

THE PROCESS

Pioneer's family of electroless nickel plating methods offer a variety of solutions to meet your finishing requirements. Each of our proprietary electroless nickel processes can be engineered to meet different hardness and/or corrosion protection needs.

Process	Hardness		Wear Suga	Corrosion Salt Spray (.001")	Lubricity C.O.F.	Description	Major Benefit
	Rc	Knoop					
Nor-Last™							
As Plated	64	822	7 mg	100 hrs	0.18	Nor-Last™ offer the best wear protection of our electroless nickel finishes approaching the ability of hard chrome.	Surface hardness and supreme wear resistance increasing tooling longevity 2.5 to 4 times.
Baked	70	970	5 mg	48 hrs	0.21		
Nor-Kote I™							
As Plated	44	452	15 mg	100 hrs	0.18	Pioneer Metal Finishing's standard electroless nickel process.	Hardness and good wear resistance.
Baked	68	920	13 mg	24 hrs	0.32		
Nor-Kote II™							
As Plated	68	900	13 mg	24 hrs	0.157	Added PTFE surface treatment.	Improved surface lubricity and release properties.
Nor-Kote III™							
As Plated	68	900	13 mg	24 hrs	0.187	Combination of proprietary surface pretreatment of the base metal and PTFE surface treatment.	Improved surface lubricity and release properties.
Nor-Guard™							
As Plated	45	466	13 mg	1200 hrs	0.15	Pioneer Metal Finishing's most corrosion resistant electroless nickel process.	Supreme corrosion protection.
Nor-Lube™							
As Plated	25	275	53	100 hrs	0.116	Electroless nickel process with occluded PTFE particles.	Offering supreme lubricity.
Baked	44	450	25	100 hrs	0.116		

Pioneer Metal Finishing offer Electroless Nickel processes that are Cadmium-Free and Lead-Free and are ELV, RoHs & WEEE compliant.

PERFORMANCE BENEFITS

- Abrasion & Corrosion Resistance
- Uniform Plating, No Edge Build Up
- Natural Surface Lubricity
- Post Machining Unnecessary
- Well-suited for Salvage Work
- Food Grade Approved

THE OVERVIEW

ELECTROLESS NICKEL

Yielding excellent wear and corrosion resistance, electroless nickel is an autocatalytic plating process resulting in a reflective layer of nickel-phosphorous. This plating process provides an extremely uniform coating on all surfaces, making post machining unnecessary when dimensions are accurate.

[CLICK HERE TO VIEW IMAGES OF THIS PROCESS](#)

RECEPTIVE METALS

- Aluminum
- Stainless Steel
- Brass
- Iron Alloys
- Copper

THICKNESS

.0001 - .005"

TOLERANCES

+/- .0001

MAX PART SIZE

12' X 30" x 30"

SPECIFICATIONS

- ASTM B 733
- AMS 2404
- TYPE I, III, IV, V
- CLASSES 1-6
- Approved for food grade applications



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