

Form No.: BEL-840-2 Revision: B Form Rev Date: 4/27/18 Form Created: 1/14/18		Record No: BEL-840-2-ASTM B633 Revision: A Record Rev Date: 5/8/18 Record Created: 5/8/18
Document Title: ASTM-B633 - Zinc Plating Purchase Order Supplemental		
Approval: CMCB		
<b>Rev</b>	<b>Date</b>	<b>Rev description</b>
A	5/8/18	Record Established

**ASTM-B633**

As specified in the latest revision of ASTM-B633, the following statements regarding purchasers' requirements of the supplier shall apply for Belden purchase order: \_\_\_\_\_

**FINISH TYPE: Check applicable finish**

- Zinc Plating Type I IAW ASTM B633
- Zinc Plating Type II IAW ASTM B633
- Zinc Plating Type III IAW ASTM B633
- Zinc Plating Type IV IAW ASTM B633
- Zinc Plating Type V IAW ASTM B633
- Zinc Plating Type VI IAW ASTM B633

**THICKNESS CLASS: Check applicable thickness (Post plating dimensions should match the drawing call out)**

- Zinc Plating Class Fe/Zn 5 SC 1 IAW ASTM B633
- Zinc Plating Class Fe/Zn 8 SC 2 IAW ASTM B633
- Zinc Plating Class Fe/Zn 12 SC 3 IAW ASTM B633
- Zinc Plating Class Fe/Zn 25 SC 4 IAW ASTM B633

**LUSTER:**

Luster per standard. Additives such as a brightener that can cause Hydrogen Embrittlement failure should not be used.

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**ADDITIONAL PROCESSES**

**1. Pre-plating Hydrogen Embrittlement Relief Treatment** – Required by purchaser. For HRc 31 and above, pre-plating hydrogen embrittlement relief treatment shall be performed.

**Post-plating Hydrogen Embrittlement Relief Treatment** – Required by purchaser. Elongated HE bake

- i. Hydrogen Embrittlement relief treatment shall be performed:
  - a. For HRc 31 and above: 401°F +/-27°F for 44 hr minimum
  - b. Time between plating and Baking shall not exceed 4 hrs – Must be documented.

**Corrosion Resistance Test**

- Not Required
- Required

**Hydrogen Embrittlement test:** Belden will supply notch bars and be responsible for hydrogen embrittlement testing. In the case of a Hydrogen Embrittlement failure, supplier shall be responsible for the cost of reworking.

**Sample size for inspection** – As specified within ASTM B633

**Supplementary requirements** – Supplier is responsible for inspection per ASTM B633