

<b>BOSCH NORM</b>	Surface finishing, metallic coatings <b>Deposition of ZnNi alloys, transparent passivation and sealing</b>	N67F <b>826 10</b>				
Oberflächenverfahren, metallische Überzüge; Abscheiden einer ZnNi-Legierung, transparent Passivieren und Versiegeln		Replaces edition 2004-02				
<b>In case of doubt, apply the German version of this Bosch Norm.</b>						
<b>1 Scope</b>						
This norm describes requirements and characteristics of the ZnNi alloy coating to be applied as well as process specifications. The principal subject of this norm is the protection of components against corrosion.						
This norm applies to Fe materials with tensile strength < 1000 N/mm <sup>2</sup> (< 31 HRC), e.g. steel or gray cast iron.						
<b>2 Requirements and characteristics</b>						
<b>2.1 Coating thickness</b>						
≥ 5 µm ZnNi,						
Measuring point(s) and maximum coating thickness according to drawing.						
<b>2.2 Corrosion resistance</b>						
<b>2.2.1 Salt spray test according to N42AP 102</b>						
<table border="1"> <tr> <td>Test duration</td> <td>acceptable degree of corrosion or rusting (white or red rust) according to N42AP 015</td> </tr> <tr> <td>h</td> <td></td> </tr> </table>	Test duration	acceptable degree of corrosion or rusting (white or red rust) according to N42AP 015	h			
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h						
120	K 0					
600	Ri 0					
<b>2.3 Hue</b>						
Silver colors						
<b>2.4 Absence of Cr(VI)</b>						
The applied coating should be Cr(VI)-free. Testing method in accordance with draft DIN 50993-1 edition July 2004.						
<b>3 Process specifications</b>						
<b>3.1 Process characteristics</b>						
Electrolytic ZnNi alloy deposition in the barrel (Ni-percentage by mass = 10 to 15 %), transparent passivation and sealing.						
<b>3.2 Process parameters</b>						
<ul style="list-style-type: none"> <li>- Pre-treatment</li> <li>- ZnNi alloy deposition</li> <li>- Passivation</li> <li>- Sealing</li> </ul>						
<b>Note:</b> Additional process parameters can be defined in manufacturing documentation, they are not covered by this norm.						
		Continued on page 2 to 2				
Technical responsibility : CR/APT1						
<b>CR/APS</b>	Re	Language:EN				

### **3.3 Approved suppliers**

No restrictions

**Note:** Qualified suppliers can be suggested by CR/APT1, if required.

### **Additional applicable norms**

N42AP 015;

N42AP 102;

### **Change information on edition**

05.99; 06.00 (A18320); 02.04 (A18798)

### **Alterations**

Section 2.4 "Absence of Cr(VI)" included.

Section 3.2 "Process parameters" under "Passivation" supplement "in Cr(VI)-free solution" removed.