

ELECTROLYTIC ZINC COATING

ELECTROLYTIC ZINC COATINGS (EXTRACT FROM ISO 4042)

The following tables are in accordance with the contents of ISO 4042

DESIGNATION CODES FOR COATINGS	OTHER POSSIBLE DESIGNATION	NOMINAL COAT. THICKNESS μm	CHROMATE	SALT SPRAY RESISTANCE	
				WHITE CORROSION h	RED RUST h
A2A	Fe/Zn 5c1A	5	A	6	24
A2B	Fe/Zn 5c1B		B	12	36
A2C	Fe/Zn 5c2C		C	48	72
A2D	Fe/Zn 5c2D		D	72	96
A2R	Fe/Zn 5Bk		Bk	12	-
A3A	Fe/Zn 8c1A	8	A	6	48
A3B	Fe/Zn 8c1B		B	24	72
A3C	Fe/Zn 8c2C		C	72	120
A3D	Fe/Zn 8c2D		D	96	144
A3R	Fe/Zn 8Bk		Bk	24	72
A4A	Fe/Zn 12c1A	12	A	6	72
A4B	Fe/Zn 12c1B		B	24	96
A4C	Fe/Zn 12c2C		C	72	144
A4D	Fe/Zn 12c2D		D	96	168
A4R	Fe/Zn 12Bk		Bk	24	96

DESIGNATION OF CORMATE TREATMENT			
CLASS	DESIGNATION	TYPE	TYPICAL APPEARANCE
1	A	CLEAR	TRASPARENT ,CLEAR, SOMETIMES WITH A BLUISH TINGE
	B	BLEACHED	TRASPARENT WITH SLIGHT IRIDESCENCE
2	C	IRIDESCENT	YELLOW IRIDESCENT
	D	OPAQUE	OLIVE GREEN SHADING TO BROWN OR BRONZE
	Bk	BLACK	BLACK WHIT SLIGHT IRIDESCENCE

DESIGNATION CODE

The following code system is given for electroplated coatings:

A	2	C
X	Y	Z

X = Coating metal **Y**=Minimum coating thickness **Z** = Finish and chromate treatment

COATING METAL /ALLOY		
SYMBOL	ELEMENTS	DESIGNATION X
Zn	ZINC	A
Cu	COPPER	C
Ni	NICKEL	E
CuNi	COPPER-NICKEL	G
ZnNi	ZINC-NICKEL	P
ZnCo	ZINC –COBALT	Q
ZnFe	ZINC-IRON	R
COATING THICKNESS/DESIGNATION		
ONE COATING METALS $\mu\text{m min.}$	TWO COATING METALS $\mu\text{m min}$	DESIGNATION Y
NO COATING THICKNESS REQUIRED	-	0
5	2+3	2
8	3+5	3
12	4+8	4
FINISH AND CHROMATE TREATMENT		
TYPICAL APPEARANCE		DESIGNATION Z
TRASPARENT, CLEAR		A
TRASPARENT WITH SLIGHT IRIDESCENCE (BLEACHED)		B
YELLOW IRIDESCENT		C
OLIVE GREEN BROWN		D
BLACK		R

ELECTROLYTIC ZINC COATING

ELECTROLYTIC ZINC COATINGS (EXTRACT FROM FIAT 9.57405)

(The following table is in accordance with the contents of Fiat 9.57405)

DESIGNATION	MINIMUM COAT THICKNESS μm	TYPICAL APPEARANCE	WHITE CORROSION h	RED RUST h
Fe/Zn 5 I	5	TRASPARENT	-	36
Fe/Zn 7 I	7			48
Fe/Zn 12 I	12			72
Fe/Zn 25 I	25			96
Fe/Zn 5 II	5	BRIGHT	24	72
Fe/Zn 7 II	7			96
Fe/Zn 12 II	12			192
Fe/Zn 25 II	25			384
Fe/Zn 5 IV	5	IRIDESCENT	96	120
Fe/Zn 7 IV	7			168
Fe/Zn 12 IV	12			240
Fe/Zn 25 IV	25			600
Fe/Zn 7 IV LUB	7	IRIDESCENT + LUBRICANT	96	168
Fe/Zn 7 IV S	7	IRIDESCENT + SEALING	120	360
Fe/Zn 12 IV S	12			480
Fe/Zn 7 VII S	7	BLACK IRIDESCENT + SEALING	24	72
Fe/Zn 7 VII ST	7	BLACK IRIDESCENT + SEALING (STATIC)	120	240
Fe/Zn 12 VII ST	12			480