

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

DK-0 EZINC-8H BAKE-TRICHROME-ROHS

DK

0

REV DATE: 5/16/2013

GENERAL DESCRIPTION

.0002 MIN. ELECTROZINC HIGH BUILD, 8 HOUR BAKE, TRI-CHROME(CLEAR, HEX-CHROME FREE, NO SEALER).
!!!MUST BE ROHS COMPLIANT!!!

APPEARANCE

CLEAR BRIGHT COLOR REFLECTING THE BRIGHT SHINY ZINC WITH A SMOOTH LOW FRICTION FEEL

ADHESION AND DUCTILITY

TO BE TESTED IN ACCORDANCE TO ASTM B571

CORROSION REQUIREMENTS

RED RUST: 168

WHITE CORRIOSION: 96

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