High Sulphur Nickel	50°-70°	5 Mintues	Plating process
160		Bright Nickel	50°-70°	40 Mintues	Plating process
170		Water Rinse	R.T	2-3Dips	Stationery water
180		Water Rinse	R.T	2-3Dips	Stationery water
190		Bright Chrome	50°-70°	1-2 Min	Chrome Plating
200		Water Rinse	R.T	2-3Dips	Stationery water
210		DM water Dip	R.T	2-3 Dips	D M water
220		Drying	30°-40°	05 - 10mins	Centrifugal Drier
230		Final Inspection	Step Tester	18μ	If not Acc repeat process.

240		Packing/ Dispatch	---	---	Given Racks
R:T = Room temperature, D.M = De Mineralized Water ,					
Issued By : QE					
Approved By: QMR					