

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

DM-0 EZINC-8H BAKE-TRI-PTHEAD-ROHS

DM

0

REV DATE: 6/9/2016

GENERAL DESCRIPTION

.0002 MIN. ELECTROZINC HIGH BUILD, 8 HOUR BAKE, TRI-CHROME(CLEAR, HEX-CHROME FREE, NO SEALER). PAINT HEAD ALUMINUM ACCENT PER GE COLOR CHIP #14H2619. USE ONLY POLY URETHANE PAINT TO PREVENT CHIPPING. PAINTED HEAD MUST MEET 500 HOURS SALT SPRAY PER GE EMPIS E50L045. IF MYLAR WASHER IS REQUIRED, THIS OPERATION TO BE COMPLETED BETWEEN ELECTROPLATING AND PAINTING THE HEAD. !!!MUST BE RoHS COMPLIANT!!!

APPEARANCE

CLEAR BRIGHT COLOR REFLECTING THE BRIGHT SHINY ZINC WITH A SMOOTH LOW FRICTION FEEL BODY. ALUMINUM ACCENT HEAD.

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

ZINC ELECTROPLATE .0002 MIN ADDITIONAL THICKNESS ALLOWED TO MEET SALT SPRAY REQUIREMENTS.

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

GE F70B22B2 PAINT HEAD F50L014 CHIP # 14H2619

PRINT DATE:

6/9/2016