



**NSAI**  
Standards

Irish Standard  
I.S. EN 2535:2011

# Aerospace series - Vacuum deposition of cadmium

## I.S. EN 2535:2011

*Incorporating amendments/corrigenda/National Annexes issued since publication:*

The National Standards Authority of Ireland (NSAI) produces the following categories of formal documents:

I.S. xxx: Irish Standard – national specification based on the consensus of an expert panel and subject to public consultation.

S.R. xxx: Standard Recommendation - recommendation based on the consensus of an expert panel and subject to public consultation.

SWIFT xxx: A rapidly developed recommendatory document based on the consensus of the participants of an NSAI workshop.

*This document replaces:*

*This document is based on:*  
EN 2535:2011

*Published:*  
5 July, 2011

This document was published  
under the authority of the NSAI  
and comes into effect on:  
5 July, 2011

ICS number:  
49.040

**NSAI**  
1 Swift Square,  
Northwood, Santry  
Dublin 9

T +353 1 807 3800  
F +353 1 807 3838  
E standards@nsai.ie  
W NSAI.ie

**Sales:**  
T +353 1 857 6730  
F +353 1 857 6729  
W standards.ie

Údarás um Chaighdeáin Náisiúnta na hÉireann

ICS 49.040

English Version

## Aerospace series - Vacuum deposition of cadmium

Série aérospatiale - Cadmiage sous vide

Luft- und Raumfahrt - Aufdampfen von Kadmium im  
Vakuum

This European Standard was approved by CEN on 12 February 2011.

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-CENELEC 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-CENELEC Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.



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

**Management Centre: Avenue Marnix 17, B-1000 Brussels**

## Contents

	Page
Foreword.....	4
1 Scope .....	5
2 Normative references .....	5
3 Purpose of process .....	5
4 Limitation of process use .....	5
5 Definitions .....	6
6 Thickness .....	6
7 Apparatus and materials.....	6
7.1 Vacuum enclosure .....	6
7.2 Deposition material.....	6
7.3 Masking material.....	6
8 Information for the processor .....	7
9 Condition of parts prior to processing.....	7
9.1 General.....	7
9.2 Stress relief treatment.....	7
10 Process schedule .....	7
11 Pre-treatment.....	8
11.1 Degreasing .....	8
11.2 Abrasive blasting .....	8
12 Treatment.....	8
12.1 Suspension and clamping of parts .....	8
12.2 Evacuation of the enclosure (primary vacuum) .....	8
12.3 Sputter cleaning.....	8
12.4 Deposition .....	8
12.5 Flooding, venting .....	9
12.6 Removal .....	9
13 Post-treatment.....	9
13.1 Chromating.....	9
13.2 Additional protection.....	9
14 Removal of the coating .....	9
14.1 Chemical process .....	9
14.2 Mechanical process.....	9
15 Required characteristics .....	10
15.1 Appearance .....	10
15.2 Thickness of the layer .....	10
15.3 Adhesion.....	10
15.4 Corrosion resistance.....	10
16 Inspection .....	10
16.1 Inspection of vacuum deposited parts and samples .....	10
16.1.1 Appearance .....	10
16.1.2 Inspection of the thickness of the coating.....	10
16.1.3 Adhesion test .....	10

	Page
<b>16.1.4 Corrosion test for steel.....</b>	<b>11</b>
<b>17 Quality assurance.....</b>	<b>11</b>
<b>17.1 Approval of the processor.....</b>	<b>11</b>
<b>17.2 Process approval.....</b>	<b>11</b>
<b>17.3 Acceptance .....</b>	<b>11</b>
<b>17.4 Reprocessing .....</b>	<b>12</b>
<b>18 Health, safety and environmental aspects.....</b>	<b>12</b>
<b>19 Designation .....</b>	<b>12</b>

## **Foreword**

This document (EN 2535:2011) 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 December 2011, and conflicting national standards shall be withdrawn at the latest by December 2011.

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.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and the United Kingdom.

This is a free preview. Purchase the entire publication at the link below:

[Product Page](#)

- 
- Looking for additional Standards? Visit Intertek Inform Infostore
  - Learn about LexConnect, All Jurisdictions, Standards referenced in Australian legislation
-