

ES-88-A: FINISH SPECIFICATION - NICKEL

1.0 SCOPE

This specification defines the requirements for all NICKEL finishes on metallic surfaces.

2.0 PURPOSE

To define the standard finish characteristics and finish codes along with their minimum and maximum layer requirements.

3.0 REFERENCE DOCUMENTS

ES-88 Molex Finish Specification

4.0 DEFINITIONS

4.1 Finish Specification Codes

4.1.1 Nickel Only Overall

Note: See ES-88 for specific material properties, quality, packaging, etc. details.
Conversion factor $1\mu\text{m} = 39.37\mu\text{in}$

PROCESS CODE	APPEARANCE CODES	FINISH CODE	OVERALL NICKEL MIN μin (μm) MAX μin (μm)	OBSOLETE/ RECOMMENDED
		910	30(0.76)	NOT RECOMMENDED
E		981	120(3.05)	
		982	80(2.03)	
		983	160(4.06)	
		991	50(1.27)	
	B	994	100(2.54)	
		995	250(6.35) 400(10.16)	
		996	80(2.03) 160(4.06)	

UNLESS OTHERWISE SPECIFIED MAXIMUM FINISH THICKNESS ALLOWED ABOVE MINIMUMS:

Continuous and batch plating:

Nickel	Continuous plating	50 μ " (1.27 μm)
	Batch plating	50 μ " (1.27 μm)

REVISION: C1	EC INFORMATION: EC No: 663282 DATE: 2021/05/08	TITLE: FINISH SPECIFICATION NICKEL	SHEET No. 1 of 2
DOCUMENT NUMBER: ES-88-A	CREATED / REVISED BY: MANOHARA HV	CHECKED BY: SHIVA B ARALI	APPROVED BY: SHIVA B ARALI

4.1.2 Nickel Over Copper Overall

Note: See ES-88 for specific material properties, quality, packaging, etc. details.
Conversion factor 1µm = 39.37µin

PROCESS CODE	APPEARANCE CODES	FINISH CODE	OVERALL NICKEL MIN µin (µm) MAX µin (µm)	OVERALL COPPER MIN µin (µm) MAX µin (µm)	OBSOLETE/ RECOMMENDED
		980	70(1.78) 150(3.81)	30(0.76) 150(3.81)	
		984	120(3.05)	4(0.10) 10(0.25)	
		985	280(7.11)	200(5.08)	
		986	80(2.03) 160(4.06)	30(0.76)	
		997	200(5.08)	10(0.25) 20(0.51)	

UNLESS OTHERWISE SPECIFIED MAXIMUM FINISH THICKNESS ALLOWED ABOVE MINIMUMS:

Continuous and batch plating:

Nickel	Continuous plating	50µ" (1.27µm)
	Batch plating	50µ" (1.27µm)
Copper	Continuous plating	50µ" (1.27µm)
	Batch plating	100µ" (2.54µm)

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DOCUMENT NUMBER: ES-88-A	CREATED / REVISED BY: MANOHARA HV	CHECKED BY: SHIVA B ARALI	APPROVED BY: SHIVA B ARALI