



Designation: F1136 – 04

# Standard Specification for Zinc/Aluminum Corrosion Protective Coatings for Fasteners<sup>1</sup>

This standard is issued under the fixed designation F1136; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

## 1. Scope

1.1 This specification covers the basic requirements for water-based zinc/aluminum dispersion inorganic basecoats and optional sealers and topcoats for fasteners. The basecoat can contain chrome (C) or be non-chrome (NC).

1.2 These coatings are applied by conventional dip-spin, dip-drain, or spray methods to ferrous parts which can be handled through a cleaning, coating, and baking operation, and which are not adversely affected by baking temperatures up to 626°F.

1.3 The coating process does not induce the possibility of internal hydrogen embrittlement providing that the fasteners have not been cleaned or pre-treated with an acid or phosphate. Alkaline cleaning or vapor degreasing is required along with shot blasting to remove rust or scale.

1.4 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

## 2. Referenced Documents

- 2.1 *ASTM Standards:*<sup>2</sup>
- [B117 Practice for Operating Salt Spray \(Fog\) Apparatus](#)
  - [D610 Practice for Evaluating Degree of Rusting on Painted Steel Surfaces](#)
  - [D3359 Test Methods for Measuring Adhesion by Tape Test](#)
  - [F606 Test Methods for Determining the Mechanical Properties of Externally and Internally Threaded Fasteners, Washers, Direct Tension Indicators, and Rivets](#)

<sup>1</sup> This specification is under the jurisdiction of ASTM Committee F16 on Fasteners and is the direct responsibility of Subcommittee F16.03 on Coatings on Fasteners.

Current edition approved July 1, 2004. Published July 2004. Originally approved in 1988. Last previous edition approved in 1998 as F1136 – 88 (1998)<sup>e1</sup>. DOI: 10.1520/F1136-04.

<sup>2</sup> For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

- [F1470 Practice for Fastener Sampling for Specified Mechanical Properties and Performance Inspection](#)
- [F1789 Terminology for F16 Mechanical Fasteners](#)
- [F1940 Test Method for Process Control Verification to Prevent Hydrogen Embrittlement in Plated or Coated Fasteners](#)

## 3. Classification

3.1 These coatings are classified into six grades according to the requirements in [Table 1](#).

3.1.1 Grade 1 requires a minimum basecoat thickness of 0.16 mil (0.052 oz/ft<sup>2</sup>). This is usually applied in two coats to bulk parts, or one coat to racked parts. No topcoat is applied in Grade 1.

3.1.2 Grade 2 requires a minimum basecoat thickness of 0.20 mil (0.066 oz/ft<sup>2</sup>). This is usually applied in two coats to bulk parts, or one coat to racked parts. No topcoat is applied in Grade 2.

3.1.3 Grade 3 requires a minimum basecoat thickness of 0.20 mil (0.066 oz/ft<sup>2</sup>) and a single coat of the clear sealer. The sealer provides additional corrosion protection and greater lubricity than Grade 2.

3.1.4 Grade 4 requires a minimum basecoat thickness of 0.31 mil (0.092 oz/ft<sup>2</sup>). This is usually applied in three coats to bulk parts, or one to two coats to racked parts. No topcoat is applied in Grade 4.

3.1.5 Grade 5 requires a minimum basecoat thickness of 0.20 mil (0.066 oz/ft<sup>2</sup>) and a single coat of the lubricated sealer. The sealer provides additional corrosion protection than Grade 2 and greater lubricity than Grade 3.

3.1.6 Grade 6 requires a minimum basecoat thickness of 0.20 mil (0.066 oz/ft<sup>2</sup>) with various pigmented topcoats applied. The topcoats can be black or various other colors.

## 4. Ordering Information

4.1 Orders for parts under this specification shall include the following information:

- 4.1.1 Quantity of parts,
- 4.1.2 Grade of coating as given in [Table 1](#),