



CORPORATE STANDARD

AA 067 36 04

Rev. No. 05

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PROCESS FOR PASSIVATION OF ZINC AND CADMIUM PLATED ARTICLES

1.0 GENERAL:

This standard details the compositions of the passivation solution and the procedure for passivation of zinc and cadmium electroplated articles.

2.0 APPLICATION:

To increase resistance to corrosion and finger marking.

3.0 COMPLIANCE WITH NATIONAL STANDARDS:

This standard has reference to the following Indian standards regarding the quality of the passivated film:

- i) IS: 1340-1977 (RA2006): Code of practice for chromate conversion coating on zinc and cadmium coated articles and zinc base alloys
- ii) IS: 1573-1986(RA 2006): Electroplated coating of zinc on iron and steel.

4.0 MATERIAL:

Material	CPS No. / IS No. / Available From
4.1 Sulphuric Acid (Technical)	: AA 541 01
4.2 Nitric Acid (Technical)	: AA 541 02
4.3 Chromic Acid-Electroplating Grade:	AA 541 04
4.4 Sodium Bichromate (Technical)	: AA 556 12
4.5 Ginthox - Q.982 (L)	: M/s Grauer & Weil (I) Ltd.,
4.6 Ginthos - 995	: Mumbai.
4.7 Kempas - 755	: M/s Artek surfen Chemicals (P) Ltd., Mumbai
4.8 Zinc chrome 62L	: M/S Platewel & process chemicals, Vadodara

5.0 EQUIPEMENT:

- 5.1 Passivating Rinsing Tank : FRP/PVC lined mild steel tank preferable with heating arrangements.

Revisions: As per 40th MOM of
MRC-CPO

APPROVED :
INTERPLANT MATERIAL
RATIONALISATION COMMITTEE-MRC (CPO)

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Reaffirmedd

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HARDWAR

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