

# ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH  
CODE

REVISION  
LEVEL

**BRIEF DESCRIPTION:**

DA-0 EZINC-8H BAKE-YELLOW-RoHS

**DA**

**0**

REV DATE: 11/20/2019

**GENERAL DESCRIPTION**

.0002-.0004 ELECTROZINC, 8 HOUR BAKE, TRI-CHROMATE WITH YELLOW DYE.  
!!!MUST BE RoHS COMPLIANT!!!

**APPEARANCE**

GLOSSY UNIFORM YELLOW

**ADHESION AND DUCTILITY**

TO BE TESTED IN ACCORDANCE TO ASTM B571

**CORROSION REQUIREMENTS**

RED RUST: 108

WHITE CORRIOSION: 72

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

**COATING THICKNESS REQUIREMENTS**

.0002 MIN THICKNESS .0004 MAX THICKNESS  
THICKNESS SHALL BE TESTED PER ASTM E376

**STRESS RELIEF**

WITHIN 1 HOUR OF BASE PLATING, PARTS TO BE BAKED AT 400 +/- 25 DEGREES F FOR A MINIMUM OF 8 HOURS.  
THE 8 HOUR DURATION OF BAKING SHALL COMMENCE WHEN THE PRODUCT CORE TEMPERATURE REACHES 375  
DEGREES F

**QUALITY CONTROL**

VISUALLY INSPECT FOR UNIFORMITY OF COLOR & SURFACE APPEARANCE, FREEDOM FROM TEARS, BARE  
SPOTS, POWDERY FILM. SLOUGHING OFF OF FILM & BLISTERING

**PROCESS TO**

PRINT DATE:

11/20/2019