

ICS 20.220.10; 25.220.40
CCS A 29



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

GB/T 34626.2-2017

**Metallic and other inorganic coatings -- Cleaning and
preparation of metal surfaces -- Part 2: Non-ferrous metal and
alloys**

金属及其他无机覆盖层 金属表面的清洗和准备 第2部分：有色金属及其合金
(English Translation)

Issued on: September 29, 2017

Implemented on: April 1, 2018

**Issued by: General Administration of Quality Supervision, Inspection and
Quarantine of the People's Republic of China, Standardization
Administration of the People's Republic of China**

Table of Contents

Foreword V.	
Introduction	
1 Scope	
2 Normative references	
3 Terms and definitions	
4 The buyer should provide the necessary information to the processor	
5 Requirements	
6 Standard cleaning method	
7 Non-corrosion-resistant steel, cast iron and pure iron	
8 Corrosion-resistant steel and heat-resistant steel	
9 Powder coating before the metal pre-treatment	
10 Cleaning and preparation process	
11 Aluminum and aluminum alloy	
11.1 Overview	
11.2 Conventional degreasing and cleaning	
11.3 Removal of corrosion products	
11.4 Preparation before anodization	
11.5 To remove oxide or film preparation before processing	
11.6 Non-anodized workpiece preparation before bonding	
11.7 Preparation before plating	
11.8 Electroless Nickel Preparation	
11.9 Preparation before conversion film	
11.10 Metal Preparation before spraying	
11.11 Preparation of glaze porcelain before coating	
11.12 Preparation of Physical Vapor Deposition Aluminum Auxiliary Treatment	
12 Copper and copper alloy	
12.1 Conventional Degreasing and Cleaning	
12.2 Preparation before plating	
12.3 Electroless Nickel Preparation	
12.4 Hot Tinning (TRI Treatment) [2] Before Preparation	
12.5 Glassy tin before preparation	
13 Nickel alloy	

- 13.1 Conventional degreasing and cleaning
- 13.2 Preparation before plating
- 13.3 Electroless Nickel Preparation
- 13.4 Glaze porcelain preparation before coating
- 14 Titanium and titanium alloy
 - 14.1 Conventional Degreasing and Cleaning
 - 14.2 Preparation before plating
 - 14.3 Electroless nickel preparation before plating
- 15 Manganese alloy
 - 15.1 Conventional Degreasing and Cleaning Before Plating and Conversion
 - 15.2 Preparation before plating
 - 15.3 Preparing for Conversion
- 16 Zinc alloy
 - 16.1 Conventional degreasing and cleaning
 - 16.2 Corrosion parts cleaning
 - 16.3 Preparation of zinc alloy die-casting before plating
 - 16.4 Preparation of zinc alloy castings before chromium conversion or phosphating
- 17 Tin and tin alloy
- 18 Tungsten alloy
 - 18.1 Preparation before plating
 - 18.2 Preparation before bonding
- 19 Lead and lead alloy

Foreword

GB/T 34626 "metal and other inorganic coating surface cleaning and preparation" is divided into two parts.

--- Part 1. Steel and its alloys;

--- Part 2. Non-ferrous metals and their alloys.

This section GB/T 34626 Part 2.

This section drafted in accordance with GB/T 1.1-2009 given rules.

This section uses redrafted law revision using ISO 27831-2:2008 "Metal and other inorganic surface coating metal cleaning and Prepare part 2. Non-ferrous metals and their alloys. "

this section compared with ISO 27831-2:2008, the main differences and the reasons are as

follows.

--- On normative references, this standard made a technical difference with the adjustment to adapt to China's technical conditions, adjust the situation Concentration reflected in the second chapter "Normative references", the specific adjustments are as follows.

Replace ISO 2080 with GB/T 3138 equivalent to international standards (see Chapter 3);

Replace ISO 2064 with GB/T 12334 equivalent to international standards (see Chapter 3);

Use GB/T 13913 equivalent to international standards instead of ISO 4527 (see 11.8);

Use equivalent to international standards GB/T 19349 instead of ISO 9587 (see 7.1.2);

Use GB/T 19350 equivalent to the international standard instead of ISO 9588 (see 20.1);

Replace ISO 10074 with GB/T 19822 equivalent to international standards (see 11.4);

Use equivalent to international standards GB/T 31566 instead of ISO (see 11.12);

GB/T 34626-1.2017 modified to adopt international standards instead of ISO 27831-1:2008.

This part is proposed by China Machinery Industry Federation.

This part of the National Metal and Nonmetallic Coating Standardization Technical Committee (SAC/TC57) centralized.

This part of the drafting unit. Wuhan Institute of Materials Protection, COSCO rare earth New Materials Co., Ltd., Zhaoqing College, Guangzhou City, VW five Gold Co., Ltd., Shandong Taifeng Cleaning Technology Co., Ltd., Dongying Yellow River Delta Standard Technical Service Center, Shenzhen Green constant low-carbon development Promotion Center.

Introduction

The adhesion of the coating depends on the effect of degreasing and cleaning of the substrate surface. For plating (coating), it is necessary to remove the manufacturing process the resulting grease, oil, dirt, or other forms of contaminants formed as a result of corrosion/erosion during storage and use to obtain a non-corrosive, clean, Chemically active surface.

Surface contaminants may be.

--- Steel and non-ferrous metal castings on the corrosion products, sand or mold release agent;

--- Corrosion products and scale (such as hot rolled steel, steel beams, etc.) (for the substrate, the crushed scale is the cathode);

--- Oil on the cold-rolled steel and rolling lubricant;

- Rolling aluminum rolling lubricant;
- Hot-dip galvanized steel, steel/bracket in the transport or storage process of corrosion products;
- Storage and handling of other pollutants generated in the process.

It is well known that plating/coating the surface of these materials is difficult.

There are many ways to remove surface contaminants, among other factors, depending on the type and level of pollutants the size and shape of the body, the cleanliness requirements, the availability of the necessary facilities, the cost of the treatment and its impact on the environment, Process characteristics.

GB/T 34626 listed cleaning methods, covering the mechanical method (this method to achieve the lowest degree of cleanliness), chemical and ultrasonic methods (to achieve relatively high cleanliness) and glow discharge plasma treatment (sputter cleaning) of the substrate before vapor deposition.

GB/T 34626 lists the coating (coated) with or without coating the coating layer, the metal and its alloys cleaning practical method.

The cleaning process given in GB/T 34626.1 and GB/T 34626.2 is only the most commonly practiced method in practice. However, many solutions do Square programs and special handling methods are not included in GB/T 34626.1 and GB/T 34626.2. This standard references these as much as possible Special treatment method For reference GB/T 34626 parts given in other treatment processes, refer to the standard parts of the reference Listed publications.

GB/T 34626.1 applies to steel and its alloys, and GB/T 34626.2 applies to non-ferrous metals and alloys. In order to make as much as possible GB/T 34626.2 as a separate standard document to use, GB/T 34626.1 chapters 1 to 6 are contained in GB/T 34626.2 , Also Chapter 1 to Chapter 6, other terms according to the order of GB/T 34626.1 numbering. In addition, some of GB/T 34626.1 for steel Material cleaning and preparation process can also be applied to non-ferrous metal materials, therefore, these cleaning and preparation process also according to GB/T 34626.1 Shun Sort and use the same name.

Metal and other inorganic coatings Cleaning and preparation of metal surfaces Part 2. Non-ferrous metals and their alloys Warning --- GB/T 34626 this part requires the use of some of the substances and processes, if you do not take appropriate measures, health products Health hazards. This section does not discuss any health hazards, safety or environmental issues and regulations involved in the use of the standard. Producer, buy Party and standard users are responsible for establishing appropriate health, safety and environmental regulations and taking appropriate measures to bring them in line with national, local and /International regulations and rules. Compliance with this section does not imply a legal exemption.