

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

IA-0 EZINC-BAKE F1941-CHROMATE-RoHS

IA

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REV DATE: 1/16/2017

GENERAL DESCRIPTION

.0001 MIN ELECTROPLATE ZINC CLEAR TRIVALENT PER ASTM F1941.
!!!MUST BE RoHS COMPLIANT!!!

APPEARANCE

CLEAR

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 108

WHITE CORRIOSION: 72

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN. THICKNESS: .0001 MAX. THICKNESS: .0003
THICKNESS SHALL BE TESTED PER ASTM E376

STRESS RELIEF

PARTS TO BE BAKED AT 375-425 DEG F FOR A MIN. OF 24 HOURS WITHIN 4 HOURS OF ELECTROPLATING,
PREFERABLY 1 HOUR.

QUALITY CONTROL

VISUALLY INSPECT FOR UNIFORMITY OF COLOR & SURFACE APPEARANCE, FREEDOM FROM TEARS, BARE SPOTS,
POWDERY FILM, SLOUGHING OFF OF FILM, & BLISTERING

PROCESS TO

ASTM F1941 Fe/Zn 3 AN

PRINT DATE:

1/16/2017