

## Engineering Specifications for Poly-Ond® Metal Plating

### Coefficient of friction

under 200 pound kinetic load — .06

### Salt spray

resistance in salt fog (per ASTM-B-117 test) — 300+ hours

### Continuous operating temperature range

of coated parts is -65°F to +550°F.  
(Intermittent range is -65°F to +750°F.)

### Thickness range

per surface coating — .00005 to .003 per surface\*  
\*(Under special conditions we can plate to .010 +)

### Standard plating thickness

.0005 (± .0001)

### Thickness controllability

± .0001

### Bake temperature range for coating

is 350°F to 750°F. (Unless otherwise specified,  
your component will be processed at our  
standard bake temperature of 700°F.)

### Resultant hardness

as deposited — Rc 50

### Resultant hardness

after 750°F bake for one hour — Rc 68-70

## Technical Information About Poly-Ond® Plating

### Mask Before Plating?

If there are certain sections of a component that you don't want plated ... check with us first. Often we can suggest a course that can save significant dollars. Masking may not be the best answer.

### Residual PTFE.

In some applications, residual PTFE should be removed. In others, leaving it on the component can be a benefit. If you have a question, check with us.

### Plating Dissimilar Materials.

Although we can Poly-Ond® any material, we can't plate dissimilar materials simultaneously.

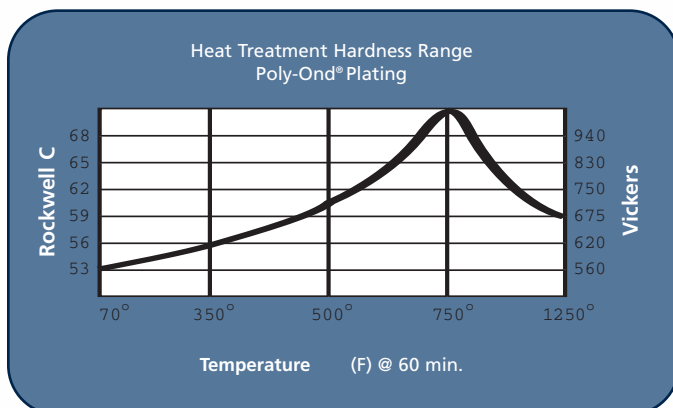
### When Poly-Onded Surfaces Are To Run Against Each Other.

If two Poly-Onded surfaces make friction contact with each other, their surface hardness must be mismatched by 10 Rockwell points or more.

### Stripping Platings.

We can chemically strip Poly-Ond® coating without damaging any parent material.

**If you have specifications to meet that are not on this page ... or if you have a technical question not covered here, we may be able to help.**



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### Poly Coatings of the South

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