

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

JN-5 ZINC PHOS-ENAMEL-BAKE-OIL-RoHS

JN

5

REV DATE: 4/30/2015

GENERAL DESCRIPTION

CATHODIC ELECTROPLATED BAKE ENAMEL (BLACK) & OIL DRY TO TOUCH OVER ZINC PHOSPHATE
!!!!MUST BE RoHS COMPLIANT!!!!

APPEARANCE

SMOOTH DENSE BLACK APPEARANCE

ADHESION AND DUCTILITY

PER ASTM B571 (SCOTCH TAPE TEST)

CORROSION REQUIREMENTS

RED RUST: 240

WHITE CORRIOSION: 0

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN THICKNESS: PHOSPHATE:1500 MIL/FT2 MAX THICKNESS: PAINT .0005 THICKNESS SHALL BE TESTED
PER ASTM E376

STRESS RELIEF

PARTS TO BE BAKED AT 225 DEGREES F FOR 2 HOURS WITHIN 1 HOUR OF BASE PLATING.

QUALITY CONTROL

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

PROCESS TO

GM 6047-M CHRYSLER PS-7902-C GE F42B1A1

PRINT DATE:

1/5/2017