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CCS A29



**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB/T 12611-2008

Replacing GB/T 12611-1990

**Technical requirements of quality control for metal parts to be
coated**

金属零（部）件镀覆前质量控制技术要求

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Quarantine of the People's Republic of China;
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Foreword

This standard is GB/T 12611-1990 "metal zero (portion) member coated front quality control technology requirements," the amendment. This standard replaces GB/T 12611-1990 "metal zero (the Department) of coated technical requirements of quality control." This standard compared with GB/T 12611-1990, the main changes are as follows:

- According to GB/T 1.1-2000 requirements, increasing the preamble;
- Increasing the normative references;
- Increasing the terms and definitions section;
- Increased before plating quality control data portion of the file;
- Revised before plating quality control requirements specified factors. The standard proposed by China Machinery Industry Federation. This standard layer Standardization Committee (SAC/TC57) administered by the National Metal and non-metal cover. This standard was drafted. Wuhan Institute of Materials Protection. The main drafters of this standard. new JIA Jian, Mao Zuguo, De-Zhong Zhang, He Jie, Tang Chi Day. This standard replaces the standards previously issued as follows:
 - GB/T 12611-1990. Metal zero (the Department) of coating before plating Quality Control Requirements

1 Scope

GB/T 12611-2008 is the Chinese national standard on technical requirements of quality control for metal parts to be coated, in the field of manufacturing engineering. The /T suffix marks it as a recommended standard: it is not compulsory by itself, but it becomes binding as soon as a contract, a tender or a customer specification calls it up - which in practice is how most foreign buyers meet it. It was issued on 1 July 2008 by the General Administration of Quality Supervision, Inspection and Quarantine of the People's Republic of China; Standardization Administration of China, and has been in force since 1 February 2009. Classification: ICS 25.220.40, CCS A29. This page is published from the official record of the standard held by the Chinese standards administration: the identification, the

dates, the classification and the issuing body are taken from there. The clause text, the tables and the numeric limits are in the document itself, which is delivered complete in English translation.

This standard specifies the metal zero (the Department of) the technical requirements of member coated front quality control. This standard applies in electroplating, electroless plating, chemical passivation, chemical oxidation, electrochemical oxidation and quality coated metal member before the other zero (portion) Control and acceptance.

2 Normative references

The following documents contain provisions which, through reference in this standard and become the standard terms. For dated references, subsequent Amendments (not including errata content) or revisions do not apply to this standard, however, encourage the parties to the agreement are based on research Whether the latest versions of these documents. For undated reference documents, the latest versions apply to this standard.

GB/T 197 common thread tolerance (GB/T 197-2003, ISO 965-1.1998, MOD)

GB/T 1172 ferrous metal hardness and strength conversion value

GB/T 3138 metal plating and chemical treatment and related process (GB/T 3138-1995, neq ISO 2079. 1981)

GB/T 5267.1 fasteners plating layer (GB/T 5267.1-2002,

ISO 4092.1999, IDT) Review of Test Methods metal cladding layer deposition and chemical deposition layer adhesion strength

GB/T 5270 on the metal substrate (GB/T 5270-2005, ISO 2819. 1980, IDT)

GB/T 6463 Metallic and other inorganic coatings - Review of thickness measurement method (GB/T 6463-2005, ISO 3882.2003, IDT)

GB/T 12609 Electrodeposited metallic coatings and related finishes - Sampling procedures for inspection (GB/T 12609-2005, ISO 4519. 1980, IDT)

GB/T 13911 metal plating and chemical treatment methods of identification

GB/T 17720 Metallic coatings - Review of porosity tests (GB/T 17720-1999, eqv ISO 10308.1995)

GB/T 20015 Metallic and other inorganic coatings electroplated nickel, autocatalytic nickel, chrome plating and final finishing Automated Controlled Shot Hardening pre-treatment (GB/T 20015-2005, ISO 12686.1999, MOD)

3 Terms and Definitions

Terms and definitions GB/T 3138 established apply to this standard. 4 metal zero (the Department) of data before plating plating shall obtain

4.1 necessary information Plated metal parts before coating, plating shall by contract or subscription contract, or to obtain the following information in writing on the drawing sheet.

- a) plating layer identification (see GB/T 13911);
- b) to be plated main surface of the sample should be marked on the workpiece drawing, there may also be appropriately labeled sample description;
- c) plating layer may be allowable defect type, size and number of requirements (see Chapter 5); Appearance and surface
- d) defects in metal parts processing requirements, such as mechanical grinding, chemical polishing leveling, leveling electrochemical polishing degree; It can also be provided by or approved by the required sample to show the appearance of metal parts and processing required for comparison;
- e) The minimum thickness of plating thickness measurement and test methods (see GB/T 6463) cladding; Requirements and Test Methods
- f) metal parts plating layer adhesion and porosity (see GB/T 5270 and GB/T 17720);