

# ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH  
CODE

REVISION  
LEVEL

**BRIEF DESCRIPTION:**

JM-0 BLK ORGANIC-NICKEL-BAKE

**JM**

**0**

REV DATE: 4/1/2007

**GENERAL DESCRIPTION**

BLACK ORGANIC COATING OVER .0005 MIN ZINC/NICKEL ALLOY OVER .0002 MIN NICKEL ALLOY. NOT RECOMMENDED FOR MACHINE SCREW THREADS

**APPEARANCE**

SMOOTH DULL BLACK APPEARANCE

**ADHESION AND DUCTILITY**

TO BE TESTED IN ACCORDANCE TO ASTM B571 (SCOTCH TAPE TEST) GRINDING  
WHEEL TEST: SAMPLES WILL BE GROUND ON EDGES THROUGH THE PLATING DEPOSITS AND INTO THE BASE METAL AND THE GROUND EDGES EXAMINED FOR FLAKING, PEELING OR LAYER SEPERATION

**CORROSION REQUIREMENTS**

RED RUST: 1000

WHITE CORRIOSION: 72

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

**COATING THICKNESS REQUIREMENTS**

MIN THICKNESS: ORGANIC: NA ZINC/NICKEL ALLOY: .00050 NICKEL ALLOY: .00020  
MAX THICKNESS: ORGANIC: .001 ZINC/NICKEL ALLOY: .00065 NICKEL ALLOY: .00035  
THICKNESS SHALL BE TESTED PER ASTM E376

**STRESS RELIEF**

PARTS TO BE BAKED AT 400 DEGREES F FOR 4 HOURS WITHIN 1 HOUR OF BASE PLATING

**QUALITY CONTROL**

SALT SPRAY TEST: EXTERNALLY THREADED PRODUCTS SHALL BE POWER DRIVEN INTO A TAPPED HOLE OR NUT, THEN INSTALLED FINGER TIGHT INTO AN ACRYLIC PLASTIC OR OTHER INERT MATERIAL. VISUALLY INSPECT FOR UNIFORMITY OF COLOR AND SURFACE APPEARANCE, FREEDOM FROM RUNS, TEARS, BLISTERING, FLAKING, PEELING, AND LAYER SEPERATION.

**PROCESS TO**

GM 6138M

PRINT DATE:

6/2/2016