

# PLATERONICS PROCESSING

Form-029 Revised: 11/10/17

## Minimum Plating Charges (effective 1/1/2013)

<u>Process</u>	<u>Specification</u>	<u>Minimum</u>
Sulfuric Anodize (non-dyed)	MIL-A-8625 Ty II, CI 1	60.00
Sulfuric Anodize (dyed or dichromate seal)	MIL-A-8625 Ty II, CI 2	65.00
Hard Anodize (non-dyed)	MIL-A-8625 Ty III, CI 1	75.00
Hard Anodize (dyed)	MIL-A-8625 Ty III, CI 2	85.00
Hard Anodize (dyed or non-dyed with teflon coating)	MIL-A-8625 Ty III, CI 1	125.00
Chemical Film (Yellow)	MIL-C-5541 CI 1A or 3	50.00
Chemical Film (Clear, RoHS compliant)	MIL-DTL-5541 Ty II	60.00
Clean, Etch, Strip, or Abrasive Blast		50.00
Bright Dip		50.00
Passivation	QQ-P-35 or Equivalent	65.00
Copper	MIL-C-14550	65.00
Copper (Heavy Buildup)	AMS 2418 Ty II	95.00
Tin (Bright)	ASTM B545/MIL-T-10727 Ty I	65.00
Zinc (w/chromate or w/o chromate)	ASTM-B633 Ty I, V, VI	65.00
Black Zinc	ASTM-B633 Ty II	75.00
Electroless Nickel	MIL-C-26074 CI 1	75.00
Electroless Nickel	CI 3,4	100.00
Electroless Nickel	CI 2	140.00
Bright Nickel	QQ-N-290	65.00
Silver	QQ-S-365 Ty 1,2	125.00
Gold	MIL-G(DTL)-45204 Ty II, II, III	150.00
Mask		50.00
Bake (stress and embrittlement relief)	( 4 hrs and over)	70.00
Bake (stress and embrittlement relief)	(under 4 hrs)	40.00
Stripping (most metals and substrates)		65.00

If multiple processes are used, the minimum lot charges for two of the higher priced processes added together will apply. Information that is necessary in processing parts include: Applicable Specification(s), alloy and temper or Condition of material, thickness of plating required, close tolerances, critical areas to be free of rack marks, masking requirements. Please provide drawing whenever possible. Several items may be mixed to meet a single minimum lot charge by meeting the following criteria: The items must be of the same material and of similar configuration. They must be plated using the same process requirements and not require separate racking or tank runs.