

DIN EN ISO 4042:2022-11 (E)

Fasteners - Electroplated coating systems (ISO 4042:2022)

Contents		Page
European foreword		4
Foreword		5
Introduction		6
1 Scope		7
2 Normative references		7
3 Terms and definitions		8
4 General characteristics of the coating		8
4.1 Coating metals or alloys and main purposes		8
4.2 Build-up of basic electroplated coating systems		9
4.3 Coating systems and coating processes		10
4.4 Internal hydrogen embrittlement		10
4.4.1 General		10
4.4.2 Fasteners with hardness up to 360 HV		11
4.4.3 Fasteners with hardness above 360 HV and up to 390 HV		11
4.4.4 Fasteners with hardness above 390 HV		11
4.4.5 Fasteners in accordance with ISO 898-1, ISO 898-2 and ISO 898-3		12
4.4.6 Case-hardened fasteners		13
4.4.7 Work hardened fasteners and fasteners with threads rolled after heat treatment		14
4.4.8 Fasteners with bainitic structure		15
4.5 Baking		15
5 Corrosion protection and testing		15
5.1 General		15
5.2 Neutral salt spray test (NSS) for zinc-based coating systems		16
5.3 Sulfur dioxide test (Kesternich test)		17
5.4 Bulk handling, automatic processes such as feeding and/or sorting, storage and transport		18
6 Dimensional requirements and testing		18
6.1 General		18
6.2 Fasteners with ISO metric thread		18
6.2.1 Coating thickness		18
6.2.2 Gaugeability and assemblability		19
6.3 Other fasteners		19
6.4 Test methods for thickness determination		20
7 Mechanical and physical properties and testing		22
7.1 General		22
7.2 Appearance		22
7.3 Corrosion resistance related to temperature		22
7.4 Torque/clamp force relationship		22
7.5 Determination of hexavalent chromium		22
8 Applicability of tests		23
8.1 General		23
8.2 Tests mandatory for each lot		23
8.3 Tests for in-process control		23
8.4 Tests to be performed when specified by the purchaser		23

9	Designation system	23
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	Ordering requirements for electroplating	27
11	Storage conditions	28
Annex A (informative) Design and assembly aspects for joints with coated fasteners		29
Annex B (informative) Hydrogen embrittlement consideration		37
Annex C (informative) Corrosion protection related to zinc coatings with chromate conversion coatings		42
Annex D (informative) Coating thickness and thread clearance for ISO metric threads		43
Annex E (informative) Coating systems tested in accordance with ISO 9227, NSS — Evaluation of cabinet corrosivity for the neutral salt spray test		50
Annex F (informative) Obsolete designation codes for electroplated coating systems on fasteners according to ISO 4042:1999		60
Bibliography		63