

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

EZ-0 RIE 130-TRANE GREEN-ROHS

EZ

0

REV DATE: 7/18/2013

GENERAL DESCRIPTION

RIE 130 TRANE GREEN 2 COATS. THIS TOP COAT IS ROHS COMPLIANT. TOP COAT APPLIED OVER .0003 MIN. ELECTROZINC, BAKE FOLLOWED BY CLEAR CHROMATE. !!!MUST BE ROHS COMPLIANT!!!

APPEARANCE

GREEN

ADHESION AND DUCTILITY

PER RIE 130 PROCESS

CORROSION REQUIREMENTS

RED RUST: 1000

WHITE CORRIOSION:

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

PER RIE 130 PROCESS

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