

มาตรฐานผลิตภัณฑ์อุตสาหกรรม

THAI INDUSTRIAL STANDARD

มอก. 2408 – 2551

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**ตัวยึด – การเคลือบผิวด้วยเกล็ดสังกะสี
โดยไม่ใช้กรรมวิธีทางไฟฟ้า**

FASTENERS – NON-ELECTROLYTICALLY APPLIED ZINC FLAKE
COATINGS

สำนักงานมาตรฐานผลิตภัณฑ์อุตสาหกรรม

กระทรวงอุตสาหกรรม

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มาตรฐานผลิตภัณฑ์อุตสาหกรรมกำหนดขึ้นโดยรับ ISO 10683:2000 Fasteners – Non-electrolytically applied zinc flake coatings มาใช้ในระดับเหมือนกันทุกประการ (identical) โดยใช้ ISO ฉบับภาษาอังกฤษเป็นหลัก

คณะกรรมการมาตรฐานผลิตภัณฑ์อุตสาหกรรมได้พิจารณามาตรฐานนี้แล้ว เห็นสมควรเสนอรัฐมนตรีประกาศตาม
มาตรา 15 แห่งพระราชบัญญัติมาตรฐานผลิตภัณฑ์อุตสาหกรรม พ.ศ. 2511



ประกาศกระทรวงอุตสาหกรรม

ฉบับที่ 3931 (พ.ศ. 2551)

ออกตามความในพระราชบัญญัติมาตรฐานผลิตภัณฑ์อุตสาหกรรม

พ.ศ. 2511

เรื่อง กำหนดมาตรฐานผลิตภัณฑ์อุตสาหกรรม

ตัวยึด – การเคลือบผิวด้วยเกล็ดสังกะสีโดยไม่ใช้กรรมวิธีทางไฟฟ้า

อาศัยอำนาจตามความในมาตรา 15 แห่งพระราชบัญญัติมาตรฐานผลิตภัณฑ์อุตสาหกรรม พ.ศ. 2511 รัฐมนตรีว่าการกระทรวงอุตสาหกรรมออกประกาศกำหนดมาตรฐานผลิตภัณฑ์อุตสาหกรรม ตัวยึด – การเคลือบผิวด้วยเกล็ดสังกะสีโดยไม่ใช้กรรมวิธีทางไฟฟ้า มาตรฐานเลขที่ มอก. 2408-2551 ไว้ ดังมีรายละเอียดต่อท้ายประกาศนี้

ประกาศ ณ วันที่ 24 พฤศจิกายน พ.ศ. 2551

พลตำรวจเอก ประชา พรหมนอก

รัฐมนตรีว่าการกระทรวงอุตสาหกรรม

มาตรฐานผลิตภัณฑ์อุตสาหกรรม ตัวยึด – การเคลือบผิวด้วยเกล็ดสังกะสี โดยไม่ใช้กรรมวิธีทางไฟฟ้า

บทนำ

มาตรฐานผลิตภัณฑ์อุตสาหกรรมนี้กำหนดขึ้นโดยรับ ISO 10683:2000 Fasteners – Non-electrolytically applied zinc flake coatings มาใช้ในระดับเหมือนกันทุกประการ (identical) โดยใช้ ISO ฉบับภาษาอังกฤษเป็นหลัก

ขอบข่าย

มาตรฐานผลิตภัณฑ์อุตสาหกรรมนี้กำหนดคุณลักษณะที่ต้องการสำหรับความหนา ความต้านทานการผุกร่อน คุณสมบัติทางกลและคุณสมบัติทางกายภาพสำหรับผิวเคลือบเกล็ดสังกะสีโดยไม่ใช้กรรมวิธีทางไฟฟ้าบนตัวยึดเหล็กกล้าแบบเกลียวเมตริก มาตรฐานใช้กับการเคลือบทั้งมีและไม่มีโครเมต การเคลือบตามมาตรฐานนี้อาจใช้กับหมุดเกลียวเหล็กกล้าซึ่งทำร่องเกลียวด้วยตัวเองเช่น หมุดเกลียวสำหรับงานไม้ หมุดเกลียวปล่อย หมุดเกลียวเจาะ หมุดเกลียวแบบกัดเกลียวด้วยตัวเอง และ หมุดเกลียวแบบรีดเกลียวด้วยตัวเองรวมถึงชิ้นส่วนเหล็กกล้าซึ่งไม่มีเกลียว เช่นแหวนและหมุด

อาจใช้กับตัวยึดเหล็กกล้าซึ่งมีเกลียวแบบอื่น

การเคลือบตามมาตรฐานนี้สามารถใช้กับอุปกรณ์หล่อลื่น และ/หรือเติมสารหล่อลื่นภายหลัง

เอกสารอ้างอิง

เอกสารอ้างอิงที่ระบุต่อไปนี้ใช้ประกอบกับมาตรฐานผลิตภัณฑ์อุตสาหกรรมนี้ เอกสารอ้างอิงฉบับที่ระบุปีที่พิมพ์ให้ใช้ฉบับที่ระบุ ส่วนเอกสารที่ไม่ระบุปีที่พิมพ์นั้นให้ใช้ฉบับล่าสุด (รวมถึงฉบับแก้ไขเพิ่มเติม)

ISO 898-1:1999, *Mechanical properties of fasteners made of carbon steel and alloy steel – Part 1: Bolts, screws and studs.*

ISO 965-1:1998, *ISO general purpose metric screw threads – Tolerances – Part 1: Principles and basic data.*

ISO 965-2:1998, *ISO general purpose metric screw threads – Tolerances – Part 2: Limits of sizes for general purpose external and internal screw threads – Medium quality.*

ISO 965-3:1998, *ISO general purpose metric screw threads – Tolerances – Part 3: Deviations for constructional screw threads.*

มอก. 2408-2551
ISO 10683:2000

ISO 1463—¹⁾, *Metallic and oxide coatings — Measurement of coating thickness — Microscopical method.* ISO 3269:2000, *Fasteners — Acceptance inspection.*

มอก. 2420-2551 มาตรฐานผลิตภัณฑ์อุตสาหกรรมระบบการระบุข้อมูลสำหรับตัวยึด

ISO 9227:1990, *Corrosion tests in artificial atmospheres — Salt spray tests.*

ISO 15330:1999, *Fasteners — Preloading test for the detection of hydrogen embrittlement — Parallel bearing surface method.*

คำศัพท์และบทนิยาม

มาตรฐานผลิตภัณฑ์อุตสาหกรรมนี้กำหนด คำศัพท์และบทนิยาม รายละเอียดตาม ISO 10683:2000 ข้อ 3

ลักษณะทั่วไป

มาตรฐานผลิตภัณฑ์อุตสาหกรรมนี้กำหนด ลักษณะทั่วไป รายละเอียดตาม ISO 10683:2000 ข้อ 4

มิติที่ต้องการและการทดสอบ

มาตรฐานผลิตภัณฑ์อุตสาหกรรมนี้กำหนด มิติที่ต้องการและการทดสอบ รายละเอียดตาม ISO 10683:2000 ข้อ 5

การทดสอบการป้องกันการผุกร่อน

มาตรฐานผลิตภัณฑ์อุตสาหกรรมนี้กำหนด การทดสอบการป้องกันการผุกร่อน รายละเอียดตาม ISO 10683:2000 ข้อ 6

คุณสมบัติทางกลและคุณสมบัติทางกายภาพและการทดสอบ

มาตรฐานผลิตภัณฑ์อุตสาหกรรมนี้กำหนด คุณสมบัติทางกลและคุณสมบัติทางกายภาพและการทดสอบ รายละเอียดตาม ISO 10683:2000 ข้อ 7

การนำการทดสอบมาใช้

มาตรฐานผลิตภัณฑ์อุตสาหกรรมนี้กำหนด การนำการทดสอบมาใช้ รายละเอียดตาม ISO 10683:2000 ข้อ 8

1) ระหว่างพิมพ์ (Revision of ISO 1463:1982)

การระบุ

มาตรฐานผลิตภัณฑ์อุตสาหกรรมนี้กำหนด การระบุ รายละเอียดตาม ISO 10683:2000 ข้อ 9

ข้อกำหนดความต้องการ

มาตรฐานผลิตภัณฑ์อุตสาหกรรมนี้กำหนด ข้อกำหนดความต้องการ รายละเอียดตาม ISO 10683:2000 ข้อ 10

ภาคผนวก ก.

(ข้อแนะนำ)

ตัวอย่างสำหรับการเลือกความหนาของผิวเคลือบสัมพัทธ์
กับความต้องการในการป้องกันการกัดกร่อน

มาตรฐานผลิตภัณฑ์อุตสาหกรรมนี้กำหนด ตัวอย่างสำหรับการเลือกความหนาของผิวเคลือบผิวสัมพัทธ์กับ
ความต้องการในการป้องกันการกัดกร่อน รายละเอียดตาม ISO 10683:2000 Annex A

Contents

Page

Foreword.....	iv
1 Scope	1
2 Normative references	1
3 Terms and definitions	2
4 General characteristics	2
5 Dimensional requirements and testing	2
6 Testing of corrosion protection	5
7 Mechanical and physical properties and testing	5
7.1 General.....	5
7.2 Appearance	5
7.3 Temperature resistance	5
7.4 Ductility.....	6
7.5 Adhesion/cohesion	6
7.6 Cathodic protection.....	6
7.7 Torque/tension relationship for coatings with integral lubricant or subsequently (externally) added lubricant.....	6
8 Applicability of tests.....	6
8.1 General.....	6
8.2 Tests mandatory for each lot.....	6
8.3 Tests to be conducted for in-process control.....	6
8.4 Tests which are only to be conducted when specified by the customer.....	6
9 Designation	7
10 Ordering requirements	7
Annex A (informative)	8

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 3.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this International Standard may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

International Standard ISO 10683 was prepared by Technical Committee ISO/TC 2, *Fasteners*, Subcommittee SC 1 *Mechanical properties of fasteners*.

Annex A of this International Standard is for information only.

Fasteners — Non-electrolytically applied zinc flake coatings

1 Scope

This International Standard specifies requirements for thickness, corrosion resistance and mechanical and physical properties of non-electrolytically applied zinc flake coatings on steel fasteners with metric threads.

It applies to both coatings with or without chromate.

Coatings according to this International Standard may also be applied to steel screws which form their own mating threads such as wood screws, self tapping screws, self drilling screws, thread cutting screws and thread rolling screws as well as to non-threaded steel parts such as washers and pins.

They may be similarly applied to steel fasteners with other types of thread.

Coatings according to this International Standard can be supplied with integral lubricant and/or with a subsequently added lubricant.

2 Normative references

The following normative documents contain provisions which, through reference in this text, constitute provisions of this International Standard. For dated references, subsequent amendments to, or revisions of, any of these publications do not apply. However, parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent editions of the normative documents indicated below. For undated references, the latest edition of the normative document referred to applies. Members of ISO and IEC maintain registers of currently valid International Standards.

ISO 898-1:1999, *Mechanical properties of fasteners made of carbon steel and alloy steel — Part 1: Bolts, screws and studs.*

ISO 965-1:1998, *ISO general purpose metric screw threads — Tolerances — Part 1: Principles and basic data.*

ISO 965-2:1998, *ISO general purpose metric screw threads — Tolerances — Part 2: Limits of sizes for general purpose external and internal screw threads — Medium quality.*

ISO 965-3:1998, *ISO general purpose metric screw threads — Tolerances — Part 3: Deviations for constructional screw threads.*

ISO 1463:—¹⁾, *Metallic and oxide coatings — Measurement of coating thickness — Microscopical method.*

ISO 1502:1996, *ISO general purpose metric screw threads — Gauges and gauging.*

ISO 2064:1996, *Metallic and other inorganic coatings — Definitions and conventions concerning the measurement of thickness.*

1) To be published. (Revision of ISO 1463:1982)

ISO 3269:2000, *Fasteners — Acceptance inspection.*

ISO 8991:1986, *Designation system for fasteners.*

ISO 9227:1990, *Corrosion tests in artificial atmospheres — Salt spray tests.*

ISO 15330:1999, *Fasteners — Preloading test for the detection of hydrogen embrittlement — Parallel bearing surface method.*

3 Terms and definitions

For the purpose of this International Standard, the definitions given in ISO 2064 together with the following apply.

3.1

non-electrolytically applied zinc flake coating (with or without integral lubricant)

coating which is produced by applying to the surface of a fastener a zinc flake dispersion, possibly with the addition of aluminium flakes, in a suitable medium which under influence of heat (curing) generates a bonding amongst flakes and also between flakes and substrate thus forming an inorganic surface coating sufficiently electrically conducting to ensure cathodic protection

NOTE The coating may or may not contain chromate.

4 General characteristics

It is a characteristic of this type of coating that no hydrogen which could be absorbed by the fasteners to be coated is generated during the coating process. Therefore, by using pretreatment cleaning methods which do not generate nascent hydrogen (for example blast cleaning), there is no risk of hydrogen embrittlement from the surface preparation procedure.

If cleaning methods are applied which could lead to hydrogen absorption (such as acid cleaning), then for fasteners with a hardness above 365 HV in-process control shall be conducted to ensure that the process with regard to hydrogen embrittlement is under control. This can be done by a preloading test according to ISO 15330.

However it should be noted that a non-electrolytically applied zinc flake coating has a high permeability for hydrogen which, during the curing process, allows effusion of hydrogen which may have been absorbed before the coating process.

5 Dimensional requirements and testing

Coating thicknesses which can be applied on ISO metric threads in accordance with ISO 965-1, ISO 965-2 and ISO 965-3 depend on the fundamental deviation available as given in Table 1, which itself depends on the screw thread and the following tolerance positions:

- g, f, e for external threads;
- G for internal threads or H if required.

The coating shall not cause the zero line (basic size) to be exceeded in the case of external threads; nor shall it fall below in the case of internal threads. This means that for an internal thread of tolerance position H, a measurable coating thickness can only be applied to the thread if the tolerance zone is not taken up to the zero line (basic size).

Table 1 — Theoretical upper limits of coating thicknesses for ISO metric threads

Pitch <i>P</i>	Nominal thread diameter for coarse-pitch thread ^a <i>d</i>	Internal thread		External thread					
		Tolerance position G		Tolerance position g		Tolerance position f		Tolerance position e	
		Funda-mental deviation	Coating thickness max.	Funda-mental deviation	Coating thickness max.	Funda-mental deviation	Coating thickness max.	Funda-mental deviation	Coating thickness max.
mm	mm	µm	µm	µm	µm	µm	µm	µm	µm
0,2		+ 17	4	– 17	4				
0,25	1; 1,2	+ 18	4	– 18	4				
0,3	1,4	+ 18	4	– 18	4				
0,35	1,5; 1,8	+ 19	4	– 19	4	– 34	8		
0,4	2	+ 19	4	– 19	4	– 34	8		
0,45	2,5; 2,2	+ 20	5	– 20	5	– 35	8		
0,5	3	+ 20	5	– 20	5	– 36	9	– 50	12
0,6	3,5	+ 21	5	– 21	5	– 36	9	– 53	13
0,7	4	+ 22	5	– 22	5	– 38	9	– 56	14
0,75	4,5	+ 22	5	– 22	5	– 38	9	– 56	14
0,8	5	+ 24	6	– 24	6	– 38	9	– 60	15
1	6; 7	+ 26	6	– 26	6	– 40	10	– 60	15
1,25	8	+ 28	7	– 28	7	– 42	10	– 63	15
1,5	10	+ 32	8	– 32	8	– 45	11	– 67	16
1,75	12	+ 34	8	– 34	8	– 48	12	– 71	17
2	16; 14;	+ 38	9	– 38	9	– 52	13	– 71	17
2,5	20; 18; 22	+ 42	10	– 42	10	– 58	14	– 80	20
3	24; 27;	+ 48	12	– 48	12	– 63	15	– 85	21
3,5	30; 33	+ 53	13	– 53	13	– 70	17	– 90	22
4	36; 39	+ 60	15	– 60	15	– 75	18	– 95	23
4,5	42; 45	+ 63	15	– 63	15	– 80	20	– 100	25
5	48; 52	+ 71	17	– 71	17	– 85	21	– 106	26
5,5	56; 60	+ 75	18	– 75	18	– 90	22	– 112	28
6	64	+ 80	20	– 80	20	– 95	23	– 118	29

NOTE Theoretical upper limits of coating thicknesses are calculated on the basis of thread dimensions which are at the lower limit (internal thread) or upper limit (external thread) of the respective thread tolerance.

^a Information for coarse-pitch threads is given for convenience only. The determining characteristic is the thread pitch.

After coating, ISO metric screw threads shall be gauged according to ISO 1502 with a GO-gauge of tolerance position h for external threads and H for internal threads. When gauging the coated thread a maximum torque of $0,001 d^3$ (N·m) is acceptable, where *d* is the nominal thread diameter in mm.

Other product dimensions apply only before coating.

If a minimum coating thickness (t_{\min}) is required in order to achieve a specified corrosion resistance (see clause 6) the range of the coating thickness has to be taken into consideration of which the dimension is approximately the same as the minimum coating thickness itself. Therefore the maximum coating thickness to be expected is twice as much as the required minimum coating thickness, see Table 2. The minimum fundamental deviation required for a specified minimum coating thickness which is $4 t_{\max}$ (or $8 t_{\min}$) is also given in Table 2.

If, for a given pitch the fundamental deviation as given in Table 1 is not sufficient to allow for the required minimum coating thickness then:

- either the tolerance position of the thread has to be changed (e.g. f instead of g);
- or the tolerance within the given tolerance field has to be restricted such that the thread has to be manufactured at the upper limit for the internal thread or at the lower limit for the external thread of the respective tolerance.

Required minimum local coating thicknesses to achieve specified corrosion resistance are given in Table 3.

NOTE Guidance for the choice of coating thickness relating to corrosion protection requirements is given in annex A.

If the minimum local coating thickness is specified (see Table 3) it may be measured by magnetic or X-ray techniques. In the case of dispute the referee test shall be the microscopical method as described in ISO 1463. The surfaces to be used for thickness measurements, measuring areas, are those given in Figure 1.

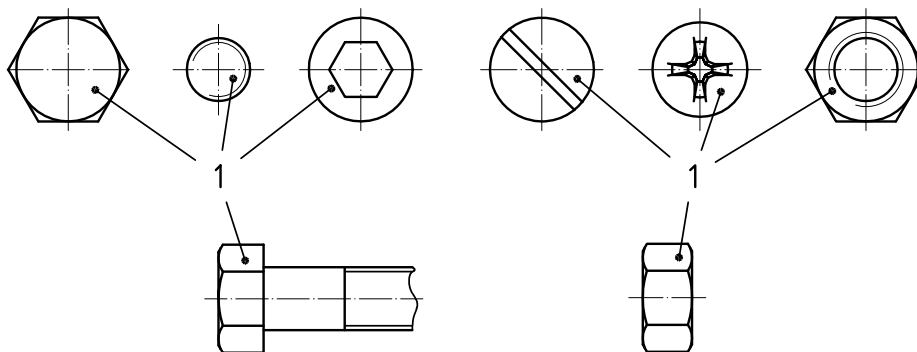
If fasteners with metric thread with pitch below 1 mm (< M6) or fasteners with small internal drives or cavities are to be coated, a special agreement between supplier and purchaser is required.

Table 2 — Coating thickness and required fundamental deviation

Dimensions in micrometres

Coating thickness ^a		Minimum fundamental deviation required
minimum (if required, see Table 3) t_{min}	maximum (to be expected) t_{max}	
4	8	32
5	10	40
6	12	48
8	16	64
9	18	72
10	20	80
12	24	96

^a The thickness of coating on the bearing face of fasteners is important with regard to reduction of clamp load due to relaxation.



Key

1 Measuring area

Figure 1 — Measuring area for coating thickness measurement on threaded fasteners

6 Testing of corrosion protection

The neutral salt spray test in accordance with ISO 9227 is used to evaluate the quality of the coating. The test is applied to coated parts which are in the as-delivered condition. Performance in the test cannot be related to corrosion protection behaviour in particular service environments.

NOTE In normal cases the coating should be defined by specifying the test duration for neutral salt spray test from those given in Table 3, see example 1 in clause 9.

After the neutral salt spray test using a test duration as given in Table 3 there shall be no visible ferrous (red) corrosion attack on the base metal.

Table 3 — Test duration (neutral salt spray test)

Test duration h	Minimum local coating thickness (if specified by the purchaser) ^a	
	Coating with chromate (fIZnyc)	Coating without chromate (fIZnnc)
	µm	µm
240	4	6
480	5	8
720	8	10
960	9	12

NOTE If the coating areic mass in g/m² is specified by the purchaser, it may be converted into thickness as follows:
 — coating with chromate: 4,5 g/m² correspond to a 1 µm thickness
 — coating without chromate: 3,8 g/m² correspond to a 1 µm thickness

^a The purchaser may specify whether he wants to have a coating with chromate (fIZnyc) or without chromate (fIZnnc); otherwise the symbol fIZn is suitable, see clause 9.

7 Mechanical and physical properties and testing

7.1 General

The coating process shall not adversely influence the mechanical and physical properties of the fasteners as specified in the relevant ISO Standards.

Consideration shall be given by the manufacturer supported by testing if necessary, to determine whether the curing temperature and duration as specified by the coater are suitable for the particular type of fastener to be coated.

7.2 Appearance

The colour of the coating is silver-grey. The coated fastener shall be free from blisters, localized excess coating and uncoated areas which may have adverse effects on corrosion protection and fitness for use.

Special techniques may be necessary to avoid excess coating or uncoated areas with parts such as washers, nuts and recess drive screws.

7.3 Temperature resistance

After heating the coated fasteners for 3 h at 150 °C (component temperature) the corrosion protection requirements as specified in clause 6 shall still be met.

7.4 Ductility

After loading the coated fastener with the proof load specified in ISO 898-1 the corrosion protection as specified in clause 6 shall still be met in areas other than where thread engagement has occurred. This requirement only applies to bolts, screws and studs with metric thread.

7.5 Adhesion/cohesion

If an adhesive tape with an adhesive strength of (7 ± 1) N per 25 mm width is firmly pressed by hand on to the surface and is subsequently pulled off jerkily and perpendicularly to the surface, the coating shall not be peeled off the base metal. Small amounts of the coating material left sticking to the tape are acceptable.

7.6 Cathodic protection

The cathodic protection capability of the coating can be tested by making the salt spray test according to clause 6 with a specimen which is scratched down to the base metal, the scratch having a width of maximum 0,5 mm. After the salt spray test of 72 h duration there shall be no red rust in the scratched area.

7.7 Torque/tension relationship for coatings with integral lubricant or subsequently (externally) added lubricant

The requirements for torque/tension shall be agreed between the manufacturer and purchaser.

8 Applicability of tests

8.1 General

All requirements given in clauses 5, 6 and 7 apply as far as they are general characteristics of the coating or are separately specified by the customer. The tests included in 8.2 shall be carried out for each lot of fasteners (see ISO 3269). The tests included in 8.3 are not intended to be applied for each fastener lot, but are used for in-process control.

8.2 Tests mandatory for each lot

- Gauging of threads (clause 5).
- Appearance (7.2).
- Adhesion/cohesion (7.5).

8.3 Tests to be conducted for in-process control

- Neutral salt spray test (clause 6).
- Temperature resistance (7.3).
- Ductility (7.4).
- Cathodic protection (7.6).

8.4 Tests which are only to be conducted when specified by the customer

- Coating thickness (clause 5).
- Torque/tension relationship for coatings with integral or subsequently added lubricant (7.7).

9 Designation

The designation of the coating shall be added to the product designation in accordance with the designation system specified in ISO 8991 using the symbol flZn for non-electrolytically applied zinc flake coatings, a figure for the required duration of salt spray test in hours and, if necessary, the specification for a coating with chromate (yc) or without chromate (nc).

EXAMPLE 1 Hexagon head bolt ISO 4014 - M12 × 80 - 10.9 with a non-electrolytically applied zinc flake coating (flZn), with a required duration of salt spray test of 480 h is designated as follows:

Hexagon head bolt ISO 4014 - M12 × 80 - 10.9 - flZn - 480 h

If a coating with integral lubricant is required, the letter L shall be added to the designation after the symbol for the zinc flake coating as follows:

Hexagon head bolt ISO 4014 - M12 × 80 - 10.9 - flZnL - 480 h

If a coating with a subsequently added lubricant (external lubricant) is required, the letter L shall be added at the end of the designation as follows:

Hexagon head bolt ISO 4014 - M12 × 80 - 10.9 - flZn - 480 h - L

EXAMPLE 2 Hexagon head bolt ISO 4014 - M12×80 - 10.9 with a non-electrolytically applied zinc flake coating without chromate flZnnc, with a required duration of salt spray test of 480 h is designated as follows:

Hexagon head bolt ISO 4014 - M12 × 80 - 10.9 - flZnnc - 480 h

EXAMPLE 3 Hexagon head bolt ISO 4014 - M12 × 80 - 10.9 with a non-electrolytically applied zinc flake coating with chromate flZnyc, with a required duration of salt spray test of 480 h is designated as follows:

Hexagon head bolt ISO 4014 - M12 × 80 - 10.9 - flZnyc - 480 h

10 Ordering requirements

When ordering threaded parts to be coated according to this International Standard, the following information shall be supplied to the coater:

- a) reference to this International standard and the coating designation (see clause 9);
- b) The material of the component and its condition, i.e. heat treatment, hardness or other properties, which may be influenced by the coating process;
- c) thread tolerances if different from the product standard;
- d) performance (torque/tension, coefficient of friction) and the test methods for integrally lubricated or supplementary lubricated coatings as agreed between the manufacturer and purchaser;
- e) tests to be carried out, if any (see clause 8);
- f) sampling.

Annex A (informative)

Example for the choice of the coating thickness relating to corrosion protection requirement

A customer wishes to order ISO metric bolts M10, standard thread pitch of 1,5 mm, with a non-electrolytically applied zinc flake coating.

According to his experience he needs a minimum test duration of 480 h salt spray test in order to fulfil the corrosion protection requirement of his application.

Using Table 3, the customer decides to choose a non-electrolytically applied zinc flake coating with chromate (fIZnyc) with a minimum coating thickness of 5 µm corresponding to the minimum duration of 480 h.

Using Table 2, he finds out that the minimum coating thickness of 5 µm corresponds to a maximum coating thickness of 10 µm and therefore a minimum fundamental deviation of 40 µm is needed.

Using Table 1, he finds out that the minimum fundamental deviation of 40 µm for a thread pitch of 1,5 mm can only be achieved by using the tolerance position f. This implies that he cannot order the bolts with a 6g tolerance before coating.

The customer can decide amongst three possibilities:

- 1) To accept the 6f tolerance on the bolts before coating:

The coater will know from ISO 10683 that he cannot go beyond a 11 µm coating thickness in order to avoid assembly problems.

The customer will order:

Hexagon head bolts ISO 4014 - M10 × 60 - 10.9 - fIZnyc - 480 h

Thread tolerance 6f before coating

- 2) The customer could decide to keep the 6g tolerance and diminish the corrosion resistance requirement.

The fundamental deviation given in Table 1 is 32 µm for a thread pitch of 1,5 mm, which allows a maximum coating thickness of 8 µm. Reading Table 2, the customer finds the corresponding minimum coating thickness of 4 µm, which corresponds to a salt spray test duration of 240 h in Table 3 for a coating with chromate (fIZnyc).

He will order:

Hexagon head bolts ISO 4014 - M10 × 60 - 10.9 - fIZnyc - 240 h

NOTE In this case the specification of the thread tolerance is not necessary since it is according to the product standard.

- 3) The customer wants to keep the tolerance position g but requires 480 h minimum duration of salt spray test.

In this case he shall reduce the thread diameter tolerance, which is 132 μm for tolerance grade 6, by an amount necessary to allow for the required coating thickness.

480 h with coating with chromate (fZnyc): $t_{\min} = 5 \mu\text{m}$ (Table 3)
 $t_{\max} = 10 \mu\text{m}$

Clearance required for coating: 40 μm

Fundamental deviation for tolerance position g: 32 μm

necessary reduction of thread tolerance: 8 μm

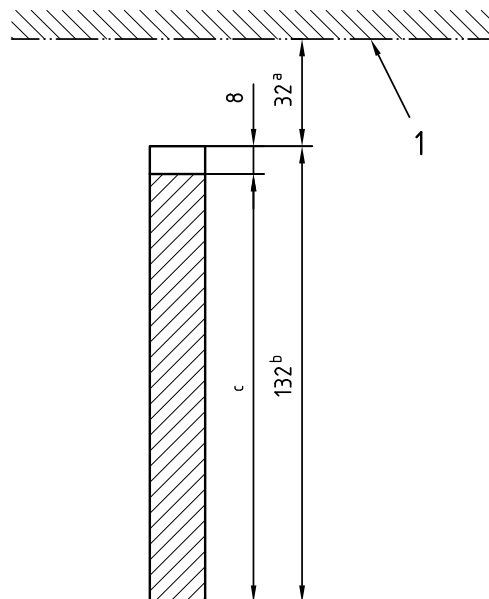
He will order:

Hexagon head bolt ISO 4041 - M10 \times 60 - 10.9 fZnyc - 480 h

Maximum thread dimensions of tolerance class 6g reduced by 8 μm

NOTE For the necessary reduction of the thread tolerance of tolerance grade 6 see figure A.1.

Tolerances in micrometres



Key

1 Zero line

^a Fundamental deviation of tolerance position g

^b Tolerance of tolerance grade 6

^c Restricted tolerance of tolerance grade 6

Figure A.1 — Reduction of thread tolerance in order to accept a specified coating