

Internal Specification Level I

Title: Immersion Gold – Electroless Nickel Specification
Revision: 04 **Revision Date: 9/29/2014**
Contact Name: Todd Jarman

Number: IS-009
Requirements: NA

PURPOSE & SCOPE

This Internal Specification will standardize the amount/tolerance of micro-inches of gold on immersion gold product.

This document shall take precedence over all existing L-3 Communications, Communication Systems-West (CSW) drawings, policies or procedures. This specification is effective March 1, 2004 and shall be subject to Inspection acceptance on affected product after said date.

POLICY STATEMENT

CS-W Internal Specification IS-009 shall be referenced on all Printed Circuit Board (PCB) drawings used for the procurement of printed circuit boards/printed wiring boards (PCB/PWB).

This Internal Specification standardizes the requirements for Electroless Nickel/Immersion Gold plating as follows:

Electroless Nickel / Immersion Gold Thickness: In accordance with IPC-4552

Immersion Gold: Maximum thickness shall not exceed 5 micro-inches

Adhesion: In accordance to the guidelines established in IPC-4552.

Released PCB/PWB drawings and parts lists will not be revised. This internal specification will be provided to all approved PCB suppliers. Drawings released after 1 March, 2004 will reference Internal Specification IS-009.

Note: *Indicates addition, deletion, or revision. Changes are shown in a different color on screen.

END OF DOCUMENT

Internal Specification Level I

DOCUMENT INFORMATION

Responsible Organization: Operations (OPS)

Sub-Level Function: Manufacturing (MFG)

Governing Document: [Y-001](#), Quality Management System
IPC-4552

Subordinate Documents: NA

Related Documents: [IS-005](#), Printed Wiring Board Workmanship & Design Criteria

Approval Requirements: Technical Expert
Manager of Electronic Circuits
[PCCB Chairman](#)
[Director, Quality Hardware](#)

Review Requirements: DCMA Representative

Revision History Summary:

Revision #	Reason for Update/Revision	Date
New – 01	Initial release through revision 01	05-02-2006
02	24 month review. Put into new format. No process changes made.	03-13-2009
03	24 month review. No changes made.	7/26/2011
04	24 month review. Modified approval requirements. No other changes made.	9/29/2014