

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

DH-0 EZINC-8H BAKE-CLEAR-ROHS

DH

0

REV DATE: 5/16/2013

GENERAL DESCRIPTION

.0002 MIN. ELECTROZINC, 8 HOUR BAKE, CLEAR CHROMATE. MUST BE ROHS COMPLIANT

APPEARANCE

SHINY SILVER WITH A BLuish TINGE

ADHESION AND DUCTILITY

TO BE TESTED IN ACCORDANCE TO ASTM B571

CORROSION REQUIREMENTS

RED RUST: 48

WHITE CORRIOSION: 16

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

SUPPLY TECH REQUIREMENT MANUAL

PRINT DATE:

6/2/2016