

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

LJ-0 SHARPERIZE-BLACK-UV COAT-RoHS

LJ

1

REV DATE: 5/23/2019

GENERAL DESCRIPTION

"SHARPERIZE" ZINC-NICKEL BLACK CORROSION / UV RESISTANT COATING.
!!!MUST BE RoHS COMPLIANT!!!

APPEARANCE

BLACK FINISH

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 1000

WHITE CORRIOSION: 240

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN THICKNESS: .0003 MAX THICKNESS: .0005
THICKNESS SHALL BE TESTED PER ASTM E376

STRESS RELIEF

PARTS TO BE BAKED AT 400 DEGREES F FOR 8 HOURS WITHIN 1 HOUR OF BASE PLATING

QUALITY CONTROL

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

PROCESS TO

INTERNATIONAL TMS-4521, TYPE 1 : EZ-GO GS-726-153

PRINT DATE:

5/23/2019