

# ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH  
CODE

REVISION  
LEVEL

**BRIEF DESCRIPTION:**

GF-3 COPPER ELECTRO

**GF**

**3**

REV DATE: 10/22/2019

**GENERAL DESCRIPTION**

COPPER ELECTROPLATE WITH A THICKNESS OF .0003" TO PROTECT STEEL PARTS FROM ABSORBING CARBON FROM CARBURIZING ATOMOSPHERE DURING HEAT TREAT

**APPEARANCE**

COPPER WITH A SMOOTH UNIFORM APPEARANCE.

**ADHESION AND DUCTILITY**

TO BE TESTED IN ACCORDANCE TO ASTM B571 (SCOTCH TAPE TEST)

**CORROSION REQUIREMENTS**

RED RUST:

WHITE CORRIOSION:

NOT REQUIRED

**COATING THICKNESS REQUIREMENTS**

MIN THICKNESS: .0003                      MAX THICKNESS: .0006  
THICKNESS SHALL BE TESTED PER ASTM E376

**STRESS RELIEF**

IF PARTS ARE LESS THAN R"C" 32, NO STRESS RELIEF REQUIRED.  
IF PARTS ARE R"C" 32 OR ABOVE BAKE FOR 4 HOURS AT 400 DEGREES F. WITHIN 1 HOUR OF COATING.

**QUALITY CONTROL**

THICKNESS TEST: ELECTRONIC THICKNESS TESTER.

**PROCESS TO**

PRINT DATE:

10/22/2019