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White Paper

Title: Do it Once, Do it Right: Surface Preparation for Plating Revision Date: July 10, 2019

Do it Once, Do it Right: Surface Preparation for Plating

Identify the physical characteristics and evaluate the condition of the parts. Determine whether or not the plated finish must meet a certain spec (ASTM, MIL, etc.) or merely needs to be a bright and functional coating. Naturally, equipment and chemical process



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- iii. Is live entry required or is dead entry OK? This is critical as the chemistry of the intended plating solution may chemically etch or dissolve the allimportant zincate coating.
- iv. Some plating solutions are specifically formulated to successfully plate over zincated aluminum. Confirm using the correct plating solutions.
- a. All surface preparation and activation baths should be analyzed and balanced in concentration for optimum surface conditioning of parts.
- b. Replace any spent baths with fresh make ups.
- c. Plating baths should also be analyzed and adjusted for optimum performance. This should include a hull-cell evaluation.
- Heaters in the soak and electro deaner must achieve and maintain desired temperature. Agitation where required should be in good operating order.
- b. Rectifiers can be tested for accurate current output. Bus connections must be dean and tight. Make sure the positive bus from the rectifier connects to the anode bar on the plating tank. Confirm the same for negative bus connection to the cathode bar.
- c. If the plating line is a junior or senior return type, check for any dead stations in plating and correct the problem.
- d. Plating barrels and racks should provide good service performance.
- a. After all checks and corrections have been made, process a limited quantity of parts as a final confirmation that the line will produce the required plated finish.