

Process Step/Operation	Symbol	Operation Steps	Temp	Time mins	Control Limits	Standards	Operations
10		Goods Inward Inspection	APPROVED By Daniel D at 4:10 pm, Jun 15, 2022		Visual Doc no: F-05-01-00 incoming Inspectiobn Check list	As Per Plan Doc No: F-05-02-00	Check Incoming material qty Check for plating fitness
20		Jigging	-	-	PM Doc No:F-07-01-00	As per OCP/10	Refer Jigs PM Check Sheet & Load the parts as Per Loading Work Instruction
30		US Degreasing	40°-60°	10-15 mins	Timer Temp Controller Lab Analysis	As per OCP/01	Cleaning Process as per Work instruction
40		Water Rinse	R.T	2-3 Dips	-		Running Water
50		Degreasing	50°-70°	5-10 mins	Timer Temp Controller Lab Analysis	As per OCP/01	Cleaning Process as per Work instruction
60		Water Rinse	R.T	2-3 Dips	-	As per OCP/13	Running Water
70		Desmutting	R.T	45-90sec	Timer Temp Controller Lab Analysis	As per OCP/01	Cleaing Process as per Work instruction
80		Water Rinse	R.T	2-3 Dips	-	As per OCP/13	Running Water
90		Albond	R.T	45-90 sec	Timer Temp Controller Lab Analysis	As per OCP/01	Check the Activated surface
100		Water Rinse -01	R.T	2-3 Dips	-	As per OCP/13	Running Water
110		Albond	R.T	2-3 mins	Timer Temp Controller Lab Analysis	Doc no: WI-06-23-	Check the Activated surface
120		Water Rinse	R.T	2-3 Dips	-	As per OCP/13	DM Water
130		Electroless Nickel Medium Phosphours Plating	80°-90°	40-50 Mins	Timer Temp Controller Lab Analysis	As per customert requirement	As Per Work Instruction
140		Water Rinse	R.T	2-3 Dips	-	As per OCP/13	DM Water
150		Water Rinse	R.T	2-3 Dips	-	As per OCP/13	DM Water
160		Electroless Nickel High Phosphours Plating	80°-90°	60-90	Timer Temp Controller Lab Analysis	As per customert requirement	As Per Work Instruction
170		Water Rinse	R.T	2-3 Dips	-	As per OCP/13	DM Water
180		Water Rinse	R.T	2-3 Dips	-	As per OCP/13	DM Water
190		Zinc Nickel (With 15-16% of Ni)	R.T	60-90	Timer Temp Controller Lab Analysis	As per customert requirement	As Per Work Instruction
200		Water Rinse	R.T	2-3 Dips	-	As per OCP/13	DM Water
210		Water Rinse	R.T	2-3 Dips	-	As per OCP/13	DM Water
220		Grey Passivation With Cobalt	30°-50° C	40- 100 Sec	-	As per OCP/05	As Per Work Instruction
230		Water Rinse	R.T	2-3 dips	-	As per OCP/13	DM Water
240		Top Coat	R.T	20- 60 Sec	-	As per OCP/05	As Per Work Instruction
250		Water Rinse	R.T	2-3 dips	-	As per OCP/13	DM Water
260		Drying	50°-70°	10 - 15 mins	-	-	Hot air oven
270		Final Inspection	Thickness	As Per Customer Specification	XRF Instrument	As per Customer Specification	As per work instruction Electroless Nickel Mid Phosphorous : 3μ-4μ Min Electroless Nickel High Phosphorous : 6μ-7μ ZnNi Plating (With 15-16% of Ni) : 10μ-13μ
			Adhesion Test		Bend Test		
			Visual		Doc no: F-05-05-00 Inspection Check list		
280		Packing/ Dispatch	---	---	As per customer requirement	Doc no: F-08-03-00	As per Customer Requirement

R:T = Room temperature, D.M = De Mineralized Water ,