

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

KA-0 EZINC-GREY-RESIN-BAKE

KA

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REV DATE: 4/1/2007

GENERAL DESCRIPTION

3 COATS OF COPOLYMER RESIN (BX7Z) OVER .0003 MIN ELECTROPLATED ZINC & YELLOW DICHROMATE (CLIMASEAL)

APPEARANCE

SATINY METALIC GREY APPEARANCE

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 360

WHITE CORRIOSION: 72

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN THICKNESS ZINC: .0003 MAX THICKNESS ZINC: .0005 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

GRINDING WHEEL TEST: SAMPLES WILL BE GROUND ON EDGES THROUGH THE DEPOSITS AND INTO THE BASE METAL, AND THE GROUND EDGES EXAMINED FOR FLAKING, PEELING AND SPERATION OF LAYERS. VISUALLY INSPECT FOR UNIFORMITY OF COLOR AND SURFACE APPEARANCE, FREEDOM FROM TEARS, RUNS, BLISTERING, FLAKING AND PEELING.

PROCESS TO

PRINT DATE:

6/3/2016