



## CORPORATE STANDARD

AA 067 36 11

Rev. No. 03

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### PROCESS FOR ELECTROPLATING BRIGHT TIN FROM ACID BATH ON FERROUS AND NON-FERROUS METAL PARTS

#### 1.0 GENERAL:

This standard details the process for bright tin plating by vat or barrel from an acid tin solution on steel, copper & copper alloys to protect them against corrosion, to provide good surface for soldering and also to provide minimum contact resistance of joints and for masking during nitriding.

#### 2.0 APPLICATION:

Used for bus-bar and spout connections, cables, sockets, connection cams, brush holder, cable glands, clamp plates, support plating clamps, brackets, hardware, etc.

#### 3.0 COMPLIANCE WITH NATIONAL STANDARDS:

There is no National Standard covering this Standard. However, assistance has been derived from the following National Standard in respect of surface condition and quality of deposit.

IS:1359 : Electroplated Coatings Of Tin in Respect of Surface Condition & Quality of Deposit.

#### 4.0 MATERIALS:

Material	IS No. / Available From
Sulphuric Acid (C.P. Grade)	: IS : 266
Tin Anodes	: IS : 2384
Activated Carbon Powder-Pure	: IS : 8366
Stannous Sulphate (Electroplating Grade)	: M/s Grauer & Weil (I) Ltd and M/s Artek Surfin Chemicals (P) Ltd. Bombay
Tinbrite Make-up Brightner	: M/s Grauer & Weil (I), Limited, Bombay.
Teknolume Carrier Additive	: M/s Artek Surfin Chemicals (P) Ltd. Bombay.

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