



Designation: F 1428 – 92 (Reapproved 1999)

Standard Specification for Aluminum Particle-Filled Basecoat/Organic or Inorganic Topcoat, Corrosion Protective Coatings for Fasteners¹

This standard is issued under the fixed designation F 1428; 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 (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This specification covers the basic requirements for a corrosion-resistant coating consisting of an inorganic aluminum particle-filled basecoat and an organic or inorganic topcoat, depending on the specific requirements.

1.2 The coating may be specified with basecoat only, or with the top coated with compatible organic polymer or inorganic topcoats, depending on the specific requirements.

1.3 The basecoat is a water-dilutable slurry containing aluminum particles dispersed in a liquid binder of chromate/phosphate compounds.

1.4 The organic topcoats consist of polymer resins and dispersed pigments and are for service where temperatures do not exceed 230°C (450°F).

1.5 The inorganic topcoats consist of ceramic oxide pigments dispersed in a liquid binder of chromate/phosphate compounds and are for service where temperatures do not exceed 645°C (1200°F).

1.6 These coatings are applied by conventional dip/spin, dip/drain, or spray methods.

1.7 The coating process does not normally induce hydrogen embrittlement, provided that the parts to be coated have not been subjected to an acid cleaner or pretreatment (see Note 1).

NOTE 1—Although this coating material contains water, it has a relatively low susceptibility to inducing hydrogen embrittlement in steel parts of tensile strengths equal to or greater than 1000 MPa (approximately RC31). Normal precautions for preparing, descaling, and cleaning steels of these tensile strengths must be observed. An initial stress relief treatment should be considered prior to any chemical treatment or cleaning operation. Acids or other treatments that evolve hydrogen should be avoided. Mechanical cleaning methods may be considered. Some steels are more susceptible to hydrogen embrittlement than others and may also require hydrogen embrittlement relief baking after cleaning but before coating. Since no process can completely guarantee freedom from embrittlement, careful consideration must be given to the entire coating process and the specific steel alloy employed.

¹ This specification is under the jurisdiction of ASTM Committee F-16 on Fasteners and is the direct responsibility of Subcommittee F16.03 on Metal Coatings on Threaded Fasteners.

Current edition approved Aug. 15, 1992. Published October 1992.

1.8 The coating systems defined by this specification can be applied to ferrous alloy steels, aluminum, and ferritic and austenitic stainless steels.

1.9 The values stated in SI units are to be regarded as the standard. The values given in parentheses are for information only.

1.10 The following safety hazards caveat pertains only to the test methods portion, Section 6, of this specification: *This standard does not purport to address all of the safety problems, 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:

B 117 Test Method of Salt Spray (Fog) Testing²

B 487 Test Method for Measurement of Metal and Oxide Coating Thicknesses by Microscopical Examination of a Cross Section³

B 568 Test Method for Measurement of Coating Thickness by X-Ray Spectrometry³

D 1186 Test Methods for Nondestructive Measurement of Dry Film Thickness of Nonmagnetic Coatings Applied to a Ferrous Base⁴

D 2247 Practice for Testing Water Resistance of Coatings in 100 % Relative Humidity⁴

D 3359 Test Methods for Measuring Adhesion by Tape Test⁴

E 122 Practice for Choice of Sample Size to Estimate a Measure of Quality for a Lot or Process⁵

E 376 Practice for Measuring Coating Thickness by Magnetic-Field or Eddy-Current (Electromagnetic) Test Methods⁶

² Annual Book of ASTM Standards, Vol 03.02.

³ Annual Book of ASTM Standards, Vol 02.05.

⁴ Annual Book of ASTM Standards, Vol 06.01.

⁵ Annual Book of ASTM Standards, Vol 14.02.

⁶ Annual Book of ASTM Standards, Vol 03.03.