

CONTENTS

CHAPTER 1 INTRODUCTION	1
1.1 INTRODUCTION	1
CHAPTER 2 WEAR AND FRICTION PROPERTIES OF SURFACES	7
2.1 INTRODUCTION	7
2.2 ABRASIVE WEAR	9
2.2.1 LOW-STRESS SCRATCHING ABRASION	10
2.2.2 HIGH-STRESS GRINDING ABRASION	11
2.2.3 GOUGING ABRASION	12
2.3 ADHESIVE WEAR	12
2.4 CASE STUDY: SOLID LUBRICANTS AND TRIBOLOGICAL CHARACTERISATION HEREOF	16
2.4.1 BLOCK-ON-RING TEST FOR SOLID LUBRICANTS	17
2.4.2 FALEX PIN AND VEE BLOCK TEST FOR SOLID LUBRICANTS	19
2.5 FATIGUE WEAR	21
2.6 CORROSIVE WEAR	22
2.6.1 CASE STUDY: FRETTING	23
2.7 EROSION WEAR	27
2.8 REFERENCES	33
2.9 RECOMMENDED ADDITIONAL READING	33
2.10 RELEVANT STANDARDS	33
CHAPTER 3 INTRODUCTION TO CORROSION	37
3.1 INTRODUCTION	37
3.2 THE POURBAIX DIAGRAM	48
3.3 STRATEGIES FOR CORROSION PROTECTION	52
3.3.1 CONVERSION COATINGS AS CORROSION PROTECTION	52
3.3.2 ADDITIONAL CORROSION PROTECTION STRATEGIES	55
3.4 TYPICAL APPEARANCE OF SURFACE CORROSION	56
3.4.1 UNIFORM CORROSION	57
3.4.2 GALVANIC CORROSION	61
3.4.3 CREVICE OR DEPOSIT CORROSION	63
3.4.4 FRETTING CORROSION	68
3.5 RECOMMENDED ADDITIONAL READING	69

CHAPTER 4 BASIC ELECTROCHEMISTRY FOR SURFACE MODIFICATIONS	71
4.1 INTRODUCTION	71
4.2 BASIC ELECTROLYTIC PROCESSES	72
4.2.1 HYDRATION OF THE METAL ION	72
4.2.2 DISSOCIATION OF THE SOLUTION	73
4.2.3 INTERACTION BETWEEN DIFFERENT IONS	73
4.3 THE LAW OF FARADAY	79
4.4 THE ELECTROCHEMICAL DOUBLE LAYER	80
4.5 ACTIVATION OVERPOTENTIAL	83
4.6 CONCENTRATION OVERPOTENTIAL	90
4.7 CRYSTALLIZATION OVERPOTENTIAL	94
4.8 THE OHMIC RESISTANCE OF AN ELECTROLYTE	97
4.9 OTHER RELEVANT FACTORS	97
4.10 ADDITIVES FOR ELECTROPLATING	98
4.11 REFERENCES	102
4.12 RECOMMENDED ADDITIONAL READING	102
CHAPTER 5 INTRO. TO CHEMICAL AND ELECTROCHEMICAL PROCESSES	105
5.1 INTRODUCTION	105
5.1.1 CHEMICAL/ELECTROCHEMICAL PLATING	105
5.1.2 CONVERSION COATINGS	106
5.1.3 CHEMICAL/ELECTROCHEMICAL POLISHING	106
5.2 ELECTROCHEMICAL PLATING OF METALS	107
5.2.1 ELECTROLYTIC PLATING	107
5.2.2 ELECTROLESS PLATING	115
5.3 ELECTROPLATABLE SUBSTRATES	118
5.4 PRETREATMENT PROCESSES	120
5.4.1 REMOVING OIL, GREASE AND DIRT	120
5.4.2 IMPORTANT FACTORS IN THE CLEANING PROCESS	124
5.4.3 REMOVAL OF OXIDES	126
5.4.4 ELECTROCLEANING	131
5.4.5 ACTIVATION	133
5.4.6 PRETREATMENT OF AL, CU, CU-ALLOYS AND STRONG OXYGEN GETTERS	134
5.5 PLATING OF NON-CONDUCTIVE MATERIALS	140
5.5.1 MOLDED INTERCONNECT DEVICES	144
5.6 REFERENCES	147

CHAPTER 6 GUIDELINES FOR ELECTRO-CHEMICAL DEPOSITION	149
6.1 INTRODUCTION	149
6.2 MATERIAL DISTRIBUTION AND GEOMETRY	149
6.2.1 TYPES OF OVERPOTENTIAL (POLARIZATION TYPES)	149
6.2.2 OPTIMIZING MATERIAL DISTRIBUTION	151
6.2.3 CURRENT EFFICIENCY	152
6.2.4 ELECTROPLATING IN PRACTICE	156
6.3 CONTINUOUS PLATING	162
6.3.1 COIL COATING	162
6.3.2 REEL-TO-REEL PLATING	163
6.4 BRUSH PLATING	167
6.5 ENVIRONMENTAL REQUIREMENTS	169
CHAPTER 7 ELECTROLYTIC PLATING OF ZINC	173
7.1 INTRODUCTION	173
7.2 CORROSION OF ZINC	175
7.3 PROCESSES FOR ELECTROPLATING PURE ZINC	177
7.3.1 CYANIDE-BASED ELECTROLYTES	177
7.3.2 THE ALKALINE, CYANIDE-FREE ZINC ELECTROLYTE	182
7.3.3 ACID ZINC ELECTROLYTES	186
7.3.4 COMPARING THE DIFFERENT ZINC ELECTROLYTES	188
7.4 ALLOY ZINC PLATING	191
7.5 POST-TREATMENT OF ZINC	193
7.5.1 CLEAR AND BLUE CHROMATES (A AND B)	194
7.5.2 YELLOW CHROMATES (C)	194
7.5.3 OLIVE DRAB (D)	194
7.5.4 BLACK CHROMATES (E)	194
7.5.5 CHROMATE-FREE CONVERSION COATINGS	199
7.6 REFERENCES	202
7.7 RECOMMENDED ADDITIONAL READING	202
7.8 RELEVANT STANDARDS	202
CHAPTER 8 ELECTROLYTIC PLATING OF NICKEL	205
8.1 INTRODUCTION	205
8.1.1 THE DEVELOPMENT OF NICKEL PLATING	205
8.2 THE WATTS BATH	208
8.2.1 TECHNICAL ELECTROLYTES	209
8.2.2 SEMI-BRIGHT ELECTROLYTES	209
8.2.3 BRIGHT NICKEL ELECTROLYTES	212

8.3	SATIN NICKEL COATINGS	216
8.4	MECHANICAL PROPERTIES OF NICKEL COATINGS	219
8.4.1	ELECTROFORMING	220
8.5	REFERENCES	223
8.6	RECOMMENDED ADDITIONAL READING	224
8.7	RELEVANT STANDARDS	224
CHAPTER 9 ELECTROLYTIC PLATING OF COPPER		227
9.1	INTRODUCTION	227
9.2	THE PLATING PROCESS	227
9.3	COPPER PLATING APPLICATIONS	230
9.3.1	COPPER COATINGS ON Zn, Al AND Mg	231
9.3.2	COPPER PLATING FOR CONDUCTIVITY PURPOSES	231
9.3.3	COPPER PLATING FOR PRINTING ROLLS	232
9.3.4	ELECTROFORMING	235
9.3.5	COPPER PLATING AS PART OF PLATING ON POLYMERS	237
9.4	REFERENCES	240
9.5	RELEVANT STANDARDS	240
CHAPTER 10 ELECTROLYTIC PLATING OF TIN		243
10.1	INTRODUCTION	243
10.2	THE PLATING PROCESS	243
10.3	PROPERTIES OF TIN COATINGS	244
10.3.1	CORROSION PROPERTIES OF TIN	244
10.4	TIN WHISKERS	246
10.5	TIN SOLDERING	248
10.6	REFERENCES	252
10.7	RECOMMENDED ADDITIONAL READING	252
10.8	RELEVANT STANDARDS	253
CHAPTER 11 ELECTROLYTIC PLATING OF CHROMIUM		255
11.1	INTRODUCTION	255
11.2	THE CHROMIUM PLATING PROCESS	257
11.3	BRIGHT AND HARD CHROMIUM PLATING	258
11.3.1	CURRENT EFFICIENCY	260

11.3.2 CHARACTERISTIC COATING CRACKS	262
11.3.3 PROPERTIES OF HARD CHROMIUM	263
11.3.4 ALTERNATIVES TO HEXAVALENT CHROMIUM	268
11.4 REFERENCES	270
11.5 RECOMMENDED ADDITIONAL READING	270
 CHAPTER 12 ELECTROLYTIC PLATING OF PRECIOUS METALS	273
12.1 INTRODUCTION	273
12.2 SILVER	274
12.2.1 THE SILVER PLATING PROCESS	277
12.2.2 PROPERTIES OF SILVER	279
12.2.3 SILVER MIGRATION	280
12.3 GOLD	282
12.3.1 THE GOLD PLATING PROCESS	282
12.4 OTHER PRECIOUS METALS	292
12.4.1 PALLADIUM	292
12.4.2 RHODIUM	293
12.4.3 PLATINUM	294
12.4.4 RUTHENIUM	296
12.4.5 OSMIUM	296
12.4.6 IRIDIUM	296
12.4.7 RHENIUM	296
12.5 REFERENCES	297
12.6 RECOMMENDED ADDITIONAL READING	297
12.7 RELEVANT STANDARDS	297
 CHAPTER 13 ELECTROLYTIC PLATING OF ALLOYS	299
13.1 INTRODUCTION	299
13.2 BASIC THEORY BEHIND ALLOY PLATING	300
13.3 GROUPING BINARY ALLOYS	306
13.4 COMMERCIALLY APPLIED ALLOYS	308
13.4.1 LEAD/TIN ALLOY PLATING	308
13.4.2 NICKEL/PHOSPHORUS ALLOY PLATING	308
13.4.3 NICKEL/TUNGSTEN ALLOY PLATING	309
13.4.4 TIN/ZINC ALLOY PLATING	310
13.4.5 COPPER/TIN ALLOY PLATING	310
13.4.6 NICKEL/TIN ALLOY PLATING	311
13.4.7 COPPER/ZINC ALLOY PLATING	313
13.4.8 NICKEL/IRON ALLOY PLATING	314

13.4.9 ZINC/NICKEL ALLOY PLATING	314
13.4.10 COBALT/ZINC ALLOY PLATING	314
13.5 REFERENCES	314
13.6 RELEVANT STANDARDS	316
 CHAPTER 14 ELECTROLESS PLATING OF METALS	319
14.1 INTRODUCTION	319
14.2 AUTOCATALYTIC (ELECTROLESS) COPPER PLATING	322
14.3 AUTOCATALYTIC (ELECTROLESS) NICKEL PLATING	324
14.3.1 PROCESSES INVOLVING HYPOPHOSPHITE	324
14.3.2 PROCESSES INVOLVING BORON AND HYDRAZINE	328
14.3.3 CONDUCTING THE AUTOCATALYTIC NICKEL PROCESS	328
14.3.4 HARDENING OF AUTOCATALYTIC NICKEL COATINGS	330
14.3.5 SELECTION OF AUTOCATALYTIC NICKEL	331
14.3.6 STRESS IN AUTOCATALYTIC NICKEL COATINGS	333
14.3.7 ELECTRIC AND MAGNETIC PROPERTIES	335
14.3.8 WELDING AND SOLDERING	338
14.4 DISPERSION PLATING	340
14.5 OTHER ELECTROLESS PLATING PROCESSES	345
14.5.1 ELECTROLESS PLATING OF GOLD	345
14.5.2 ELECTROLESS PLATING OF SILVER	347
14.5.3 AUTOCATALYTIC (ELECTROLESS) PLATING OF PALLADIUM	349
14.5.4 ION EXCHANGE PLATING OF TIN	350
14.5.5 ION EXCHANGE (ELECTROLESS) PLATING OF BRONZE	352
14.6 REFERENCES	353
14.7 RELEVANT STANDARDS	353
 CHAPTER 15 CHEMICAL AND ELECTROCHEMICAL POLISHING	355
15.1 INTRODUCTION	355
15.2 METALS SUITABLE FOR POLISHING	356
15.3 THE MECHANISM OF ELECTROPOLISHING	357
15.3.1 CURRENT/POLARIZATION CONDITIONS DURING POLISHING	358
15.3.2 OXYGEN DEVELOPMENT DURING ELECTROPOLISHING	360
15.3.3 ELECTROPOLISHING STAINLESS STEEL	361
15.3.4 ELECTROPOLISHING OF WELDINGS	363
15.3.5 ADDITIONAL APPLICATIONS FOR ELECTROPOLISHING	364
15.4 CHEMICAL POLISHING	366
15.5 REFERENCES	368

CHAPTER 16 CONVERSION COATINGS	371
16.1 INTRODUCTION	371
16.2 ANODIZING OF ALUMINUM	372
16.2.1 AREAS OF APPLICATION	379
16.2.2 THE BASE MATERIAL	380
16.2.3 THE ANODIZING PROCESS	386
16.2.4 COLORING OF ANODIZED ALUMINUM	389
16.3 SPECIAL PROCESSES	395
16.3.1 HARD ANODIZING	395
16.3.2 CHROME ACID ANODIZING	399
16.3.3 PLASMA ELECTROLYTIC OXIDATION	400
16.4 INTERFERENCE COLORS FROM OXIDE GROWTH	405
16.4.1 INTERFERENCE COLORS ON TITANIUM	405
16.4.2 INTERFERENCE COLORS ON STAINLESS STEEL	408
16.4.3 FUNDAMENTAL MECHANISM OF THIN-FILM INTERFERENCE	412
16.5 CHEMICAL CONVERSION COATINGS	414
16.5.1 CHROMATING OF ALUMINUM	415
16.5.2 PHOSPHATING OF STEEL	426
16.6 REFERENCES	433
16.7 RECOMMENDED ADDITIONAL READING	434
16.8 RELEVANT STANDARDS	434
CHAPTER 17 INTRODUCTION TO GAS-PHASE AND PLASMA PROCESSES	437
17.1 INTRODUCTION	437
17.2 PLASMA PROCESSES	442
17.2.1 PARTICLE ENERGIES AND TEMPERATURES	444
17.2.2 THE MEAN FREE PATH BETWEEN COLLISIONS	445
17.2.3 INTERACTION BETWEEN ELECTRON AND MOLECULES	445
17.2.4 THE SHIELDING EFFECT OF A PLASMA	448
17.2.5 INTERACTIONS BETWEEN A PLASMA AND THE SURROUNDINGS	449
17.3 DC-PLASMA	450
17.3.1 A SIMPLE EXAMPLE	450
17.3.2 A CLOSER LOOK AT THE DC-PLASMA	452
17.3.3 POWER SUPPLIES FOR DC-PLASMA	454
17.4 OTHER TYPES OF DIODE PLASMAS	455
17.5 OTHER PROCESSES	455
17.6 PLASMA CHARACTERIZATION	456
17.6.1 LANGMUIR-PROBE	456
17.6.2 OPTICAL EMISSION SPECTROSCOPY	456
17.7 REFERENCES	458

CHAPTER 18 PHYSICAL VAPOR DEPOSITION	461
18.1 INTRODUCTION	461
18.2 NON-REACTIVE PVD PROCESSES	462
18.2.1 EVAPORATION	462
18.2.2 SPUTTERING	469
18.2.3 DIFFERENT COMBINATION POSSIBILITIES FOR NON-REACTIVE PVD PROCESSES	474
18.3 REACTIVE PVD PROCESSES	475
18.3.1 DIFFERENT COMBINATION POSSIBILITIES FOR REACTIVE PVD PROCESSES	475
18.3.2 REACTIVE EVAPORATION	475
18.3.3 REACTIVE SPUTTERING PROCESSES	478
18.4 STRUCTURAL MODELS FOR VACUUM-BASED COATINGS	481
18.5 THE QUALITY OF THE DEPOSITED COATING	483
18.6 REFERENCES	484
CHAPTER 19 CHEMICAL VAPOR DEPOSITION	487
19.1 INTRODUCTION	487
19.2 THERMAL CVD	488
19.2.1 QUALITATIVE DESCRIPTION OF A CVD PROCESS	488
19.2.2 KINETICS	493
19.2.3 THE STRUCTURE OF A CVD COATING	497
19.2.4 INTRODUCTION TO VARIOUS CVD REACTIONS	498
19.2.5 COMMON CVD REACTIONS	499
19.2.6 ELEMENTARY SUBREACTIONS—AN ILLUSTRATIVE EXAMPLE	500
19.2.7 CVD EQUIPMENT	501
19.2.8 PUMPS SUITABLE FOR CVD	503
19.2.9 PRESSURE GAUGES SUITABLE FOR CVD	504
19.3 PLASMA-ACTIVATED CVD	504
19.3.1 THE BASIC PRINCIPLE OF PACVD	505
19.3.2 AREAS OF APPLICATION FOR THE PACVD PROCESS	507
19.4 REFERENCES	507
19.5 RECOMMENDED ADDITIONAL READING	507
CHAPTER 20 INDUSTRIAL PVD AND CVD PROCESSES	509
20.1 INTRODUCTION	509
20.2 COATINGS ON METALS AND HARD METALS	509
20.3 CONSIDERATIONS PRIOR TO COATING	511
20.4 COMMERCIAL PVD AND CVD COATINGS	513
20.5 COMMERCIAL COATINGS BASED ON PVD AND CVD	518

20.5.1 GAS NITRIDING	519
20.5.2 OVERVIEW OF SOME PVD/CVD COATINGS	519
20.5.3 DIAMOND AND DIAMOND-LIKE CARBON COATINGS	528
20.5.4 MULTIPHASE SYSTEMS	534
20.6 CVD OF PARYLENE	535
20.7 ATOMIC LAYER DEPOSITION	537
20.8 PVD COATINGS FOR DECORATIVE APPLICATIONS	538
20.9 REFERENCES	541
20.10 RECOMMENDED ADDITIONAL READING	541
20.11 RELEVANT STANDARDS	541
CHAPTER 21 ION BEAM PROCESSES	543
21.1 INTRODUCTION	543
21.2 THE KAUFMAN ION SOURCE	545
21.3 SPUTTER CLEANING (ION ETCHING)	546
21.4 DEPOSITION	547
21.4.1 SPUTTER DEPOSITION WITH ION BEAMS	547
21.4.2 ION DEPOSITION	548
21.4.3 ION BEAM ASSISTED DEPOSITION	549
21.5 ION IMPLANTATION	550
21.5.1 THE EFFECT OF IMPLANTATION	553
21.5.2 EQUIPMENT FOR ION BEAM IMPLANTATION	554
21.5.3 ADVANTAGES AND LIMITATIONS	558
21.5.4 TYPICAL APPLICATIONS	558
21.6 REFERENCES	560
INDEX	563
THE AUTHORS	577

CONTENTS

CHAPTER 22 THERMO-CHEMICAL DIFFUSION PROCESSES	579
22.1 INTRODUCTION	579
22.2 DIFFUSION PROCESSES	579
22.2.1 LATTICE DIFFUSION	580
22.2.2 THE RATE OF DIFFUSION AND DIFFUSION DEPTH	581
22.2.3 DIFFUSION REMEDY	583
22.3 CARBURIZING (DIFFUSION OF CARBON)	584
22.3.1 VACUUM CARBURIZING	591
22.4 CARBONITRIDING	591
22.5 NITRIDING	595
22.5.1 PLASMA NITRIDING	598
22.5.2 EXPANDED LATTICE S-PHASE	598
22.5.3 NITROCARBURIZING	600
22.6 BORONIZING (BORIDING)	602
22.6.1 BORONIZING PROCESSES	603
22.6.2 INFLUENCE OF THE SUBSTRATE MATERIAL	604
22.6.3 PROCESS PARAMETERS	605
22.6.4 PROPERTIES OF BORONIZED COMPONENTS	606
22.7 CHROMIZING	607
22.8 SHERARDIZING	608
22.9 DIFFUSION ANNEALING	609
22.10 THE TOYOTA DIFFUSION PROCESS	612
22.11 INDUCTION HARDENING	614
22.12 RECOMMENDED ADDITIONAL READING	617
22.13 RELEVANT STANDARDS	617
CHAPTER 23 HOT DIP GALVANIZING	621
23.1 INTRODUCTION	621
23.2 REGULAR HOT DIP GALVANIZING	622
23.2.1 DRY GALVANIZING	622
23.2.2 WET GALVANIZING	624
23.3 GALVANIZING OF SHEETS	625
23.4 REACTIONS BETWEEN IRON AND ZINC	626
23.5 SIGNIFICANT PROCESS PARAMETERS	627

23.5.1 HOT ROLLED CONSTRUCTION STEELS	630
23.5.2 COLD ROLLED STEELS	631
23.5.3 OTHER STEEL TYPES	632
23.6 DECORATIVE COATINGS	633
23.7 THE PROPERTIES OF HOT DIP GALVANIZED STEEL	635
23.8 CONSTRUCTION CONSIDERATIONS	636
23.9 STANDARDS	639
23.10 REFERENCES	640
23.11 RECOMMENDED ADDITIONAL READING	641
23.12 RELEVANT STANDARDS	641
 CHAPTER 24 VITREOUS ENAMEL	 643
24.1 INTRODUCTION	643
24.2 PROPERTIES AND STRUCTURE	644
24.3 MANUFACTURING OF ENAMELLED PRODUCTS	649
24.3.1 APPLICATION OF ENAMEL	650
24.4 QUALITY SPECIFICATIONS AND TEST METHODS	651
24.5 RECOMMENDED ADDITIONAL READING	651
24.6 RELEVANT STANDARDS	651
 CHAPTER 25 THERMAL SPRAYING AND HARDFACING	 655
25.1 INTRODUCTION	655
25.2 DIFFERENT TYPES OF THERMAL SPRAYING	657
25.2.1 FLAME SPRAYING	658
25.2.2 ARC SPRAYING	659
25.2.3 DETONATION SPRAYING	660
25.2.4 HIGH VELOCITY OXYGEN FUEL SPRAYING	661
25.2.5 PLASMA SPRAYING	662
25.2.6 COLD SPRAYING	665
25.2.7 COMPARISON OF THERMAL SPRAYING PROCESSES	667
25.2.8 APPLICATION OF THERMAL SPRAYING	672
25.3 LASER FUSING	674
25.4 HARDFACING	676
25.5 REFERENCES	686
25.6 RECOMMENDED ADDITIONAL READING	686
25.7 RELEVANT STANDARDS	687

CHAPTER 26 MECHANICAL PLATING	689
26.1 INTRODUCTION	689
26.2 THE PLATING PROCESS	690
26.2.1 MECHANICAL PLATING OF STEEL	691
26.3 REFERENCES	695
26.4 RECOMMENDED ADDITIONAL READING	695
26.5 RELEVANT STANDARDS	695
CHAPTER 27 INTRODUCTION TO PAINT	697
27.1 INTRODUCTION	697
27.1.1 KEY FACTORS FOR THE SUCCESSFUL USE OF PAINT	700
27.2 THE COMPONENTS OF PAINT	701
27.2.1 BINDERS	701
27.2.2 SOLVENTS	702
27.2.3 PIGMENTS	704
27.2.4 ADDITIVES	742
27.2.5 RHEOLOGY	743
27.3 PRODUCTION OF PAINT	744
27.4 REFERENCES	748
27.5 RECOMMENDED ADDITIONAL READING	749
27.6 RELEVANT STANDARDS	749
CHAPTER 28 CLASSIFICATION OF PAINTS	751
28.1 INTRODUCTION	751
28.2 PHYSICALLY DRYING PAINTS	753
28.2.1 GENERIC PROPERTIES OF PHYSICALLY DRYING PAINTS	753
28.2.2 TAR AND BITUMEN	754
28.2.3 CHLORINATED RUBBER	756
28.2.4 ACRYLIC	758
28.2.5 VINYL	759
28.2.6 NITROCELLULOSE	761
28.3 WATER-BORNE PAINTS	763
28.3.1 GENERIC PROPERTIES OF WATER-BORNE PAINTS	763
28.4 CHEMICALLY CURING PAINTS	766
28.4.1 GENERIC PROPERTIES OF CHEMICALLY CURING PAINTS	766
28.4.2 OXIDATIVELY CURING PAINTS	767
28.4.3 TWO-COMPONENT CURING PAINTS	772
28.4.4 HUMIDITY CURING PAINTS	779
28.4.5 HEAT CURING PAINTS	783

28.5 ALTERNATIVE CURING METHODS	787
28.5.1 ACID-CURING PAINTS	787
28.5.2 PEROXIDE-CURING PAINTS	787
28.5.3 UV-CURING PAINTS	787
28.6 REFERENCES	791
28.7 RECOMMENDED ADDITIONAL READING	791
28.8 RELEVANT STANDARDS	792
 CHAPTER 29 SPECIAL PAINTS AND APPLICATION METHODS	 795
29.1 INTRODUCTION	795
29.2 PAINT FOR CORROSION PREVENTION	795
29.2.1 THE BARRIER EFFECT	796
29.2.2 THE INHIBITING EFFECT	798
29.2.3 THE GALVANIC EFFECT (CATHODIC PROTECTION)	798
29.2.4 DIP-SPIN COATINGS	800
29.3 FOULING CONTROL PAINT	801
29.4 PASSIVE FIRE PROTECTION PAINT	806
29.5 SHOPPRIMERS	809
29.6 ELECTROCOATING PROCESSES	811
29.6.1 ANAPHORESIS	811
29.6.2 CATAPHORESIS	813
29.6.3 CHARACTERISTICS OF THE ELECTROCOATING PROCESS	814
29.6.4 PROCESS CONSIDERATIONS FOR ELECTROCOATING	815
29.7 AUTOPHORETIC LACQUERING PROCESSES	818
29.8 COIL-COATING PROCESSES	820
29.9 POWDER COATING PROCESSES	825
29.9.1 THERMOSETTING POWDER	828
29.9.2 THERMOPLASTIC POWDER	831
29.9.3 APPLICATION METHODS	831
29.10 REFERENCES	838
29.11 RECOMMENDED ADDITIONAL READING	838
 CHAPTER 30 PRETREATMENT PRIOR TO APPLICATION OF PAINT	 841
30.1 INTRODUCTION	841
30.1.1 SURFACE CONTAMINANTS	841
30.1.2 PRELIMINARY CLEANING METHODS	843
30.2 SANDBLASTING METHODS	843
30.2.1 VACUUM BLASTING	845

30.3 WET BLASTING METHODS	846
30.3.1 WATER CLEANING METHODS (WATER JETTING)	847
30.4 ABRASIVE MEDIA	850
30.5 STANDARDS	854
30.6 EVALUATION OF SURFACE ROUGHNESS	859
30.7 PREPARATION OF METAL SURFACES BEYOND STEEL	860
30.7.1 ALUMINUM	860
30.7.2 HOT DIP GALVANIZED STEEL	861
30.7.3 STAINLESS STEEL	861
30.8 PAINT ADHESION	862
30.8.1 SURFACE TENSION AND WETTING	862
30.8.2 ADHESION THEORIES	865
30.9 REFERENCES	867
30.10 RECOMMENDED ADDITIONAL READING	867
30.11 RELEVANT STANDARDS	868
CHAPTER 31 SELECTION OF PAINT SYSTEMS	871
31.1 INTRODUCTION	871
31.2 CORROSION CLASSES	873
31.3 PAINT SYSTEMS FOR CORROSION PROTECTION	875
31.3.1 CONVERSION COATINGS AS PRETREATMENT	880
31.4 TEST OF ORGANIC COATINGS	886
31.5 PAINT DEFECTS	887
31.6 RELEVANT STANDARDS	888
CHAPTER 32 MEASUREMENT OF »TOTAL VISUAL APPEARANCE«	893
32.1 INTRODUCTION	893
32.2 GLOSS	896
32.2.1 HAZE	901
32.3 COLOR	902
32.3.1 COLOR FORMATION	903
32.3.2 MIXING OF COLORS	905
32.4 REFERENCES	912
32.5 RECOMMENDED ADDITIONAL READING	912
32.6 RELEVANT STANDARDS	912

CHAPTER 33 QC; THICKNESS AND ADHESION OF COATINGS	915
33.1 INTRODUCTION	915
33.2 MEASURING THE THICKNESS OF COATINGS	916
33.2.1 WEIGHT GAIN UPON COATING	919
33.2.2 MECHANICAL MEASUREMENT	920
33.2.3 CHEMICAL MEASUREMENT	921
33.2.4 OPTICAL MEASUREMENT	921
33.2.5 ELECTROCHEMICAL MEASUREMENT	926
33.2.6 MAGNETIC MEASUREMENT	929
33.2.7 MAGNETIC-INDUCTIVE MEASUREMENT	930
33.2.8 EDDY-CURRENT MEASUREMENT	931
33.2.9 X-RAY FLUORESCENCE MEASUREMENT	933
33.2.10 BETA BACKSCATTER MEASUREMENT	936
33.2.11 ULTRASONIC MEASUREMENT	937
33.2.12 ELLIPSOMETRY	938
33.2.13 MEASUREMENT BEFORE CURING	939
33.3 QUANTIFYING COATING ADHESION	940
33.3.1 BENDING TEST	941
33.3.2 POLISHING TEST	943
33.3.3 CHISEL TEST	943
33.3.4 PULL TEST	943
33.3.5 FILE TEST	943
33.3.6 GRIND/SAW TEST	944
33.3.7 COOLING TEST	944
33.3.8 IMPACT/STROKE TEST	945
33.3.9 PEEL TEST	945
33.3.10 PUSH TEST	945
33.3.11 SCRIBE/GIRD TEST	945
33.3.12 SCRATCH TESTER	948
33.3.13 DAIMLER-BENZ TEST	949
33.4 RELEVANT STANDARDS	951
CHAPTER 34 MEASURING HARDNESS	955
34.1 INTRODUCTION	955
34.2 HARDNESS MEASUREMENT	955
34.2.1 MODELS FOR CORRELATING INDENTER AREA AND SURFACE HARDNESS	959
34.3 NANOINDENTATION	962

CHAPTER 35 CORROSION EVALUATION AND DURABILITY TESTING	965
35.1 INTRODUCTION	965
35.2 CORROSION AND DURABILITY TESTING	967
35.2.1 FIELD TESTING/WEATHERING	967
35.2.2 ACCELERATED LABORATORY TESTING	976
35.3 ADDITIONAL READING	996
35.4 RELEVANT STANDARDS	997
CHAPTER 36 CHARACTERIZATION OF SURFACES AND BULK MATERIALS	1001
36.1 INTRODUCTION	1001
36.2 THE INTERACTION OF ELECTRONS WITH MATTER	1003
36.3 THE INTERACTION OF PHOTONS WITH MATTER	1004
36.3.1 THE LOW ENERGY REGIME	1004
36.3.2 THE INTERMEDIATE ENERGY REGIME	1004
36.3.3 HIGH ENERGY REGIME	1005
36.4 OVERVIEW OF DIFFERENT ANALYSIS TECHNIQUES	1006
36.5 ELECTRON MICROSCOPES AND RELATED TECHNIQUES	1008
36.5.1 THE INTERACTION OF ELECTRONS WITH MATTER	1009
36.5.2 ELECTRON WAVE DUALISM	1012
36.5.3 INTRODUCTION TO SEM/TEM TECHNIQUES	1015
36.5.4 SCANNING ELECTRON MICROSCOPY	1018
36.5.5 SCANNING CONFOCAL ELECTRON MICROSCOPY	1021
36.5.6 REFLECTION ELECTRON MICROSCOPY	1023
36.5.7 SCANNING TRANSMISSION ELECTRON MICROSCOPY	1025
36.5.8 LOW-VOLTAGE ELECTRON MICROSCOPY	1026
36.5.9 ENVIRONMENTAL SCANNING ELECTRON MICROSCOPY	1026
36.5.10 CRYOGENIC-SEM	1028
36.5.11 FIB-SEM	1029
36.5.12 FIELD EMISSION GUN SCANNING ELECTRON MICROSCOPY	1032
36.5.13 TRANSMISSION ELECTRON MICROSCOPE	1033
36.6 ENERGY-DISPERSIVE X-RAY SPECTROSCOPY	1037
36.7 ELECTRON ENERGY LOSS SPECTROSCOPY	1040
36.8 X-RAY PHOTOELECTRON SPECTROSCOPY	1044
36.9 GLOW DISCHARGE OPTICAL EMISSION SPECTROSCOPY	1051
36.9.1 BASIC PRINCIPLE OF OPERATION	1051
36.9.2 EXAMPLES OF GDOES PROFILES	1053
36.10 SECONDARY ION MASS SPECTROSCOPY	1056
36.10.1 TIME-OF-FLIGHT SECONDARY ION MASS SPECTROMETRY	1058

36.11 X-RAY CHARACTERIZATION TECHNIQUES	1060
36.11.1 X-RAY DIFFRACTION	1061
36.11.2 X-RAY FLUORESCENCE	1068
36.12 SURFACE AND SUB-SURFACE ANALYSIS BASED ON HIGH ENERGY ION BEAM TECHNIQUES	1070
36.12.1 RUTHERFORD BACKSCATTERING SPECTROSCOPY	1074
36.12.2 PARTICLE INDUCED X-RAY EMISSION	1078
36.12.3 ELASTIC RECOIL DETECTION ANALYSIS	1083
36.12.4 NUCLEAR REACTION ANALYSIS	1084
36.13 SCANNING PROBE MICROSCOPY	1085
36.13.1 SCANNING TUNNELING MICROSCOPY	1086
36.13.2 ATOMIC FORCE MICROSCOPY	1093
36.14 SPECTROSCOPY	1099
36.14.1 ULTRAVIOLET-VISIBLE (UV-VIS) SPECTROSCOPY	1104
36.14.2 INFRARED SPECTROSCOPY (NEAR-IR, MID-IR AND FAR-IR)	1113
36.14.3 RAMAN	1127
36.14.4 ELLIPSOMETRY	1132
APPENDIX A THERMODYNAMIC CONSIDERATIONS	1139
A.1 INTRODUCTION	1139
A.2 ENTHALPY	1139
A.3 ENTROPY	1141
A.4 GIBB'S FREE ENERGY	1144
A.5 REFERENCES	1145
APPENDIX B REFERENCE DATA	1147
B.1 FUNDAMENTAL CONSTANTS	1147
B.2 ELECTROCHEMICAL EQUIVALENTS	1148
APPENDIX C POURBAIX DIAGRAMS	1155
C.1 DIAGRAMS	1164
C.2 REFERENCES	1187
INDEX	1189
THE AUTHORS	1205