

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

JP-3 BLACK ORGANIC PROTECTIVE COATING PLUS SEALER-RoHS

JP

3

REV DATE: 8/16/2019

GENERAL DESCRIPTION

BLACK ORGANIC CORROSION COATING. THIS FINISH IS A ZINC PHOSPHATE PRETREATMENT, BLACK ORGANIC PROTECTIVE COATING, PLUS A DRY TO TOUCH SEALER.
!!!MUST BE RoHS COMPLIANT!!!

APPEARANCE

FLAT BLACK APPEARANCE

ADHESION AND DUCTILITY

PER SM 9071P (SCOTCH TAPE TEST)

CORROSION REQUIREMENTS

RED RUST: 120

WHITE CORROSION: N/A

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN. THICKNESS: .0003 MAX. THICKNESS: .0006
THICKNESS SHALL BE TESTED PER ISO 4042 CLAUSE 10

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 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

FORD S424, WSS-M21P41-A

PRINT DATE:

10/20/2020