INTERNATIONAL STANDARD ISO 3160

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

Watch cases and their accessories — General requirements for gold alloy coverings

Boîtes de montres et leurs accessoires — Caractéristiques générales relatives aux revêtements en alliages d'or

First edition — 1975-04-01

UDC 681.11.036.2 : 671.14

Ref. No. ISO 3160-1975 (E)

Descriptors : clocks, metal coatings, gold alloys, gold coatings, specifications.

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Full document details: ISO 3160-1975

Watch cases and their accessories — General requirements for gold alloy coverings

1 SCOPE AND FIELD OF APPLICATION

This International Standard lays down technical definitions concerning gold alloy coverings.

This International Standard applies to watch cases, their accessories and crowns, including bracelets when they are permanently attached to the case.

2 DEFINITIONS

2.1 gold plated covering : A method of covering by which a layer of gold alloy is applied to the component by electrolytic, chemical or other process.

2.2 rolled gold covering : A method of covering by which a layer of gold alloy is bonded to a sheet or bar of base metal, the whole then being subjected to reduction by rolling.

2.3 gold capping : A method of covering by which a cap of gold alloy produced separately is permanently affixed to the component.

2.4 significant surface : That part of the surface which is to receive the gold covering and which is essential to the appearance or serviceability of the component.

2.5 fineness : The proportion of pure gold contained in the gold alloy, normally expressed in thousandths (41,67 thousandths = 1 carat).

3 FINENESS OF GOLD ALLOY

3.1 Gold plated covering

585 thousandths minimum

3.2 Rolled gold covering

417 thousandths minimum

3.3 Gold capping

585 thousandths minimum

4 MEASUREMENT OF THICKNESS OF COVERING

The thickness of the covering shall be measured at those points of the surface which can be touched by a ball of 5 mm diameter.

5 THICKNESS OF COVERINGS

5.1 Gold plated covering

The range of nominal thicknesses is the following 0,5 — 1 — 2 — 5 — 10 — 20 — 40 — 80 μm, with a tolerance of − 20 %.

5.2 Rolled gold covering

The range of nominal thicknesses is the following 2 — 5 — 10 — 20 — 40 — 80 μm, with a tolerance of − 20 %.

5.3 Gold capping

The range of nominal thicknesses is the following 200 — 250 — 300 μm, with a tolerance of − 50 %.

6 MARKING OF COVERINGS

6.1 The marking shall comprise :

- the letter denoting the type of covering;
- the figure giving the nominal thickness in micrometres;
- the maker's mark or mark of responsibility.

The markings shall be indelible and normally visible.

6.2 When watch-case components, as defined in clause 1, have different thicknesses of gold alloy, only the lowest value is to be marked.

6.3 Sub-clauses 6.1 and 6.2 do not apply to crowns.

6.4 The fineness of the gold alloy shall not be mentioned.

6.5 Marking, except for crowns, is obligatory for the coverings detailed in 2.1, 2.2 and 2.3 for nominal thicknesses of 5 μm and greater. Marking is prohibited for gold coverings of less than 5 μm thickness. The maker's mark or the mark of responsibility shall apply to all coverings.

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