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[Continued on next page]

(54) Title: A PLATING PROCESS TO INCREASE COIN BLANK SURFACE HARDNESS

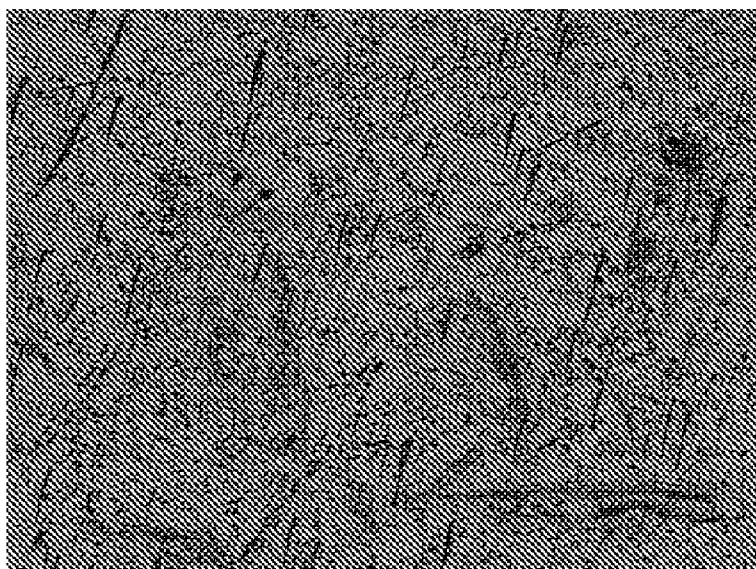


FIG. 7C

(57) Abstract: A method is described for plating metal or alloy blanks. The method includes heating the metal or alloy blanks at a recrystallization temperature sufficient to soften the steel for minting; plating the softened metal or alloy blanks with one or more layers of metal or alloy; and heating the plated blanks at a temperature sufficient to reduce plating stresses but below the recrystallization temperature of the outermost plating layer.



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