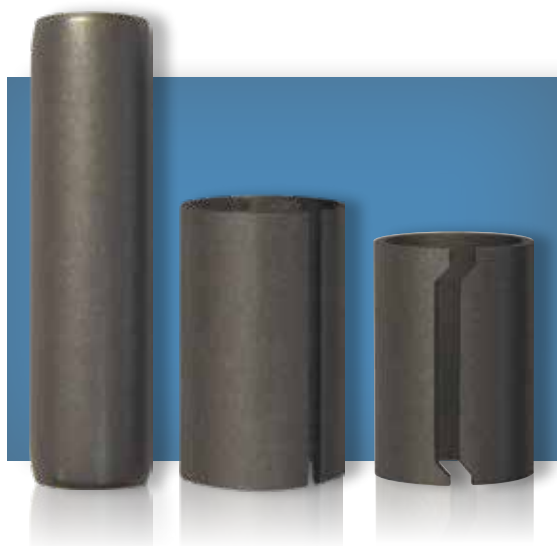


# SPIROL®

## WHITE PAPER

# Features and Benefits of ArmorGalv® Thermal Zinc Diffusion

by Michael J. Pasko, Applications Engineer  
SPIROL International Corporation



ArmorGalv® Thermal Diffusion

# 1,000+ HOURS

corrosion resistance

Thermal Diffused Zinc, a finishing process historically known as Sherardizing, has been used for corrosion protection of metal parts for over a century. Over the years, improvements have been made to the Sherardizing zinc/iron diffusion process. The modern, greatly improved process, known as **ArmorGalv®** is now being introduced as a standard finish for **SPIROL** products, and is poised to revolutionize the market. ArmorGalv® is anodic to steel and as such, provides long term sacrificial galvanic protection. Unlike traditional electroplating there is no risk of hydrogen embrittlement, adhesion is superior, coating thickness uniform, and all surfaces are covered. **There are no insignificant surfaces.** The affordability, durability, and low environmental impact of ArmorGalv® makes it ideal for today's market.

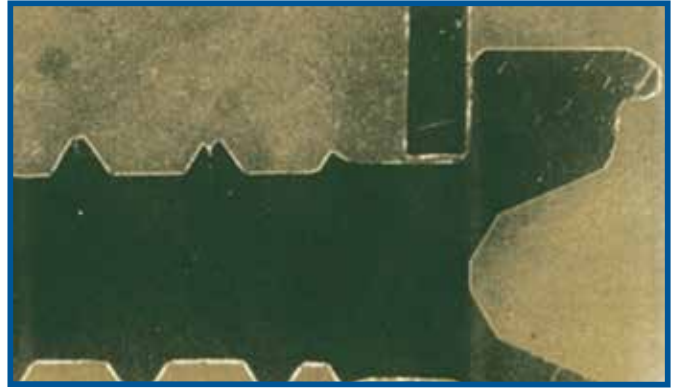
ArmorGalv® is a zinc alloy thermal diffusion coating, and is covered by ASTM A1059M-08(2013). This process requires a closed container, heated to a minimum 343°C (650°F), with a powdered zinc mixture. At this temperature sublimation of the zinc mixture occurs and it is dispersed into the container as a vapor. Being soluble in iron, the zinc vapor subsequently diffuses into the surface of ferrous parts. Volume of the zinc mixture is calculated based upon total surface area of the parts resulting in excellent control of resultant thickness with near total consumption of the zinc powder. After the diffusion, specially designed topcoats and sealers are applied to complete the finish. The United States Environmental Protection Agency has stated this finish approaches zero emissions and it has received recognition and awards for its contribution to pollution prevention. There is no hazardous chemistry and water consumption is extremely low. In addition to these benefits, ArmorGalv® exceeds the performance benchmarks of many competing solutions.

SPIROL recommends ArmorGalv® coating as an alternative to traditional platings and coatings for many reasons; chief among them product quality, maximum corrosion protection/performance, cost effectiveness, and environmental stewardship. Primary benefits of ArmorGalv® are:

	<b>1,000 hours or greater corrosion resistance</b> of time to red rust (base metal attack)
	<b>ZERO</b> risk of hydrogen embrittlement
	<b>Will not reduce fatigue strength of material</b> (applicable to all alloys including stainless)
	<b>Uniform deposition of coating</b> on all surfaces ( <b>No insignificant surfaces</b> ). All internal features or ØID's receive full coating and protection
	<b>Cost effective</b>
	<b>Anti-galling</b> characteristics similar to cadmium (may be applied to stainless steel)
	<b>No flaking, peeling, or blistering</b> – approximately 1/3 of finish thickness is diffused into the coated surface effectively becoming part of the component
	<b>Hard and highly abrasion resistant @ 37-42 HRC</b>
	<b>Slightly porous surface</b> will retain paint and other coatings in the event complete pinned assembly requires subsequent painting, powder coating, etc.

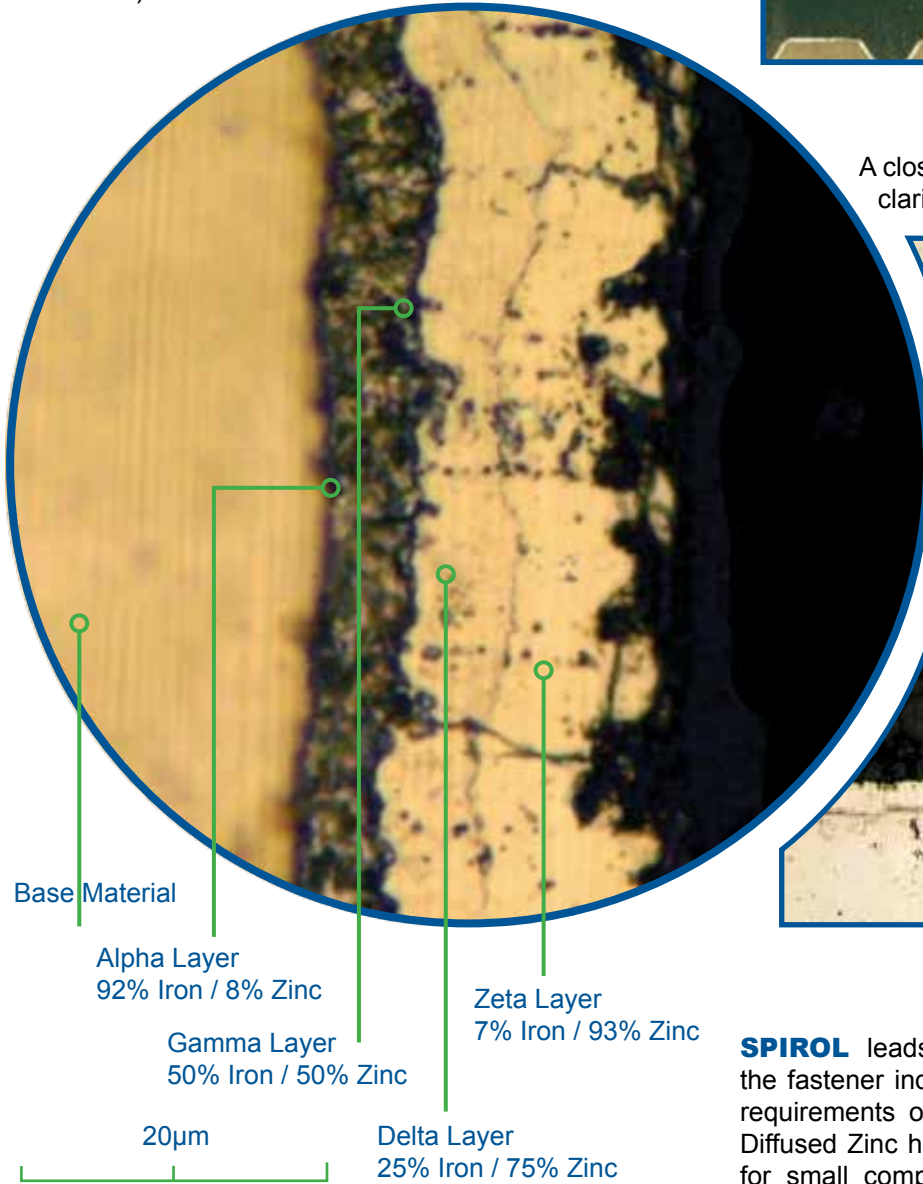
ArmorGalv® offers a low risk, cost effective, high performance alternative to many of today's platings and coatings. With ever-increasing performance and life cycle requirements, this coating is an ideal solution for fasteners used in some of the most aggressive environments such as marine, automotive, mining, and industrial manufacturing. The following photographs provide visual representation of this coatings effectiveness.

Uniformity of deposition is visible in the following photographs. Note coverage of all surfaces including peaks, valleys, corners, and gaps:



Fastener and washer with ArmorGalv® coating.

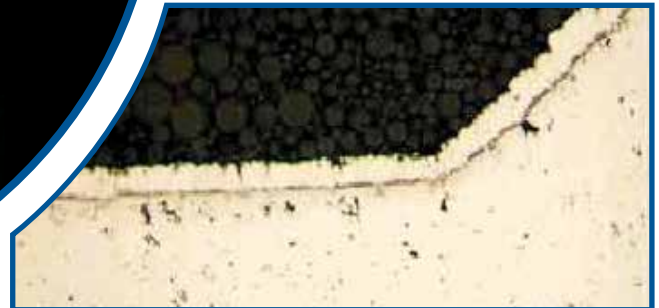
The image below demonstrates the layered structure of ArmorGalv®. Maximum percentages of zinc occur at the surface with the percent iron increasing with depth (20 microns average coating thickness is applied to SPIROL fasteners):



A closer cross-section with thicker deposition for clarity in the two images below:



Powder Metal Parts Before ArmorGalv®



Powder Metal Parts After ArmorGalv®  
(100 microns / 4mils)

**SPIROL** leads the innovation of new technologies in the fastener industry in order to meet the ever-changing requirements of a dynamic market. Until now, Thermal Diffused Zinc had not been a commercially viable option for small components. By leveraging its 75+ years of engineering ingenuity, developing the associated process, and investing in the necessary equipment, SPIROL is able to bring this superior coating to the fastener market at a cost effective price. As stated by SPIROL's Marketing Manager, Christie Jones, "ArmorGalv® is a game-changer in the fastener industry, and SPIROL is proud to be at the forefront of bringing this technology to the market."

Contact SPIROL today for more information about ArmorGalv®!

**ArmorGalv is  
RoHS and REACH  
compliant.**

## Technical Centres

**Europe** **SPIROL United Kingdom**  
17 Princewood Road  
Corby, Northants  
NN17 4ET United Kingdom  
Tel: +44 (0) 1536 444800  
Fax: +44 (0) 1536 203415

**SPIROL France**  
Cité de l'Automobile ZAC Croix Blandin  
18 Rue Léna Bernstein  
51100 Reims, France  
Tel: +33 (0) 3 26 36 31 42  
Fax: +33 (0) 3 26 09 19 76

**SPIROL Germany**  
Ottostr. 4  
80333 Munich, Germany  
Tel: +49 (0) 89 4 111 905 71  
Fax: +49 (0) 89 4 111 905 72

**SPIROL Spain**  
Plantes 3 i 4  
Gran Via de Carles III, 84  
08028, Barcelona, Spain  
Tel/Fax: +34 932 71 64 28

**SPIROL Czech Republic**  
Evropská 2588 / 33a  
160 00 Prague 6-Dejvice  
Czech Republic  
Tel: +420 226 218 935

**SPIROL Poland**  
ul. Solec 38 lok. 10  
00-394, Warsaw, Poland  
Tel. +48 510 039 345

**Americas** **SPIROL International Corporation**  
30 Rock Avenue  
Danielson, Connecticut 06239 U.S.A.  
Tel. +1 860 774 8571  
Fax. +1 860 774 2048

**SPIROL Shim Division**  
321 Remington Road  
Stow, Ohio 44224 U.S.A.  
Tel. +1 330 920 3655  
Fax. +1 330 920 3659

**SPIROL Canada**  
3103 St. Etienne Boulevard  
Windsor, Ontario N8W 5B1 Canada  
Tel. +1 519 974 3334  
Fax. +1 519 974 6550

**SPIROL Mexico**  
Avenida Avante #250  
Parque Industrial Avante Apodaca  
Apodaca, N.L. 66607 Mexico  
Tel. +52 81 8385 4390  
Fax. +52 81 8385 4391

**SPIROL Brazil**  
Rua Mafalda Barnabé Soliane, 134  
Comercial Vitória Martini,  
Distrito Industrial,  
CEP 13347-610, Indaiatuba, SP, Brazil  
Tel. +55 19 3936 2701  
Fax. +55 19 3936 7121

**Asia Pacific** **SPIROL Asia Headquarters**  
1st Floor, Building 22, Plot D9, District D  
No. 122 HeDan Road  
Wai Gao Qiao Free Trade Zone  
Shanghai, China 200131  
Tel: +86 (0) 21 5046-1451  
Fax: +86 (0) 21 5046-1540

**SPIROL Korea**  
16th Floor, 396 Seocho-daero,  
Seocho-gu, Seoul, 06619, South Korea  
Tel: +82 (0) 10 9429 1451



Coiled Spring Pins



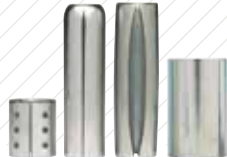
Slotted Spring Pins



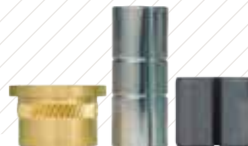
Solid Pins



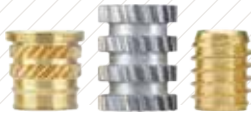
Alignment Dowels /  
Bushings



Spacers & Rolled  
Tubular Components



Compression  
Limiters



Threaded Inserts  
for Plastics



Railroad Nuts



Disc Springs



Precision Shims &  
Thin Metal Stampings



Precision Washers



Parts Feeding  
Technology



Pin Installation  
Technology



Insert Installation  
Technology



Compression Limiter  
Installation Technology

Please refer to [www.SPIROL.co.uk](http://www.SPIROL.co.uk) for current specifications and standard product offerings.

SPIROL offers complimentary Application Engineering support! We will assist on new designs as well as help resolve issues, and recommend cost savings on existing designs. Let us help by visiting **Application Engineering Services** on [SPIROL.co.uk](http://SPIROL.co.uk).