

PLATING SPECIFICATIONS

Type	Class 1 Thickness	Class 2 Thickness	Class 3 Thickness	Pre- or Post Plate treatments or Instructions	Federal Specifications
Cadmium	.0005 Min	.0003-.0005	.0002-.0004	None	QQ-P-416 Type I
Cadmium	.0005 Min	.0003-.0005	.0002-.0004	Clear post plate dip	AMS 2400
Cadmium	.0005 Min	.0003-.0005	.0002-.0004	Olive drab iridite	QQ-P-416 Type II
Cadmium	.0005 Min	.0003-.0005	.0002-.0004	Iridescent dichromate	QQ-P-416 Type II
Zinc	.0005 Min	.0003-.0005	.0002-.0004	None	QQ-Z-325 Type I
Zinc	.0005 Min	.0003-.0005	.0002-.0004	Clear bright	AMS 2402
Zinc	.0005 Min	.0003-.0005	.0002-.0004	Olive drab iridite	QQ-Z-325 Type II
Zinc	.0005 Min	.0003-.0005	.0002-.0004	Iridescent dichromate	QQ-Z-325 Type II
Zinc	.0005 Min	.0003-.0005	.0002-.0004	Supplementary Phosphate	QQ-Z-325 Type III
Silver	.0005 Min	.0003-.0005	.0002-.0004	Nickel strike	AMS 2410
Black Oxide		18-8 Stainless	Alloy Steel or Carbon Steel		AMS 2485 MIL-DTL-13924
Dull Nickel	.0005 Min	.0003-.0005	.0002-.0004		QQ-N-290 Class 2
Dull Chrome	.0005 Min	.0003-.0005	.0002-.0004		QQ-C-320 Class 2
Copper	.0005 Min	.0003-.0005	.0002-.0004		AMS 2418
Tin	.0005 Min	.0003-.0005	.0002-.0004		AMS 2408
Phosphate Class A (Parker-Lubrite)		Non-Drying Oil	Dry	Manganese-Zinc-Iron Phosphate	AMS2481
Phosphate Class B (Parkerizing)		Drying Oil	Dry	Zinc-Iron Phosphate	AMS 2480 MIL-P-16232
Cadmium		.0003-.0005	.0002-.0004	Black dye over Olive drab iridite	QQ-P-416 Type II Except color
Chemical Film Magnesium				Dichromate	AMS 2475
Silver	.0005 Min	.0003-.0005	.0002-.0004	Copper strike	AMS 2412
Nickel Cadmium		.0001-.0002 CAD	.0002-.0004 NI	Thermal treat 630° for 3 hours	AMS 2416
Cadmium	.0005 Min	.0003-.0005	.0002-.0004	Supplementary Phosphate	QQ-P-416 Type I
Nickel-Zinc Alloy		.0003-.0007	.0002-.0004	Nickel strike	AMS 2417

FORMULA FOR THREAD SIZE BEFORE PLATING

In computing thread pitch diameter before plating, it has been general practice to follow the rule that the pitch diameter size of an external screw thread is theoretically increased 4 times the plating thickness. However, variables in thickness of coating, symmetry of coatings resulting from commercial processes, extreme lengths have necessitated a revision of the theoretical allowance. The following formulas are offered as general references for Class 2A and 3A thread fits before plating.

Screw Diameter	Pitch Dia. Reduction Maximum	Pitch Dia. Reduction Minimum
No. 0-3	4x Max Plating Thickness	3x Min Plating Thickness
No. 4-12	4x Max Plating Thickness	4x Min Plating Thickness
1/4 – 1/2	5x Max Plating Thickness	4x Min Plating Thickness
9/16 and up	6x Max Plating Thickness	4x Min Plating Thickness