

TASK 20-00-10-300-807-A01

11. Electrolytic Chromium Plating (Steel Strength $R_m > 1450 \text{ N/mm}^2$ ($> 210300 \text{ lbf/in.}^2$))

A. Reason for the Job

Self explanatory

B. Job Set-up Information

(1) Consumables

Name and Material Number	Group	Specification	Vendor Code and Address
Perchloroethylene	Chemical Agent	C_2Cl_4	Local purchase
Chromic Acid	Chemical Agent	CrO_3	Local Purchase
Chromic Oxide	Chemical Agent	CrO	Local Purchase
Sulphuric Acid	Chemical Agent	H_2SO_4 (96 %), reagent grade	Local Purchase
Sodium Carbonate	Chemical Agent	Na_2CO_3	Local Purchase
Sodium Hydroxide	Chemical Agent	NaOH	Local purchase
Sodium Hydrogen Sulphite	Chemical Agent	NaHSO_3	Local purchase

C. Job Set-up

SUBTASK 20-00-10-300-009-A01

(1) General

- (a) Make sure that all special tools, fixtures and equipment are serviceable and where necessary, correctly calibrated before you use them.
- (b) Make sure that all the solutions used have been monitored at the correct interval, refer to the subtask Bath Control, subtask-20-00-10-210-034-a01.

D. Procedure

SUBTASK 20-00-10-350-013-A01

(1) Repair of Chromium Plating

- (a) As given in task Electrolytic Chromium Plating (Steel Strength $R_m \leq 1450 \text{ N/mm}^2$ ($\leq 210300 \text{ lbf/in.}^2$)), task-20-00-10-300-806-a01 other than that, Parts must be de-embrittled for a minimum of 23 h.

NOTE: Disregard instructions in Chromium Plate Removal, subtask-20-00-10-350-012-A01 which refers to steel not included in this section.

- (b) Do a test of the specimens (refer to Subtask Test of the Specimens, subtask-20-00-10-210-048-a01).
- (c) Do a check of the solution baths (refer to Subtask Bath Control, subtask-20-00-10-210-034-a01).