

Form No.: BEL-840-2 Revision: B Form Rev Date: 4/27/18 Form Created: 1/14/18	Record No: BEL-840-2-ASTM B633 Revision: D Record Rev Date: 3/16/2020 Record Created: 5/8/18	
Document Title: ASTM-B633 - Zinc Plating Purchase Order Supplemental		
Approval: CMCB		
Rev	Date	Rev description
A	5/8/18	Record Established
B	11/6/2018	Removed finish type, thickness class, luster; added purchase order information; reporting requirements; removed footer; added requirements for plating thickness inspection; notch bars and packaging; removed standards from header
C	10/24/2019	Measurement technique to B659 or B568 ONLY; updated HE testing requirements
D	3/16/2020	Updated plating thickness inspection requirements to be applicable to all components and follow drawing

PURCHASE ORDER INFORMATION

Process per attached print for class and type.
Lot traceability must be maintained.

REPORTING REQUIREMENTS

PROCESS CERTIFICATION

INSPECTION REPORT (MIL SPEC YOKES AND DERIVATIVES)

Inspection frequency – per ASTM B633 or four samples; whichever sample size is greater.

Measurement Technique – ASTM B568 or B659

Supplier HE Testing – Applicable periodic hydrogen embrittlement test report to be provided with order

NON-DESTRUCTIVE TESTING – as specified on drawing

PRE-PLATING HYDROGEN EMBRITTLEMENT RELIEF TREATMENT – For HRc 31 and above (including fatigue-proof steel)

POST-PLATING HYDROGEN EMBRITTLEMENT RELIEF TREATMENT

For HRc 31 and above (including fatigue-proof steel): 401°F +/-27°F for 44 hr minimum

CORROSION RESISTANCE TEST – as specified on drawing

SUPPLIER-PROVIDED NOTCH BARS – as specified on purchase order

ASTM F519. Certification must include the certificate of manufacture for notch bars, hydrogen embrittlement test report and supplier's job number on all cert pack documents. Notch Bars also need to be traceable to the certification and test report.

In instances of failed hydrogen embrittlement tests, the supplier shall be liable for rework (stripping and re-plating) and expediting costs.

BELDEN-PROVIDED NOTCH BARS

Belden will provide notch bars. Supplier shall ensure the threads are masked and plated notch bars are individually packaged to preserve their integrity during transportation. Refer to Belden's website for details at www.beldenuniversal.com/about/suppliers

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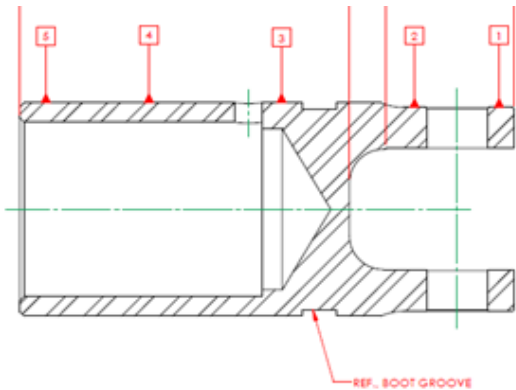


In instances of failed hydrogen embrittlement tests, the supplier shall be liable for rework (stripping and re-plating) and expediting costs.

THICKNESS INSPECTION REPORT –

- a. For MIL spec yokes and derivatives, plating thickness to be measured in locations 3, 4, and 5. Average thickness will not be acceptable. Any thickness reading outside of drawing requirements shall be cause for rejection. Refer to Belden’s website for details at www.beldenuniversal.com/about/suppliers

Contact Belden if part geometry prohibits plating thickness inspection when required.



- b. For pins and blocks, measure plating thickness on applicable surfaces

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PLATING APPEARANCE

Acceptable plating appearance in accordance with ASTM B633.

PACKAGING AND HANDLING

Plated parts must be returned to Belden packaged in such a manner that protects the integrity of the plating.