DIN EN ISO 4042:2022-11 (E)

Fasteners - Electroplated coating systems (ISO 4042:2022)

Coi	ntents	;	Page	
Euro	opean fo	oreword	4	
Fore	eword		5	
Intr	oductio	n	6	
1		e		
2	_	native references		
3		ns and definitions		
4	General characteristics of the coating			
	4.1 4.2 4.3 4.4	Coating metals or alloys and main purposes Build-up of basic electroplated coating systems Coating systems and coating processes Internal hydrogen embrittlement 4.4.1 General 4.4.2 Fasteners with hardness up to 360 HV 4.4.3 Fasteners with hardness above 360 HV and up to 390 HV 4.4.4 Fasteners with hardness above 390 HV 4.4.5 Fasteners in accordance with ISO 898-1, ISO 898-2 and ISO 898-3 4.4.6 Case-hardened fasteners 4.4.7 Work hardened fasteners and fasteners with threads rolled after heat treatment 4.4.8 Fasteners with bainitic structure Baking		
5	5.1 5.2 5.3 5.4	General Neutral salt spray test (NSS) for zinc-based coating systems Sulfur dioxide test (Kesternich test) Bulk handling, automatic processes such as feeding and/or sorting, storage and transport	15 16 17	
6		ensional requirements and testing		
	6.1 6.2 6.3 6.4	General Fasteners with ISO metric thread 6.2.1 Coating thickness 6.2.2 Gaugeability and assemblability Other fasteners Test methods for thickness determination	18 19 19 20	
7		nanical and physical properties and testing		
	7.1 7.2	General Appearance		
	7.3	Corrosion resistance related to temperature		
	7.4	Torque/clamp force relationship		
	7.5	Determination of hexavalent chromium	22	
8		icability of tests		
	8.1	General Tosts mandatowy for each lat		
	8.2 8.3	Tests mandatory for each lot		
	8.4	Tests to be performed when specified by the purchaser		

9	Designation system			
	9.1	General	23	
	9.2	Designation of electroplated coating systems for the order	24	
	9.3	Examples of designation of hexavalent chromium free electroplated coating systems for fasteners	26	
	9.4	Designation of fasteners with electroplated coating systems for labelling	27	
10	Orde	ring requirements for electroplating	27	
11	Stora	ge conditions	28	
Annex	A (inf	ormative) Design and assembly aspects for joints with coated fasteners	29	
Annex	Annex B (informative) Hydrogen embrittlement consideration			
Annex		nformative) Corrosion protection related to zinc coatings with chromate ersion coatings	42	
Annex	D (inf	Formative) Coating thickness and thread clearance for ISO metric threads	43	
Annex	Annex E (informative) Coating systems tested in accordance with ISO 9227, NSS — Evaluation of cabinet corrosivity for the neutral salt spray test			
Annex		formative) Obsolete designation codes for electroplated coating systems on ners according to ISO 4042:1999	60	
Biblio	graph	y	63	