

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

MF-1 EZINC-BAKE-CHROMATE

MF

1

REV DATE: 4/1/2007

GENERAL DESCRIPTION

ZINC ELECTROPLATE, .00015 THICK ELECTROPLATED ZINC WITH A MINIMUM THICKNESS OF .00015" DICHROMATE POST FINISH TO PROVIDE A HIGHER DEGREE OF CORROSION PROTECTION.

APPEARANCE

GLOSSY, UNIFORM YELLOW COLOR

ADHESION AND DUCTILITY

COATING MUST BE UNIFORM IN COLOR FREE OF POWDERYNESS, AND SLOUGHING OFF OF FILM. ADHESION AND DUCTILITY WILL BE TESTED IN ACCORDANCE WITH ASTM B571.

CORROSION REQUIREMENTS

RED RUST: 48

WHITE CORRIOSION: 24

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 BAKING MUST PRECEED ANY POST FINISH PROCEDURE.

QUALITY CONTROL

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

PROCESS TO

PRINT DATE:

6/3/2016