

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

MR-1 EZINC-10 HR BAKE-TRICHROME-RoHS

MR

1

REV DATE: 3/6/2019

GENERAL DESCRIPTION

.0002 MINIMUM ELECTROPLATE ZINC WITH TRI-CHROME (CLEAR, HEX FREE, NO SEALER) (HIGH BUILD)
!!!MUST BE RoHS COMPLIANT!!!

APPEARANCE

CLEAR, BRIGHT COLOR REFLECTING THE BRIGHT SHINY ZINC WITH A SMOOTH LOW FRICTION FEEL

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 168

WHITE CORRIOSION: 96

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN. THICKNESS: .0002 MAX. THICKNESS: .0004
THICKNESS SHALL BE TESTED PER ASTM E376

STRESS RELIEF

PARTS TO BE BAKED AT 374-428 DEGREE F FOR 10 HOURS MINIMUM WITHIN 1 HOUR OF BASE PLATING.
PER ASTM B850.

QUALITY CONTROL

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

PROCESS TO

SQUARE D S30793-501

PRINT DATE:

4/3/2019