

Mobile Climate Control Global Engineering Requirement	Drawing No. 57-00711 Rev B	Date: May 5, 2010
	Authorization No. 72N0043P10	Sheet 1 of 1
Title: ELECTRODEPOSITED ZINC COATINGS ON SAE INCH AND METRIC THREADED FASTENERS	Supersedes Rev A	Date June 14, 2004 Sheet 1 of 1

1.0 PURPOSE:

This Engineering Requirement was developed to define and control zinc chromate coatings as applied to SAE inch and metric threaded fasteners, specified on MCC drawings. For coating non-threaded fasteners, see MCC Engineering Requirement 57-00700.

2.0 SCOPE:

The following note shall appear under "Specifications" on MCC drawings as required:
 "Parts to be zinc chromate coated per MCC Engineering Requirement 57-00711-XX".

3.0 APPLICATION:

Transport Refrigeration and A/C products.

4.0 SPECIFICATIONS:

MCC Engrg. Requirement Number	Ordering Information per ASTM F 1941 & ASTM F1941M							Test per ASTM B 117 @ 5% Neutral Salt Spray (hrs. to first appearance of.)	
	Coating		Coating Thickness		Chromate Finish				
	Designation	Type	Designation	Min. Thk.	Designation	Type	Typical Appearance	White Corrosion	Red Rust
57-00711-00	Fe/Zn	Zinc	5	0.0002	D	Opaque	Olive green / brown or bronze	72 hrs	96 hrs
57-00711-01	Fe/Zn	Zinc	8	0.0003	C	Yellow	Yellow Iridescent	72 hrs	120 hrs
57-00711-02	Fe/Zn	Zinc	12	0.0005	B	Blue	Transparent w/slight Iridescent	24 hrs	96 hrs
57-00711-03	Fe/Zn	Zinc	12	0.0005	E	Black	Black w/slight Iridescent	24 hrs	96 hrs
57-00711-04	Fe/Zn	Zinc	8	0.0003	AT	Clear	Colorlessw/ Slight Iridescent	72 hrs	120 hrs

"_T" = Trivalent Zinc Chromate

5.0 NOTES:

- All electroplating is to be conducted as described within ASTM F 1941 or ASTM F1941M as applicable, unless otherwise first approved by Mobile Climate Control Engineering.
- The electroplater shall review MCC's threaded fastener drawing(s) to determine if the fastener is susceptible to hydrogen embrittlement, per the requirements set forth in ASTM F 1941 / 1941M. If so determined, then the electroplater shall provide hydrogen embrittlement relief per ASTM F 1941 / 1941M.
- Zinc luster of bright, semi-bright or dull is acceptable unless otherwise specified on the MCC drawing.
- Significant surfaces and supplementary requirements are non-existent unless otherwise noted on the MCC fastener drawing.
- "_T" is used to identify Trivalent Zinc Chromate finish which is RoHs compliant per MCC 57-00765.

6.0 REVISIONS:

Revision A: Added -03 to chart
 Revision B: Added -04 RoHs Compliant Zinc plating to chart "Trivalent Zinc Chromate" and Note 5

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