

**THC** 拉链  
ZIPPER  
SINCE 1985



**FINISH CARD**  
表面处理色卡

## Plating Definition 电镀原理



**电镀：**利用电解原理在某些金属表面上镀上一薄层其它金属或合金的过程。通过电解作用使金属或其它材料制品的表面附着一层金属膜，从而起到防止金属氧化（如锈蚀），提高耐磨性、导电性、反光性、抗腐蚀性及增进美观等作用。

电镀一般有含镍电镀与非镍电镀。相较非镍电镀而言，含镍电镀的耐磨、抗腐蚀性能更佳，但因欧盟等国环保法而禁止使用。我司非镍电镀（吊镀需加膜）产品均能达到OEKO一级生态环保标准。

**Plating:** The process of adding a thin layer of other metal or alloy to the surface of some metals according to the principle of electrolysis. The thin layer can prevent metal from oxidizing (such as corrosion), improve the wear resistance, electrical conductivity, reflectiveness, corrosion resistance and enhance the appearance.

Plating generally contains nickel plating and non-nickel plating. Compared with non-nickel plating, the nickel plating is better at the wear resistance and corrosion resistance. But the nickel plating is forbidden to use in the EU because of the environmental protection legislation. THC's non-nickel plating (rack plating with coating) products can meet the standard of Oeko-Tex 100 certificate class 1.

## Color & Appearance 颜色、外观

The complex process of plating determines the color will be influenced by some factors, such as current density, pH value, plating liquid composition and concentration, temperature, time, polishing or brushed finishing.

Slider plating is generally divided into rack plating and rolling plating. Auxiliary process could be chosen beside the plating, such as single-side polish, double-side polish, multi-side polish, manually separating pullers from die-casting and grinding, anti-salt spray, coating, brushed finishing, wrapping pull, laser typing. Please timely contact our sales representative if auxiliary process is necessary. The cost would be higher.

Plating products' surface can be visually inspected at the distance of 25CM under natural light or the CIE Illuminant D65. Same batch products' color difference is not less than the standard of GB250 Lv.4. The difference between the product and the customers' sample is not less than the standard of GB250 Lv.3. The darkness difference always exists when the final color is gold or similar, yellow or similar and brushed finishing because of the process feature.

Because of the process, structure of slider and shape of puller, the color difference of different parts of slider is obvious when composite plating is used, such as antique brass (tea gold), antique silver, antique copper, copper(bronze)-tin, contrasted-tin, oxidized (Orange) copper, all kinds of alloy colors, black covered copper (bronze), copper gold.

电镀的复杂工艺决定了生产过程中，其颜色会受到一些因素的影响，如：电流密度、PH值、电镀液成份与浓度、温度、时间、抛光或扫丝工艺。

拉头电镀种类：吊镀、滚镀。可选择某些辅助工艺：单、双面抛、全抛、手工掰离研磨、过盐雾、加膜、扫丝、拉片包膜、激光打字等。如需辅助工艺，须与我司销售代表沟通，需另外增加成本。

电镀产品的表面可在自然光线下或d65光源环境下，距离25cm处进行目测，同批次产品色差不低于GB250四级，不低于客户样或封样GB250三级。（金）黄色类、扫丝类因工艺局限，其颜色易有深浅差异。

复合镀种，如青古铜（茶金）、黑白镍、红古铜、红（青）铜锡、鸳鸯锡、氧化（橙）红铜、各类合金色、克面（黑面）红铜（青铜）、红铜金等，受工艺、拉头、拉片形状结构的影响，各部位颜色偏差较明显。

## Preservation 防护

1. Keep the storage place dry. Use the plastic bag to store. Keep away from the ground and wall for corrosion-proof and moisture-proof. Avoid long-time exposure to the air.

2. Handle gently during transportation and delivery to avoid the surface scratch.

3. Don't touch the acid, basicity. Don't use with corrosion material.

1、存放场地须保持干燥，贮存时应用塑料袋封装，保持与地面隔离，防潮、防腐蚀，尽量避免长时间暴露。

2、运输、搬运中应平稳轻放，防止碰伤、撞伤产品表层。

3、勿沾染酸、碱等腐蚀物，勿与强腐蚀材料接触使用。

## Condition of Use 使用环境

1. Composite plating's color is easy to change by time, temperature and humidity. It is not suitable for washing and salt spray test.

2. There should be a note of "salt spray test" when one of antique silver, black nickel, nickel, matt nickel is used at high temperature. A note of "coating" is needed when rack plating is used for salt spray test or at high temperature. Procedure details are needed if one of special washing, special fabric (leather, chlorine bleaching fabric, sulfur fabric), salt spray test is used. Test is strongly recommended before bulk production.

3. Black antique brass is died of blackening stuff. The color-fastness is not stable. The slider corner and raised part are easily worn. It is not suitable for washing and salt spray test. Color will be significantly changed when enzyme washing with sliders wrapped. (It can be replaced by hanging matt black painting to avoid color changing.)

4. During garment production and washing, plating slider should be prevented from direct collision or friction with washing stone, burrs or other sharp objects. Slider should be wrapped and fixed by cloth when washed. (Rack plating is easier to be damaged.) For common plating, enzyme washing pH value must be controlled at 4-6, the temperature is less than 60°C, duration is 30-45 minutes. These conditions are to avoid color changing or plating layer dropping.

5. After garment washing or ironing, dry fully and timely. Keep dry to avoid color change caused by moisture.

1、复合镀种随着时间、温度、湿度环境的影响，易发生氧化变色，不耐各类水洗与盐雾测试。

2、黑白镍、黑镍、无镍白、无镍哑白如用于高温条件下需注明过盐雾，吊镀如要过盐雾、耐高温则需注明加膜。对于特殊水洗、特殊面料（如皮革、氯漂面料、含硫面料）、过盐雾，须详细描述工艺及参数要求，建议进行小批量试验。

3、黑古铜是发黑剂发黑染色而成，牢度存在缺陷，如边角处、凸起部位易漏红铜底色，不耐水洗及盐雾。包起来进行酵素水洗，颜色也会明显变化。（黑古铜可用哑光黑替代，水洗前后变色不明显。）

4、在服装生产、水洗过程中，拉头应避免与磨石或尖、硬等物体直接碰撞、磨擦，水洗时要用布包好且固定好（吊镀拉头更易磨花）。常规镀种，酵素水洗PH值须控制在4-6，温度不超过60度，时间30-45分钟内，以避免变色或掉镀层。

5、服装整烫、水洗后，须及时干燥充分。保持干燥，以免受潮后颜色变暗或变色。



# ENAMEL

## 喷漆处理代码



**P** 喷漆  
normal painting  
表面: 略粗糙  
Surface: A little rough



**Z** 冷喷  
normal painting (hanger)  
表面: 光滑  
Surface: Shiny and smooth



**H** 半哑冷喷  
semi matt painting (hanger)  
表面: 半哑  
Surface: Semi matt



**J** 冷喷加胶 (橡胶漆)  
painting with rubber (hanger)  
表面: 触感柔软, 表面完全哑光  
Surface: Tough soft, Complete matt



**G** 双色冷喷  
double-tone painting (hanger)  
表面: 两层颜色重叠, 表面光滑  
Surface: Two colors overlap,  
Smooth

★ 本样卡颜色仅供参考, 大货颜色会有细微差别。  
The colors are only for reference. The colors of bulk order may be slightly different from the catalog.

★ 同批次产品色差不应低于GB/T250 4级, 与来样相色差不应低于GB/T250 3.5级, 特殊电镀效果除外。  
For the same batch of the products, the chromatics should not be lower than GB250 class 4; Comparing with the original counter sample, the chromatics should not be lower than GB250 class 3.5, except the special plating colors.

# ROLL PLATING

滚镀处理代码



**TS** 镀无镍白  
nickel



**BQ** 镀无镍亮白  
shiny nickel



**TY** 镀无镍哑白  
matt nickel



**AR** 镀无镍青铜锡  
bronze-tin



**TP** 镀无镍黑  
black nickel



**BG** 镀无镍哑光黑镍  
matt black nickel



**AL** 镀无镍鸳鸯锡  
contrasted-tin



**AJ** 镀无镍合金  
alloy



**TV** 镀无镍黑白  
black and nickel



**BJ** 镀无镍哑光黑白镍  
antique silver (matt)



★ **BL** 镀无镍厚黑镍扫丝  
thick black nickel  
brushed



★ **BM** 镀无镍厚青古铜扫丝  
thick antique brass  
brushed



**TU** 镀无镍青古铜  
antique brass



**BE** 镀无镍茶金  
tea gold



**TR** 镀无镍仿金  
golden brass



**TT** 镀无镍黄铜  
brass



**BH** 镀无镍红铜  
copper



**AY** 镀无镍橙红铜  
orange copper



**AF** 镀无镍红铜锡  
copper-tin



**BA** 镀无镍红铜金  
copper gold

★ 滚挂结合表面处理：此种表面处理较普通的滚镀，价格稍高。COMBINATION of ROLL and RACK PLATING FINISH: The price is higher than normal roll plating.



**AU** 镀无镍氧化红铜  
oxidized copper



**TO** 镀无镍克面红铜  
black covered copper



**TN** 镀无镍红铜合金  
copper alloy



**AA** 镀无镍红古铜  
antique copper



**BK** 镀无镍黑面红古铜  
black covered antique  
copper



**TQ** 镀无镍克面青铜  
black covered bronze

## Roll Plating+Painting (Hanger)



★ **BN** 镀无镍挂亮黑古铜  
black antique brass  
(hanger)



★ **BO** 镀无镍挂哑黑古铜  
matt black antique brass  
(hanger)



**BR** 镀无镍半哑黑古铜  
semi matt black antique  
brass (hanger)

This series of black is more suitable for metal zipper as its good abrasion resistance.

这个系列的黑色更加适合金属拉链，耐磨性能较好。

このシリーズの黒は金属ファスナーに適していて、耐磨耗性に優れています。

## RACK PLATING

### 吊镀处理代码



**DQ** 吊镀无镍白加膜  
nickel with  
shinny-coating



**DF** 吊镀无镍白哑膜  
nickel with matt-coating



**EM** 吊镀无镍白扫尼龙加膜  
brushed nickel with  
shinny-coating



**DN** 吊镀无镍珍珠镍  
pearl nickel

★ 滚挂结合表面处理：此种表面处理较普通的滚镀，价格稍高。COMBINATION of ROLL and RACK PLATING FINISH:The price is higher than normal roll plating.



**DP** 吊镀无镍枪加膜  
black nickel with  
shiny-coating



**EF** 吊镀无镍枪哑膜  
black nickel with  
matt-coating



**EQ** 吊镀无镍古银加膜  
antique silver with  
shiny-coating



**ER** 吊镀无镍古银哑膜  
antique silver with  
matt-coating



**FN** 吊镀无镍青铜加膜  
antique brass with  
shiny-coating



**FO** 吊镀无镍青铜哑膜  
antique brass with  
matt-coating



**EV** 吊镀无镍青铜锡扫丝  
brushed bronze-tin



**FX** 吊镀无镍仿金拉丝加膜  
brushed golden brass  
with shiny-coating



**FP** 吊镀无镍红古铜加膜  
antique copper with  
shiny-coating



**FQ** 吊镀无镍红古铜哑膜  
antique copper with  
matt-coating



**FJ** 吊镀无镍仿玫瑰金加膜  
imitation rose gold with  
shiny-coating



★ **FD** 吊镀无镍玫瑰金加膜  
rose gold with  
shiny-coating



**FC** 吊镀无镍仿金加膜  
golden brass with  
shiny-coating



**FK** 吊镀无镍仿哑金哑膜  
imitation matt gold with  
matt-coating



★ **DO** 吊镀无镍金加膜  
gold with  
shiny-coating



★ **DZ** 吊镀无镍金哑膜  
gold with  
matt-coating



**FF** 吊镀无镍仿淡淡金加膜  
imitation pale l-gold with  
shiny-coating



**FW** 吊镀无镍仿淡淡金哑膜  
imitation pale l-gold with  
matt-coating



★ **EW** 吊镀无镍浅金加膜  
l-gold with  
shiny-coating



★ **FE** 吊镀无镍浅金哑膜  
l-gold with matt-coating



**FG** 吊镀无镍仿深浅金加膜  
imitation dk l-gold with  
shiny-coating



★ **EU** 吊镀无镍浅金扫尼龙亮膜  
brushed l-gold with  
bright-coating



**FV** 吊镀无镍仿浅金扫丝加膜  
brushed imitation l-gold  
with shiny-coating

★ “真金材质”：此种表面处理，较普通的吊镀处理，价格稍高。REAL GOLD:The material of real gold's price is higher than regular rack plating.

## VOL 20220705

- ※ 此系列所有版本，均以THC发布的最新版为准。
- ※ 此样册中的所有样品仅供参考，并以大货为准。
- ※ Please refer to the newest version issued by THC,if any content differs.
- ※ Quality please refer to the bulk order.



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