Aerospace series - Electrolytic silver plating of fasteners

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EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

Käesolev Eesti standard EVS-EN 2786:2008 sisaldab Euroopa standardi EN 2786:2008 ingliskeelset teksti.	This Estonian standard EVS-EN 2786:2008 consists of the English text of the European standard EN 2786:2008.
Standard on kinnitatud Eesti Standardikeskuse 19.05.2008 käskkirjaga ja jõustub sellekohase teate avaldamisel EVS Teatajas.	This standard is ratified with the order of Estonian Centre for Standardisation dated 19.05.2008 and is endorsed with the notification published in the official bulletin of the Estonian national standardisation organisation.
Euroopa standardimisorganisatsioonide poolt rahvuslikele liikmetele Euroopa standardi teksti kättesaadavaks tegemise kuupäev on 26.03.2008.	Date of Availability of the European standard text 26.03.2008.
Standard on kättesaadav Eesti standardiorganisatsioonist.	The standard is available from Estonian standardisation organisation.

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EUROPEAN STANDARD

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EUROPÄISCHE NORM

EN 2786

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English Version

Aerospace series - Electrolytic silver plating of fasteners

Série aérospatiale - Argentage électrolytique des éléments de fixation

Luft- und Raumfahrt - Elektrolytisches Versilbern von Verbindungselementen

This European Standard was approved by CEN on 12 December 2007.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN Management Centre has the same status as the official versions.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

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Foreword

This document (EN 2786:2008) has been prepared by the Aerospace and Defence Industries Association of Europe - Standardization (ASD-STAN).

After enquiries and votes carried out in accordance with the rules of this Association, this Standard has received the approval of the National Associations and the Official Services of the member countries of ASD, prior to its presentation to CEN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by September 2008, and conflicting national standards shall be withdrawn at the latest by September 2008.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN [and/or CENELEC] shall not be held responsible for identifying any or all such patent rights.

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1 Scope

This standard specifies the electrolytic silver plating of fasteners used in aerospace applications.

It shall apply whenever referenced.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 2828, *Aerospace series — Adhesion test for metallic coatings by burnishing.*

EN 2830, *Aerospace series — Adhesion test for metallic coatings by shearing action.*

EN 2831, *Aerospace series — Hydrogen embrittlement of steels — Test by slow bending.*

EN 2832, *Aerospace series — Hydrogen embrittlement of steels — Notched specimen test.*

EN 9100, *Aerospace series — Quality management systems — Requirements (based on ISO 9001:2000) and Quality systems — Model for quality assurance in design, development, production, installation and servicing (based on ISO 9001:1994).*

3 Purpose of process

To prevent galling or seizure.

4 Technical requirement

4.1 Preparation

Parts shall have chemically and/or electrolytically clean surfaces prepared with minimum abrasion, erosion or pitting, prior to immersion in the plating solution. Treatments which may produce hydrogen embrittlement shall be avoided.

After cleaning and prior to immersion in the plating solution, parts may be etched in a suitable solution such as ferric chloride and/or hydrochloric acid, to promote adhesion.

Electrical contact between the parts and the power source shall be established in such a manner as to ensure that neither chemical/immersion deposition nor electrical arcing or overheating will occur.

4.2 Procedure

The parts shall be silver plated over a suitable nickel and/or silver strike by an approved method to the thickness quoted in the product standard or in the definition document.

The plated parts shall be removed from the plating solution then thoroughly rinsed and dried.