

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

MD-1 EZINC-BAK-CHRMT-UVWAX-RoHS

MD

1

REV DATE: 12/2/2016

GENERAL DESCRIPTION

.00015 MIN ELECTROPLATED ZINC, SINGLE DIP CLEAR CHROMATE & WAX WITH UV TRACER

APPEARANCE

SILVERY TO SILVERY WITH A SLIGHT BLUE TINT APPEARANCE

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

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

STRESS RELIEF

PARTS TO BE BAKED AT 400 DEGREES F FOR 4 HOURS WITHIN 1 HOUR OF BASE PLATING
ASTM F1941 (CORE HARDNESS BELOW R"C" 40)

QUALITY CONTROL

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

PROCESS TO

ASTM F1941 (CORE HARDNESS BELOW R"C" 40)

PRINT DATE:

12/2/2016