

Specification for

Electroplated coatings on threaded components —

**Part 7: Thicker platings for threaded
components**

621.882:669.058:621.357.7:620.197.6

Co-operating organizations

The Mechanical Engineering Industry Standards Committee, under whose supervision this British Standard was prepared, consists of representatives from the following Government departments and scientific and industrial organizations:

Associated Offices Technical Committee	Institution of Gas Engineers
Association of Consulting Engineers	Institution of Heating and Ventilating Engineers
Association of Mining Electrical and Mechanical Engineers	Institution of Mechanical Engineers
Board of Trade	Institution of Mechanical Engineers, Automobile Division
British Chemical Plant Manufacturers' Association	Institution of Production Engineers*
British Compressed Air Society	Locomotive and Allied Manufacturers' Association of Great Britain*
British Electrical and Allied Manufacturers' Association*	London Transport Board*
British Gear Manufacturers' Association	Machine Tool Trades Association
British Internal Combustion Engine Manufacturers' Association*	Ministry of Defence, Army Department*
British Iron and Steel Federation	Ministry of Defence, Navy Department*
British Mechanical Engineering Federation	Ministry of Labour, H.M. Factory Inspectorate
British Railways Board*	Ministry of Power
Crown Agents for Oversea Governments and Administrations	Ministry of Public Building and Works
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Engineering Equipment Users' Association*	Ministry of Transport
Gas Council	National Coal Board*
Institute of Marine Engineers	National Physical Laboratory, (Ministry of Technology)
Institution of Civil Engineers	Radio Industry Council*
	Royal Institute of British Architects

The Government departments and scientific and industrial organizations marked with an asterisk in the above list, together with the following, were directly represented on the committee entrusted with the preparation of this standard:

Agricultural Engineers Association	Scientific Instrument Manufacturers Association
British Bolt, Nut, Screw and Rivet Federation	Screw Thread Tool Manufacturers Association
British Non-ferrous Metals Research Association	Society of British Aerospace Companies Ltd.
Electronic Engineering Association	Society of Motor Manufacturers and Traders Ltd.
Fasteners and Turned Parts Institute	Telecommunication Engineering and Manufacturing Association
Gauge and Tool Makers' Association	Tin Research Institute
Institute of Metal Finishing	Individual Manufacturers
Ministry of Aviation	
National Association of Marine Engine Builders	
Radio and Electronic Component Manufacturers Federation	

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Foreword

This standard makes reference to the following British Standards:

- BS 57, *B.A. screws, bolts and nuts.*
- BS 84, *Parallel screw threads of Whitworth form.*
- BS 93, *British Association (B.A.) screw threads with tolerances for sizes 0 B.A. to 16 B.A.*
- BS 450, *Machine screws and machine screw nuts (B.S.W. and B.S.F. threads).*
- BS 811, *Cycle threads.*
- BS 919, *Screw gauge limits and tolerances.*
- BS 1083, *Precision hexagon bolts, screws and nuts (B.S.W. and B.S.F. threads).*
- BS 1224, *Electroplated coatings of nickel and chromium.*
- BS 1580, *Unified screw threads.*
- BS 1706, *Electroplated coatings of cadmium and zinc on iron and steel.*
- BS 1768, *Unified precision hexagon bolts, screws and nuts (UNC and UNF-threads). Normal series.*
- BS 1872, *Electroplated coatings of tin.*
- BS 1981, *Unified machine screws and machine screw nuts.*
- BS 2779, *Fastening threads of B.S.P. sizes.*
- BS 2816, *Electroplated coatings of silver for general engineering purposes.*
- BS 3155, *American machine screws and nuts in sizes below ¼ inch diameter.*
- BS 3382, *Electroplated coatings of threaded components — Part 1: Cadmium on steel components — Part 2: Zinc on steel components — Part 3: Nickel or nickel plus chromium on steel components — Part 4: Nickel or nickel plus chromium on copper and copper alloy (including brass) components — Part 5: Tin on copper and copper alloy (including brass) components¹⁾ — Part 6: Silver on copper and copper alloy (including brass) components¹⁾.*
- BS 3597, *Electroplated coatings of 65/35 tin-nickel alloy.*
- BS 3643, *ISO metric screw threads.*
- BS 3692, *Dimensions of ISO metric precision hexagon bolts, screws and nuts.*

This British Standard has been prepared under the authority of the Mechanical Engineering Industry Standards Committee. It deals with the plating of small threaded components, such as bolts, screws and nuts in various materials, with the commoner protective finishes.

The completed standard will refer to:

- *Part 1: Cadmium on steel components;*
- *Part 2: Zinc on steel components;*
- *Part 3: Nickel or nickel plus chromium on steel components;*
- *Part 4: Nickel or nickel plus chromium on copper and copper alloys (including brass) components;*
- *Part 5: Tin on copper and copper alloy (including brass) components;*
- *Part 6: Silver on copper and copper alloy (including brass) components;*
- *Part 7: Thicker platings for threaded components.*

Part 7 deals with the thicknesses of plating which will provide a greater degree of protection against corrosion than is possible on standard threads without interference.

¹⁾ In course of preparation.

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Summary of pages

This document comprises a front cover, an inside front cover, pages i to iv, pages 1 to 10, an inside back cover and a back cover.

This standard has been updated (see copyright date) and may have had amendments incorporated. This will be indicated in the amendment table on the inside front cover.

