


DATE <u>7-15-52</u>	<b>TMC SPECIFICATION NO. S 105</b>	<b>A</b>
SH. <u>1</u> OF <u>1</u>		
COMPILED BY	TITLE: <u>CADMIUM PLATE</u>	JOB
APPROVED 		

**PURPOSE:**

The purpose of this specification is to outline a treatment to be used with steel, copper and brass to protect the surface and increase their resistance to corrosion.

**REQUIREMENT:**

The material to be plated shall be substantially free from flaws or defects that will be detrimental to the final finish. It shall be subjected to such cleaning, polishing, pickling and plating procedures as are necessary to yield deposits with the desired appearance and quality. When springs are plated, they shall not be acid pickled previous to plating and shall be properly treated after plating to eliminate any embrittlement. The finish coating shall have uniform lustrous and fine grained structure, shall be adherent and free from blister, and substantially free from other defects that may affect the appearance or protective value of the coating. Plating and subsequent treatment shall be such as to prevent brittleness of the plated material.

**THICKNESS:**

Material shall have a minimum thickness of deposit on its surface as follows:

General surface-----0.0003 inch  
 Threads -----0.0002 to 0.0003 inch.

**APPLICABLE SPECIFICATIONS:**

QQ-P-116 and latest amendments. TYPE II YELLOW  
 MIL-F-14072

UNDERCOAT FOR PAINT OR PROTECTION:(To be applied only when specified)

After the material has been plated it shall be treated with Bright Iridite #4-1. in accordance with Specification 106.

**SHIPPING AND MARKING:**

All plated material shall be shipped in suitable containers to give maximum protection during transit.

All containers shall be plainly marked with the purchase order number, manufacturer's name and TMC part number.

