

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

NA-1 EZINC-BAKE-CHROMATE-RoHS

NA

1

REV DATE: 3/6/2013

GENERAL DESCRIPTION

.0002 MIN ELECTROPLATED ZINC & CLEAR CHROMATE
!!!MUST BE RoHS COMPLIANT!!!

APPEARANCE

SHINY SILVER WITH A BLuish TINGE

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 48

WHITE CORRIOSION: 16

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 400 DEGREES F FOR 4 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

ASTM B633 SC1 TYPE III GE F70B1A2 GE F70B6A2 AMANA S38014-8 HERMAN MILLER SI-263 CODE 1

PRINT DATE:

8/20/2019