



TSD 6208 B

PLANT STANDARD BHOPAL

BP 067 36 93

Rev. No. 03

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SUPERSEDES
BP 0673693 Rev. 02

ELECTROPLATING OF ZINC ON STEEL SURFACES FROM ACID BATH

1.0 GENERAL:

This standard details the process for bright zinc deposit on steel surfaces from acid chloride zinc solution by tank/barrel to provide protection against corrosion and to give bright attractive plating with excellent ductility.

2.0 APPLICATION:

Used for components like fasteners, nuts, bolts, electronic panels, tubes etc.

3.0 COMPLIANCE WITH NATIONAL STANDARDS:

This standard has reference to the following Indian Standards regarding surface condition and quality of deposit.

IS:1340 : Code of Practice For Chromate Conversion Coating on Zinc And Cadmium Coated Articles And Zinc Base Alloys.

IS:1572 : Electroplated Coatings OF Cadmium On Iron And Steel.

IS:3203 : Methods of Testing Local Thickness Of Electroplated Coatings.

4. MATERIALS

	CPS No/IS No/Available from
4.1 Surclean EC 504	M/s Grauer and weil (I) (P) Ltd. Bombay.
4.1.1 Surfolin EC 54	M/s Artek Surfin Chemicals (P) Ltd. Bombay.
4.2 <u>Gin Bond 808</u>	M/s Grauer and Weil (I) Ltd Bombay

Revision: Reviewed & Updated.

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4.2.1	Surfolin EL 80	M/s Artek Surfin Chemicals (P) Ltd Bombay
4.3	Zintho Brite CL2 936A	M/s Grauer and weil (I) Ltd Bombay
4.3.1	Tekno Brite AZ 846A	M/s Artek Surfin Chemicals (P) Ltd Bombay
4.4	Zintho Brite 937 BR	M/s Grauer and Weil (I) Ltd Bombay
4.4.1	Tekno Brite AZ 846 B	M/s Artek Surfin Chemicals (P) Ltd Bombay
4.5	Tekno Brite 942 M Or Latest Equivalent	M/s Grauer and Weil (I) Ltd Bombay
4.5.1	Tekno Brite AZ,846 M Or Latest Equivalent	M/s Artek Surfin Chemicals (P) Ltd Bombay
4.6	Tekno Brite AZ 942 R Or Latest Equivalent	M/s Grauer and Weil (I) Ltd Bombay
4.6.1	Tekno Brite AZ 846 R Or Latest Equivalent	M/s Artek Surfin Chemicals (P) Ltd Bombay
4.7	Ginthox 995	M/s Grauer and Weil (I) Ltd Bombay
4.7.1	Ginthox Q 982 L	M/s Grauer and Weil (I) Ltd Bombay
4.7.2	Kempas 755	M/s Artek Surfin Chemicals (P) Ltd Bombay
4.8	Inhibitor II	M/s Grauer and Weil (I) Ltd Bombay
4.9	Hydrogen Peroxide Puregrade (30%)	
4.10	Caustic Soda (tech)	AA 54201
4.11	Sulphuric Acid (Tech)	AA 51401
4.12	Potassium Hydroxide (Tech)	I.S.6831
4.13	Potassium Chloride	1. M/s Grauer and Weil (I) Ltd. Bombay 2. M/s Artek Surfin Chemicals (P) Ltd Bombay