


 GRETSCH-UNITAS   	Works Standard	June 2012
	Technical Specification of Surface Code WN05501	WN 05502-1R

Modification record				
Edition	Page	Modification no.	Description of modification	Date / Name
07/1999	1-1	14422	(New surface code)	08.07.1999 / Speidel
06/2008	1-1	G21303	RAL-RG 660 → DIN EN 13329 and 13126 DIN 50021 → EN ISO 9227 Treatment on racks 350 h > 400 h Further remarks updated	25.06.2008 / Di
02/2009	1-1	G22106	Purchasing text amended acc. to SAP ZOFL table, identical with English specification	17.02.2007 / Di
06/2012	1-1	G25316	DIN EN 12329 → DIN EN ISO 2081	29.06.2012 / Na

Surface Code	1R - Cyanid or alkaline electrogalvanised, blue passivated and sealed
Old surface code :	-
Group :	Galvanised
Purchasing text :	Cyanid or alkaline electrogalvanised, blue passivated and sealed
Sales text :	ferGUard*silver
Colour category :	[1] silver
Function of the surface :	Protection of steel parts against corrosion, decorative coating on zinc die cast and brass.
Materials :	Low alloy steel, zinc, brass, copper
Method of pretreatment :	A metallically pure and active surface is achieved by degreasing and inhibited pickling.
Quality requirements :	In accordance with DIN EN ISO 2081 and DIN EN 13126, stress level 3, minimum layer thickness 12 µm; exception: DIN parts (screws, nuts) and parts with specifications laid down. Corrosion resistance to DIN EN ISO 9227 NSS: Parts treated on racks > 400 h until formation of white corrosion (>2%). Parts treated in drums > 250 h until formation of white corrosion (>2%).
Dimensional changes :	Due to the zinc coat, a dimensional increase of up approx. 20 µm is to be expected. Higher coat thicknesses on edges.
Further remarks :	With high-resistant materials, alkaline zinc-plating may cause hydrogen-induced brittle fraction. Here, the appropriate treatment is acidic electrogalvanisation with blue passivation and sealing. Blue passivation specification : Cr(VI)-free system "Lanthane 311 / Finidip 12" from the company Coventya. Sealing specification : System "Finigard 401 GU-F" from the company Coventya. Visible surfaces drip-free and non-running. By permission of GU, also similar Cr(VI)-free systems of other suppliers may be used for passivation and sealing.