

# ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH  
CODE

REVISION  
LEVEL

## BRIEF DESCRIPTION:

DN-0 EZINC-8H BAKE-TRI-PTHEAD-RoHS

**DN**

**0**

REV DATE: 5/31/2017

## GENERAL DESCRIPTION

.0002 MIN. ELECTROZINC HIGH BUILD, 8 HOUR BAKE, TRI-CHROME(CLEAR, HEX-CHROME FREE, NO SEALER). PAINT HEAD ARTIC WHITE PER GE COLOR CHIP #14H2. USE ONLY POLY URETHANE PAINT TO PREVENT CHIPPING. 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. ARTIC WHITE 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 F70B21C2 PAINT HEAD F50L014 CHIP # 14H2697

PRINT DATE:

5/31/2017