

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

MA-1EZINC-BAKE-CHROMATE-RoHS

MA

1

REV DATE: 4/1/2007

GENERAL DESCRIPTION

ZINC ELECTROPLATE WITH A THICKNESS OF .00015" TO
.00035"

!!!MUST BE RoHS COMPLIANT!!!

APPEARANCE

BRIGHT, SILVERY COLOR, UNIFORM SURFACE APPEARANCE, AND FREEDOM FROM BLISTERS.

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 24

WHITE CORRIOSION: 8

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

ZINC: MIN THICKNESS: .00015" MAX THICKNESS: .00035"
THICKNESS SHALL BE TESTED PER ASTM E376

STRESS RELIEF

FERROUS PARTS: STANDARD BAKE AT 400° F FOR 4 HOURS MINIMUM

QUALITY CONTROL

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

PROCESS TO

ASTM B633

PRINT DATE:

6/3/2016