

Plating Specifications held by Jackson Plating Limited

BSI Standards

All the specifications listed below are held on file

Most of the listed specs have been withdrawn and/or superseded and are for reference only.

Withdrawn/superseded specs are highlighted in RED.

Current specifications are highlighted in GREEN.

BS 3382

PARTS 1&2

ELECTROPLATED COATINGS ON THREADED COMPONENTS - ZINC

PARTS 3&4

ELECTROPLATED COATINGS ON THREADED COMPONENTS – NICKEL/CHROME

PARTS 5&6

ELECTROPLATED COATINGS ON THREADED COMPONENTS – TIN/SILVER

PART 7

ELECTROPLATED COATINGS ON THREADED COMPONENTS – THICKER PLATINGS

BS 7371-12:2008

COATINGS ON METAL FASTENERS

BS EN 12329:2000

COATINGS OF ZINC WITH SUPPLEMENTARY TREATMENT ON IRON OR STEEL

BS EN ISO 2081:2008

COATINGS OF ZINC WITH SUPPLEMENTARY TREATMENT ON IRON OR STEEL

BS EN ISO 2081:2018

METALLIC & OTHER INORGANIC COATINGS - ZINC WITH SUPPLEMENTARY TREATMENT ON IRON OR STEEL

BS 1224:1970

ELECTROPLATED COATINGS OF NICKEL AND CHROMIUM

BS EN 12540:2000

COATINGS OF NICKEL, NICKEL PLUS CHROMIUM, COPPER PLUS NICKEL AND COPPER PLUS NICKEL PLUS CHROMIUM

BS EN ISO 1456:2009

COATINGS OF NICKEL, NICKEL PLUS CHROMIUM, COPPER PLUS NICKEL AND COPPER PLUS NICKEL PLUS CHROMIUM

BS EN ISO 4527:2003

METALLIC COATINGS – ELECTROLESS NICKEL

BS 1615:1987

ALUMINIUM & ALUMINIUM ALLOYS – METHODS

BS EN 12373-1:2001

ALUMINIUM & ALUMINIUM ALLOYS – METHODS

BS EN ISO 7599:2010

ALUMINIUM & ALUMINIUM ALLOYS – GENERAL SPECIFICATIONS FOR COATINGS

BS EN ISO 7599:2018

ALUMINIUM & ALUMINIUM ALLOYS – GENERAL SPECIFICATIONS FOR COATINGS

BS 4292 PART 2:1989

GOLD AND GOLD ALLOYS

ISO 8080:1986

ANODIC COATING OF TITANIUM & TITANIUM ALLOYS (SULPHURIC)

ISO 8080:2021

ANODIC COATING OF TITANIUM & TITANIUM ALLOYS (SULPHURIC)

BS 5599:1993	HARD ANODISE COATINGS FOR ENGINEERING PURPOSES
BS ISO 10074:2010	SPECIFICATION FOR HARD ANODIC OXIDATION COATINGS ON ALUMINIUM AND ITS ALLOYS
BS ISO 10074:2017	SPECIFICATION FOR HARD ANODIC OXIDATION COATINGS ON ALUMINIUM AND ITS ALLOYS
BS ISO 10074:2021	SPECIFICATION FOR HARD ANODIC OXIDATION COATINGS ON ALUMINIUM AND ITS ALLOYS
BS 1872:1984	COATINGS OF TIN
BS EN 12476:2000	PHOSPHATE CONVERSION COATINGS
BS EN ISO 9717:2013	PHOSPHATE CONVERSION COATINGS
BS EN ISO 9717:2017	PHOSPHATE CONVERSION COATINGS
BS 2816:1989	SILVER COATINGS FOR ENGINEERING PURPOSES, SPECS AND TEST METHODS
BS EN ISO 4521:2008	SILVER COATINGS FOR ENGINEERING PURPOSES, SPECS AND TEST METHODS
BS ISO 9588:2007	POST COATING TREATMENTS OF IRON OR STEEL TO REDUCE THE RISK OF HYDROGEN EMBRITTLEMENT
ISO 4042:2000	ELECTROPLATED COATINGS
ISO 4042:2022	ELECTROPLATED COATINGS

All Def Standards are available on file for reference only

These specifications can still be used for legacy products but are not recommended for new products

AMS series replacements are listed, but these are NOT held on file as not being called for by our Customers

DEF STAN 03-2	SAE AMS 03-2	CLEANING AND PREP OF METAL SURFACES
DEF STAN 03-5		ELECTROLESS NICKEL
DEF STAN 03-9	SAE AMS 03-9	ELECTRO DEPOSITON OF SILVER
DEF STAN 03-11	SAE AMS 03-11	PHOSPHATE
DEF STAN 03-14	SAE AMS 03-14	CHROMIUM
DEF STAN 03-17		GOLD
DEF STAN 03-18	SAE AMS 03-18	ALOCROM – CHROMATE CONVERSION
DEF STAN 03-20	SAE AMS 03-20	ZINC
DEF STAN 03-24		CHROMIC ANODISE
DEF STAN 03-25	SAE AMS 03-25	SULPHURIC ANODISE
DEF STAN 03-26		HARD ANODISE
DEF STAN 03-27	SAE AMS 03-27	NICKEL
DEF STAN 130	DEF-SPEC-130	CHROMATE PASSIVATE AND ZINC SURFACES
DEF STAN 151		ANODISING ALUMINIUM & ALUMINIUM ALLOYS
DEF STAN 21-5		CODE OF PRACTICE

DEF STAN 03 Series now AMS 03 Series

DEF STAN standards are released by the U.K. Defence Standardization Program, part of the U.K. Department of Defence. The DEF STAN 03 series has been an important documentation series for military/defence manufacturing companies. However, like many of the U.S. Defence documentation, now they are being migrated over to the oversight of the aerospace organization, SAE International. The new AMS editions replace the Def Stan publications and have been issued under the Open Government Licensing Agreement.

Here's a list of the items that were released.

- AMS-03-2, "Cleaning and Preparation of Metal Surfaces"
- AMS-03-9, "Electro-Deposition of Silver"
- AMS-03-11, "Phosphate Treatment of Iron and Steel"
- AMS-03-14, "Electrodeposition of Chromium for Engineering Purposes"
- AMS-03-17, "Electro-Deposition of Gold"
- AMS-03-18, "Chromate Conversion Coatings (Chromate Filming Treatments) Grades: Standard and Brushing for Aluminium and Aluminium Alloys"

These specifications can still be used for legacy products but are not recommended for new products. We suggest that customers consider the following replacements:

Cancelled Def Stan	Treatment	Jackson Plating Ltd.'s Preferred Replacement
Def Stan 03-2 Process M Passivation	Stainless Steel Passivation	ASTM A967 / ASTM A380 / QQ-P-35
Def Stan 03-18	Chromate Conversion Coating	Since hexavalent conversion coatings are being phased out, we do not recommend changing this specification.
Def Stan 03-20	Zinc Plating	BS EN ISO 2081
Def Stan 03-25	Sulphuric Acid Anodising	For commercial applications we suggest BS EN ISO 7599:2018 and for aerospace applications we recommend MIL-A-8625 Type 2.
Def Stan 03-26	Hard Anodising	This was superseded long ago by BS 5599, which has in turn been superseded by BS ISO 10074:2017

Please note the above are suggestions and not official advice from DSTAN. There is no formal path for replacement of most of the Def Stan's because they have been cancelled not superseded

Military Standards

www.everyspec.com is the source for free downloads of Military standards, specifications and documents. The most popular standards/specifications used by our customers are kept on file for ease of use / reference.

MIL-A-8625 F	ANODIC COATINGS FOR ALUMINUM AND ALUMINUM ALLOYS
MIL-C-5541 E	CHEMICAL CONVERSION COATINGS ON ALUMINUM AND ALUMINUM ALLOYS
MIL-DTL-5541 F	CHEMICAL CONVERSION COATINGS ON ALUMINUM AND ALUMINUM ALLOYS
MIL-DTL-81706	CHEMICAL CONVERSION MATERIALS FOR COATING ALUMINUM AND ALUMINUM ALLOYS
MIL-C-26074 E	COATINGS, ELECTROLESS NICKEL
ASTM A967	CHEMICAL PASSIVATION TREATMENTS FOR STAINLESS STEEL PARTS
QQ-P-35	PASSIVATION TREATMENTS FOR CORROSION RESISTANT STEEL
ASTM A380	CLEANING, DESCALING AND PASSIVATION OF STAINLESS STEEL PARTS
AMS 2485	COATING, BLACK OXIDE
MIL-DTL-45204 D	GOLD PLATING
MIL-F-495 E	FINISH, CHEMICAL, BLACK, FOR COPPER ALLOYS
MIL-DTL-13924	COATING, OXIDE, BLACK, FOR FERROUS METALS

Customer Specifications

The following specifications are held on file

PS002	COPPER PLATE	Sondex Wireline Chirton Engineering MOJ Engineering Duncan Lynch Precision BSL Industries Di-Spark Limited Lexel Engineering Premier Precision Engineering Duckworth and Kent
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UNCONTROLLED COPIES

114. C.1	ANODISING OF ALUMINIUM	Surface Technology/Hadleigh Castings
114-C-8	CHROMATE CONVERSION COATINGS	Hadleigh Castings
7-007	SILVER PLATING	Chad Engineering
7-008	ELECTROLESS NICKEL PLATING	Chad Engineering
SDS115/58	ZINC AND PASSIVATE	
SDS115/61	ZINC AND PASSIVATE	
P59F	ALUMINIUM CONVERSION COATING	Paramount Precision (Thales)
DS 16.52	CHEMICAL CONVERSION COATINGS	CGC Tech (Cobham spec)
DS 26.03	ANODISING OF ALUMINIUM	CGC Tech (Cobham spec)
88-1-217	ELECTROLESS NICKEL	Instron
88-1-236X	CHROME PLATING	Instron

Aim Aviation specs (Glenmore-Hane)

2-01	SATIN ANODISE
2-02	CHROMIC ANODISE
2-03	HARD ANODISE
2-08	ALOCROM 1200
2-09	ANODISE NATURAL
2-11	HARD ANODISE BLACK
2-12	HARD ANODISE – BONDING PRIMER SEALED
3-04	DULL NICKEL PLATE
3-05	NICKEL PLUS CHROMIUM
3-06	COPPER PLUS NICKEL PLUS CHROMIUM
3-07	TIN PLATING
3-08	BRIGHT NICKEL
3-09	ZINC & PASSIVATE
03-11	HARD CHROME OF ST. STEEL