

Hand out

Zirconium coating

Coating material: zirconium nitride

varies depending on base material

Zirconium on stainless steel

- Ultrasonic cleaning
- Individual quality inspection
- Vacuum sputtering with zirconium, thickness of layer 0.004mm

Zirconium on brass

- Ultrasonic cleaning
- Individual quality inspection
- Brass coating (Cupracid Ultra, thickness of layer 0.25mm)
- Nickel coating, thickness of layer 0.15-0.2mm
- Chrome coating, thickness of layer 0.15mm
- QC/cleaning
- Vacuum sputtering with zirconium, thickness of layer 0.004mm at 150-200°C

Zirconium on Zamac

- Ultrasonic cleaning
- Individual quality inspection
- Brass coating (Copper Lume, SuperPyrobite, Cupracid Ultra, thickness of layer 0.25-0.3mm)
- Nickel coating, thickness of layer 0.15-0.2mm
- Chrome coating, thickness of layer 0.15mm
- QC/cleaning
- Vacuum sputtering with zirconium, thickness of layer 0.004mm at 120-150°C

Tests

Heat test: 150°C/30min

Art welding according to ISO 3160

Abrasion: according to ISO 3160

Salt spray test (NSS): 120 hours

Tack according to ASTM D3359-79

Hardness: HB1000-HB1200