

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

KM-0 ORGANIC- ZINC-PHOS

KM

0

REV DATE: 4/1/2007

GENERAL DESCRIPTION

BLACK FLOUROCARBON ORGANIC COATING OVER ZINC PHOSPHATE

APPEARANCE

SMOOTH, BLACK FINISH

ADHESION AND DUCTILITY

TO BE TESTED IN ACCORDANCE TO 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: 500 MILLIGRAMS PER SQUARE FOOT, MAX THICKNESS: FLUOROCARBON:
.0005 APPROX THICKNESS SHALL BE TESTED PER ASTM E376

STRESS RELIEF

STANDARD BAKE AT 400 DEGREES F FOR 2 HOURS WITHIN 1 HOUR OF BASE PLATING.

QUALITY CONTROL

VISUAL INSPECTION: COATING SHALL BE UNIFORM FREE FROM BARE SPOTS RUNS, DRIPS AND BLISTERING

PROCESS TO

GM 6046M(13T240)

PRINT DATE:

6/3/2016