

Productinformation

Technical delivery-terms of HECO galvanic zinc-nickel-surfaces

Table 3.4 Valid for Universal screws, Timber screws, HMS;-MMS,-WSA-Concrete screws, Special screws, Self-tapping screws made of carbon steel

Characteristics	ZnNi-Alloy - galvanic process chromate / passivated, Chromium-VI-free	
	79	88
Surface-Code HECO	79	88
Surface acc. to DIN 50979	Fe // ZnNi 8 // Cn//T0 (12 - 16 % Ni)	Fe // ZnNi 12 // Cn//T0 (12 - 16 % Ni)
Passivation	Colorless - blue iridescent (Chromium-VI-free)	colorless - blue iridescent (Chromium-VI-free)
Corrosivity-class acc. to DIN 50962 table 1 + 3	2	3
Surface-thickness (µm/head- surface)	min. 8 µ	min. 12 µ
Color chromate layer thickness acc. to table E.3. DIN EN ISO 4042	Code letter E no color if necessary additional agreement of limit samples	Code letter E no color if necessary additional agreement of limit samples
Color-hue / passivation proceed- group acc. to DIN 50979 table 2	Cn/T0 colourless to blue iridescent if necessary additional agreement of limit samples	Cn/T0 colourless to blue iridescent if necessary additional agreement of limit samples

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Gloss-level (a.t. limiting sample)	blanc If necessary additional agreement of limit samples	
Test-point surface thickness	head surface apart from that acc. to DIN EN ISO 4042	
Surface-thickness test-practice	Acc. to valid DIN/ISO-standards as X-Ray-procedures acc. to DIN EN ISO 3497 or microscopical-test-method acc. to DIN EN ISO 1463	
Surface-condition	without surface-corrosion, basic-metal-corrosion, bubbles, color-deviation, damaging	
Corrosion-test	Salt-spray-test DIN EN ISO 9227 NSS / DIN 50021 SS	
Corrosion acc. to DIN 50979 tab. 5 Min. resistance passivation-coating / Surface corrosion Basic metal corrosion * acc. to DIN 50979 reduce of test-complexity on 720 h, if necessary testing-periods could be until to the real basic-metal-corrosion	WR 120 h *RR 720 h	WR 120 h *RR 720 h

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Straightness	L < 150 mm: L x 0,004 in mm L ≥ 150 mm: L x 0,005 in mm	
Magnetism / field force	< Ø 5,0 mm = max. 15 A/cm ≥ Ø 5,0 mm = max. 25 A/cm	
Electrolytes	Zinc-plated in acid, cyan-free electrolytes	
Hydro induced tension-crack-embrittlement (Hydro embrittlement)	hydro embrittlement not acceptable Use of procedures for avoidance of hydro-embrittlement	