ES-88-G: FINISH SPECIFICATION – GOLD OVER PALLADIUM NICKEL ALLOY

1.0 SCOPE
This specification defines the requirements for all HARD GOLD OVER PALLADIUM NICKEL ALLOY 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 Hard Gold over 80/20 Palladium Nickel Alloy over Nickel 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 HARD GOLD MIN µin (µm) MAX µin (µm)	OVERALL 80/20 Pd/Ni MIN µin (µm) MAX µin (µm)	OVERALL NICKEL MIN µin (µm) MAX µin (µm)	OBSOLETE/ RECOMMENDED
		821	2(0.05) 10(0.25)	30(0.76)	50(1.27)	OBSOLETE
		822	2(0.05) 10(0.25)	30(0.76)	30(0.76)	
		823	2(0.05) 10(0.25)	40(1.02)	50(1.27)	
		824	2(0.05) 10(0.25)	40(1.02) 60(1.52)	50(1.27)	
		825	4(0.10)	24(0.61)	40(1.02) 60(1.52)	
		826	4(0.10)	40(1.02)	40(1.02) 60(1.52)	
		827	4(0.10)	40(1.02)	20(0.51) 60(1.52)	
		828	5(0.13)	40(1.02)	50(1.27)	

UNLESS OTHERWISE SPECIFIED MAXIMUM FINISH THICKNESS ALLOWED ABOVE MINIMUMS:

Continuous and batch plating:

Nickel	Continuous plating	50µ" (1.27µm)
	Batch plating	50µ" (1.27µm)
Gold	Continuous plating	10µ" (0.25µm)
	Batch plating	20µ" (0.51µm)
Palladium Nickel Alloy	Continuous plating	20µ" (0.51µm)
	Batch plating	50µ" (1.27µm)