



AEROSPACE MATERIAL SPECIFICATIONS

SOCIETY OF AUTOMOTIVE ENGINEERS, Inc.

485 Lexington Ave., New York, N. Y. 10017

AMS 2410D

Superseding AMS 2410C

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SILVER PLATING Nickel Strike, High Bake

1. ACKNOWLEDGMENT: A vendor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase orders.
2. APPLICATION: Primarily to provide a bearing surface and to prevent galling or seizing of metal surfaces of parts made of corrosion resistant steel or other parts not deleteriously affected by high baking temperatures.
3. PREPARATION:
 - 3.1 Unless otherwise specified, roughness of surfaces to be plated on parts other than nuts shall not exceed 80 microinches prior to cleaning.
 - 3.2 Parts shall be chemically clean when immersed in plating solutions.
 - 3.3 Electrical contacts shall be made in such manner as will ensure that no chemical or immersion deposition will occur.
4. PROCEDURE:
 - 4.1 Unless otherwise specified, plating of parts shall be conducted in the following sequence, except that the nickel strike may be omitted in plating copper base alloys; process shall be approved by purchaser.
 1. Nickel Strike
 2. Silver Strike
 3. Silver Plate
 - 4.2 Unless otherwise specified, all parts except nuts shall be heated to 940 - 960 F (504.4 - 515.6 C) after plating and held at heat for not less than 20 min. and not more than 1 hr; temperature of the parts shall not be over 400 F (204 C) for more than 7 hr, and above 400 F (204 C) the heating and cooling medium shall be a neutral or reducing atmosphere or a neutral or non-oxidizing molten salt bath. If such heating would lower hardness below drawing limits or otherwise deleteriously affect the parts, heating shall be at the highest practicable temperature which will maintain specified properties.
5. THICKNESS:
 - 5.1 Where "silver flash" is specified, plate thickness shall be approximately 0.0001 inch.
 - 5.2 Thickness of plate other than flash shall be as specified on drawing. If machining of plated metal is required, plate thickness as deposited shall be sufficient to allow machining of all areas of plated surfaces to the dimensions specified on the drawing.
6. QUALITY:
 - 6.1 Silver as plated shall be not less than 99.9% pure, but actual determination of purity shall not be required as a routine inspection procedure; the process of plating shall be controlled to produce this purity.