

CONTENTS

CHAPTER 1 INTRODUCTION	1
1.1 INTRODUCTION	1
CHAPTER 2 WEAR AND FRICTION PROPERTIES OF SURFACES	7
2.1 INTRODUCTION	7
2.2 ABRASIVE WEAR	9
2.2.1 LOW-STRESS SCRATCHING ABRASION	10
2.2.2 HIGH-STRESS GRINDING ABRASION	11
2.2.3 GOUGING ABRASION	12
2.3 ADHESIVE WEAR	12
2.4 CASE STUDY: SOLID LUBRICANTS AND TRIBOLOGICAL CHARACTERISATION HEREOF	16
2.4.1 BLOCK-ON-RING TEST FOR SOLID LUBRICANTS	17
2.4.2 FALEX PIN AND VEE BLOCK TEST FOR SOLID LUBRICANTS	19
2.5 FATIGUE WEAR	21
2.6 CORROSIVE WEAR	22
2.6.1 CASE STUDY: FRETTING	23
2.7 EROSIVE WEAR	27
2.8 REFERENCES	33
2.9 RECOMMENDED ADDITIONAL READING	33
2.10 RELEVANT STANDARDS	33
CHAPTER 3 INTRODUCTION TO CORROSION	37
3.1 INTRODUCTION	37
3.2 THE POURBAIX DIAGRAM	48
3.3 STRATEGIES FOR CORROSION PROTECTION	52
3.3.1 CONVERSION COATINGS AS CORROSION PROTECTION	52
3.3.2 ADDITIONAL CORROSION PROTECTION STRATEGIES	55
3.4 TYPICAL APPEARANCE OF SURFACE CORROSION	56
3.4.1 UNIFORM CORROSION	57
3.4.2 GALVANIC CORROSION	61
3.4.3 CREVICE OR DEPOSIT CORROSION	63
3.4.4 FRETTING CORROSION	68
3.5 RECOMMENDED ADDITIONAL READING	69

CHAPTER 4	BASIC ELECTROCHEMISTRY FOR SURFACE MODIFICATIONS	71
4.1	INTRODUCTION	71
4.2	BASIC ELECTROLYTIC PROCESSES	72
4.2.1	HYDRATION OF THE METAL ION	72
4.2.2	DISSOCIATION OF THE SOLUTION	73
4.2.3	INTERACTION BETWEEN DIFFERENT IONS	73
4.3	THE LAW OF FARADAY	79
4.4	THE ELECTROCHEMICAL DOUBLE LAYER	80
4.5	ACTIVATION OVERPOTENTIAL	83
4.6	CONCENTRATION OVERPOTENTIAL	90
4.7	CRYSTALLIZATION OVERPOTENTIAL	94
4.8	THE OHMIC RESISTANCE OF AN ELECTROLYTE	97
4.9	OTHER RELEVANT FACTORS	97
4.10	ADDITIVES FOR ELECTROPLATING	98
4.11	REFERENCES	102
4.12	RECOMMENDED ADDITIONAL READING	102
CHAPTER 5	INTRO. TO CHEMICAL AND ELECTROCHEMICAL PROCESSES	105
5.1	INTRODUCTION	105
5.1.1	CHEMICAL/ELECTROCHEMICAL PLATING	105
5.1.2	CONVERSION COATINGS	106
5.1.3	CHEMICAL/ELECTROCHEMICAL POLISHING	106
5.2	ELECTROCHEMICAL PLATING OF METALS	107
5.2.1	ELECTROLYTIC PLATING	107
5.2.2	ELECTROLESS PLATING	115
5.3	ELECTROPLATABLE SUBSTRATES	118
5.4	PRETREATMENT PROCESSES	120
5.4.1	REMOVING OIL, GREASE AND DIRT	120
5.4.2	IMPORTANT FACTORS IN THE CLEANING PROCESS	124
5.4.3	REMOVAL OF OXIDES	126
5.4.4	ELECTROCLEANING	131
5.4.5	ACTIVATION	133
5.4.6	PRETREATMENT OF AL, CU, CU-ALLOYS AND STRONG OXYGEN GETTERS	134
5.5	PLATING OF NON-CONDUCTIVE MATERIALS	140
5.5.1	MOLDED INTERCONNECT DEVICES	144
5.6	REFERENCES	147

CHAPTER 6	GUIDELINES FOR ELECTRO-CHEMICAL DEPOSITION	149
6.1	INTRODUCTION	149
6.2	MATERIAL DISTRIBUTION AND GEOMETRY	149
6.2.1	TYPES OF OVERPOTENTIAL (POLARIZATION TYPES)	149
6.2.2	OPTIMIZING MATERIAL DISTRIBUTION	151
6.2.3	CURRENT EFFICIENCY	152
6.2.4	ELECTROPLATING IN PRACTICE	156
6.3	CONTINUOUS PLATING	162
6.3.1	COIL COATING	162
6.3.2	REEL-TO-REEL PLATING	163
6.4	BRUSH PLATING	167
6.5	ENVIRONMENTAL REQUIREMENTS	169
CHAPTER 7	ELECTROLYTIC PLATING OF ZINC	173
7.1	INTRODUCTION	173
7.2	CORROSION OF ZINC	175
7.3	PROCESSES FOR ELECTROPLATING PURE ZINC	177
7.3.1	CYANIDE-BASED ELECTROLYTES	177
7.3.2	THE ALKALINE, CYANIDE-FREE ZINC ELECTROLYTE	182
7.3.3	ACID ZINC ELECTROLYTES	186
7.3.4	COMPARING THE DIFFERENT ZINC ELECTROLYTES	188
7.4	ALLOY ZINC PLATING	191
7.5	POST-TREATMENT OF ZINC	193
7.5.1	CLEAR AND BLUE CHROMATES (A AND B)	194
7.5.2	YELLOW CHROMATES (C)	194
7.5.3	OLIVE DRAB (D)	194
7.5.4	BLACK CHROMATES (E)	194
7.5.5	CHROMATE-FREE CONVERSION COATINGS	199
7.6	REFERENCES	202
7.7	RECOMMENDED ADDITIONAL READING	202
7.8	RELEVANT STANDARDS	202
CHAPTER 8	ELECTROLYTIC PLATING OF NICKEL	205
8.1	INTRODUCTION	205
8.1.1	THE DEVELOPMENT OF NICKEL PLATING	205
8.2	THE WATTS BATH	208
8.2.1	TECHNICAL ELECTROLYTES	209
8.2.2	SEMI-BRIGHT ELECTROLYTES	209
8.2.3	BRIGHT NICKEL ELECTROLYTES	212

8.3	SATIN NICKEL COATINGS	216
8.4	MECHANICAL PROPERTIES OF NICKEL COATINGS	219
8.4.1	ELECTROFORMING	220
8.5	REFERENCES	223
8.6	RECOMMENDED ADDITIONAL READING	224
8.7	RELEVANT STANDARDS	224
 CHAPTER 9 ELECTROLYTIC PLATING OF COPPER		227
9.1	INTRODUCTION	227
9.2	THE PLATING PROCESS	227
9.3	COPPER PLATING APPLICATIONS	230
9.3.1	COPPER COATINGS ON Zn, Al AND Mg	231
9.3.2	COPPER PLATING FOR CONDUCTIVITY PURPOSES	231
9.3.3	COPPER PLATING FOR PRINTING ROLLS	232
9.3.4	ELECTROFORMING	235
9.3.5	COPPER PLATING AS PART OF PLATING ON POLYMERS	237
9.4	REFERENCES	240
9.5	RELEVANT STANDARDS	240
 CHAPTER 10 ELECTROLYTIC PLATING OF TIN		243
10.1	INTRODUCTION	243
10.2	THE PLATING PROCESS	243
10.3	PROPERTIES OF TIN COATINGS	244
10.3.1	CORROSION PROPERTIES OF TIN	244
10.4	TIN WHISKERS	246
10.5	TIN SOLDERING	248
10.6	REFERENCES	252
10.7	RECOMMENDED ADDITIONAL READING	252
10.8	RELEVANT STANDARDS	253
 CHAPTER 11 ELECTROLYTIC PLATING OF CHROMIUM		255
11.1	INTRODUCTION	255
11.2	THE CHROMIUM PLATING PROCESS	257
11.3	BRIGHT AND HARD CHROMIUM PLATING	258
11.3.1	CURRENT EFFICIENCY	260

11.3.2	CHARACTERISTIC COATING CRACKS	262
11.3.3	PROPERTIES OF HARD CHROMIUM	263
11.3.4	ALTERNATIVES TO HEXAVALENT CHROMIUM	268
11.4	REFERENCES	270
11.5	RECOMMENDED ADDITIONAL READING	270
CHAPTER 12 ELECTROLYTIC PLATING OF PRECIOUS METALS		273
12.1	INTRODUCTION	273
12.2	SILVER	274
12.2.1	THE SILVER PLATING PROCESS	277
12.2.2	PROPERTIES OF SILVER	279
12.2.3	SILVER MIGRATION	280
12.3	GOLD	282
12.3.1	THE GOLD PLATING PROCESS	282
12.4	OTHER PRECIOUS METALS	292
12.4.1	PALLADIUM	292
12.4.2	RHODIUM	293
12.4.3	PLATINUM	294
12.4.4	RUTHENIUM	296
12.4.5	OSMIUM	296
12.4.6	IRIDIUM	296
12.4.7	RHENIUM	296
12.5	REFERENCES	297
12.6	RECOMMENDED ADDITIONAL READING	297
12.7	RELEVANT STANDARDS	297
CHAPTER 13 ELECTROLYTIC PLATING OF ALLOYS		299
13.1	INTRODUCTION	299
13.2	BASIC THEORY BEHIND ALLOY PLATING	300
13.3	GROUPING BINARY ALLOYS	306
13.4	COMMERCIALY APPLIED ALLOYS	308
13.4.1	LEAD/TIN ALLOY PLATING	308
13.4.2	NICKEL/PHOSPHORUS ALLOY PLATING	308
13.4.3	NICKEL/TUNGSTEN ALLOY PLATING	309
13.4.4	TIN/ZINC ALLOY PLATING	310
13.4.5	COPPER/TIN ALLOY PLATING	310
13.4.6	NICKEL/TIN ALLOY PLATING	311
13.4.7	COPPER/ZINC ALLOY PLATING	313
13.4.8	NICKEL/IRON ALLOY PLATING	314

13.4.9	ZINC/NICKEL ALLOY PLATING	314
13.4.10	COBALT/ZINC ALLOY PLATING	314
13.5	REFERENCES	314
13.6	RELEVANT STANDARDS	316
CHAPTER 14 ELECTROLESS PLATING OF METALS		319
14.1	INTRODUCTION	319
14.2	AUTOCATALYTIC (ELECTROLESS) COPPER PLATING	322
14.3	AUTOCATALYTIC (ELECTROLESS) NICKEL PLATING	324
14.3.1	PROCESSES INVOLVING HYPOPHOSPHITE	324
14.3.2	PROCESSES INVOLVING BORON AND HYDRAZINE	328
14.3.3	CONDUCTING THE AUTOCATALYTIC NICKEL PROCESS	328
14.3.4	HARDENING OF AUTOCATALYTIC NICKEL COATINGS	330
14.3.5	SELECTION OF AUTOCATALYTIC NICKEL	331
14.3.6	STRESS IN AUTOCATALYTIC NICKEL COATINGS	333
14.3.7	ELECTRIC AND MAGNETIC PROPERTIES	335
14.3.8	WELDING AND SOLDERING	338
14.4	DISPERSION PLATING	340
14.5	OTHER ELECTROLESS PLATING PROCESSES	345
14.5.1	ELECTROLESS PLATING OF GOLD	345
14.5.2	ELECTROLESS PLATING OF SILVER	347
14.5.3	AUTOCATALYTIC (ELECTROLESS) PLATING OF PALLADIUM	349
14.5.4	ION EXCHANGE PLATING OF TIN	350
14.5.5	ION EXCHANGE (ELECTROLESS) PLATING OF BRONZE	352
14.6	REFERENCES	353
14.7	RELEVANT STANDARDS	353
CHAPTER 15 CHEMICAL AND ELECTROCHEMICAL POLISHING		355
15.1	INTRODUCTION	355
15.2	METALS SUITABLE FOR POLISHING	356
15.3	THE MECHANISM OF ELECTROPOLISHING	357
15.3.1	CURRENT/POLARIZATION CONDITIONS DURING POLISHING	358
15.3.2	OXYGEN DEVELOPMENT DURING ELECTROPOLISHING	360
15.3.3	ELECTROPOLISHING STAINLESS STEEL	361
15.3.4	ELECTROPOLISHING OF WELDINGS	363
15.3.5	ADDITIONAL APPLICATIONS FOR ELECTROPOLISHING	364
15.4	CHEMICAL POLISHING	366
15.5	REFERENCES	368

CHAPTER 16 CONVERSION COATINGS	371
16.1 INTRODUCTION	371
16.2 ANODIZING OF ALUMINUM	372
16.2.1 AREAS OF APPLICATION	379
16.2.2 THE BASE MATERIAL	380
16.2.3 THE ANODIZING PROCESS	386
16.2.4 COLORING OF ANODIZED ALUMINUM	389
16.3 SPECIAL PROCESSES	395
16.3.1 HARD ANODIZING	395
16.3.2 CHROME ACID ANODIZING	399
16.3.3 PLASMA ELECTROLYTIC OXIDATION	400
16.4 INTERFERENCE COLORS FROM OXIDE GROWTH	405
16.4.1 INTERFERENCE COLORS ON TITANIUM	405
16.4.2 INTERFERENCE COLORS ON STAINLESS STEEL	408
16.4.3 FUNDAMENTAL MECHANISM OF THIN-FILM INTERFERENCE	412
16.5 CHEMICAL CONVERSION COATINGS	414
16.5.1 CHROMATING OF ALUMINUM	415
16.5.2 PHOSPHATING OF STEEL	426
16.6 REFERENCES	433
16.7 RECOMMENDED ADDITIONAL READING	434
16.8 RELEVANT STANDARDS	434
CHAPTER 17 INTRODUCTION TO GAS-PHASE AND PLASMA PROCESSES	437
17.1 INTRODUCTION	437
17.2 PLASMA PROCESSES	442
17.2.1 PARTICLE ENERGIES AND TEMPERATURES	444
17.2.2 THE MEAN FREE PATH BETWEEN COLLISIONS	445
17.2.3 INTERACTION BETWEEN ELECTRON AND MOLECULES	445
17.2.4 THE SHIELDING EFFECT OF A PLASMA	448
17.2.5 INTERACTIONS BETWEEN A PLASMA AND THE SURROUNDINGS	449
17.3 DC-PLASMA	450
17.3.1 A SIMPLE EXAMPLE	450
17.3.2 A CLOSER LOOK AT THE DC-PLASMA	452
17.3.3 POWER SUPPLIES FOR DC-PLASMA	454
17.4 OTHER TYPES OF DIODE PLASMAS	455
17.5 OTHER PROCESSES	455
17.6 PLASMA CHARACTERIZATION	456
17.6.1 LANGMUIR-PROBE	456
17.6.2 OPTICAL EMISSION SPECTROSCOPY	456
17.7 REFERENCES	458

CHAPTER 18	PHYSICAL VAPOR DEPOSITION	461
18.1	INTRODUCTION	461
18.2	NON-REACTIVE PVD PROCESSES	462
18.2.1	EVAPORATION	462
18.2.2	SPUTTERING	469
18.2.3	DIFFERENT COMBINATION POSSIBILITIES FOR NON-REACTIVE PVD PROCESSES	474
18.3	REACTIVE PVD PROCESSES	475
18.3.1	DIFFERENT COMBINATION POSSIBILITIES FOR REACTIVE PVD PROCESSES	475
18.3.2	REACTIVE EVAPORATION	475
18.3.3	REACTIVE SPUTTERING PROCESSES	478
18.4	STRUCTURAL MODELS FOR VACUUM-BASED COATINGS	481
18.5	THE QUALITY OF THE DEPOSITED COATING	483
18.6	REFERENCES	484
CHAPTER 19	CHEMICAL VAPOR DEPOSITION	487
19.1	INTRODUCTION	487
19.2	THERMAL CVD	488
19.2.1	QUALITATIVE DESCRIPTION OF A CVD PROCESS	488
19.2.2	KINETICS	493
19.2.3	THE STRUCTURE OF A CVD COATING	497
19.2.4	INTRODUCTION TO VARIOUS CVD REACTIONS	498
19.2.5	COMMON CVD REACTIONS	499
19.2.6	ELEMENTARY SUBREACTIONS—AN ILLUSTRATIVE EXAMPLE	500
19.2.7	CVD EQUIPMENT	501
19.2.8	PUMPS SUITABLE FOR CVD	503
19.2.9	PRESSURE GAUGES SUITABLE FOR CVD	504
19.3	PLASMA-ACTIVATED CVD	504
19.3.1	THE BASIC PRINCIPLE OF PACVD	505
19.3.2	AREAS OF APPLICATION FOR THE PACVD PROCESS	507
19.4	REFERENCES	507
19.5	RECOMMENDED ADDITIONAL READING	507
CHAPTER 20	INDUSTRIAL PVD AND CVD PROCESSES	509
20.1	INTRODUCTION	509
20.2	COATINGS ON METALS AND HARD METALS	509
20.3	CONSIDERATIONS PRIOR TO COATING	511
20.4	COMMERCIAL PVD AND CVD COATINGS	513
20.5	COMMERCIAL COATINGS BASED ON PVD AND CVD	518

20.5.1	GAS NITRIDING	519
20.5.2	OVERVIEW OF SOME PVD/CVD COATINGS	519
20.5.3	DIAMOND AND DIAMOND-LIKE CARBON COATINGS	528
20.5.4	MULTIPHASE SYSTEMS	534
20.6	CVD OF PARYLENE	535
20.7	ATOMIC LAYER DEPOSITION	537
20.8	PVD COATINGS FOR DECORATIVE APPLICATIONS	538
20.9	REFERENCES	541
20.10	RECOMMENDED ADDITIONAL READING	541
20.11	RELEVANT STANDARDS	541
CHAPTER 21	ION BEAM PROCESSES	543
21.1	INTRODUCTION	543
21.2	THE KAUFMAN ION SOURCE	545
21.3	SPUTTER CLEANING (ION ETCHING)	546
21.4	DEPOSITION	547
21.4.1	SPUTTER DEPOSITION WITH ION BEAMS	547
21.4.2	ION DEPOSITION	548
21.4.3	ION BEAM ASSISTED DEPOSITION	549
21.5	ION IMPLANTATION	550
21.5.1	THE EFFECT OF IMPLANTATION	553
21.5.2	EQUIPMENT FOR ION BEAM IMPLANTATION	554
21.5.3	ADVANTAGES AND LIMITATIONS	558
21.5.4	TYPICAL APPLICATIONS	558
21.6	REFERENCES	560
INDEX		563
THE AUTHORS		577