

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

DG-0 CAD-BAKE-DICHRMTE-EMPIGRD

DG

0

REV DATE: 9/4/2007

GENERAL DESCRIPTION

.0005 MINIMUM ELECTROPLATED CADMIUM, DICHROMATE AND CLEAR EMPIGARD 2 COATS

APPEARANCE

GLOSSY YELLOW IN COLOR

ADHESION AND DUCTILITY

TO BE TESTED IN ACCORDANCE TO ASTM B571 (SCOTCH TAPE TEST)

CORROSION REQUIREMENTS

RED RUST: 800

WHITE CORRIOSION: 400

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN THICKNESS: .0005 MAX THICKNESS: .0007
THICKNESS SHALL BE TESTED PER ASTM E376

STRESS RELIEF

PARTS TO BE BAKED AT 400 DEGREES F FOR 4 HOURS WITHIN 1 HOUR OF BASE PLATING.

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:

6/2/2016