

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

AT-0 TIN/ZINC-CLEAR-ROHS

AT

0

REV DATE: 3/16/2011

GENERAL DESCRIPTION

.0003 MIN. PLATING ALLOY COMPOSITION WILL BE IN THE RANGE 65-80% TIN, WITH THE BALANCE ZINC. FOLLOWED BY CLEAR TRIVALENT. PER INTERNATIONAL TRUCK AND ENGINE. CEMS G-23

APPEARANCE

SILVER

ADHESION AND DUCTILITY

ADHESION OF PLATING WILL BE TESTED BY SUBJECTING PLATED PARTS TO 175° C FOR 30 MINUTES, FOLOWED BY QUENCHING IN WATER. TESTED PARTS WILL BE INSPECTED FOR BLISTERING, CHIPPING, OR FLAKING.

CORROSION REQUIREMENTS

RED RUST: 1000

WHITE CORRIOSION: 48

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

.0003 MIN. PER CEMS G-23

STRESS RELIEF

DUE TO LOW MELTING POINT OF TIN-ZINC PLATING, PARTS REQUIRING DE-EMBRITTEMENT BAKE SHALL BE HEATED TO A PART TEMPERATURE OF 187° C AND HELD FOR 4 HOURS.

QUALITY CONTROL

VISUAL INSPECTION FOR UNIFORMITY OF COLOR, EXCESS OIL AND CLEANLINESS. VISUALLY INSPECT FOR UNIFORMITY OF COLOR & SURFACE APPEARANCE, FREEDOM FROM TEARS, BARE SPOT, POWDERY FILM. SLOUGHING OFF OF FILM & BLISTERING

PROCESS TO

INTERNATIONAL TRUCK AND ENGINE. CEMS G-23

PRINT DATE:

6/2/2016