

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

NP-3 EZINC-BAKE-BLK CHROMAT

NP

3

REV DATE: 4/1/2007

GENERAL DESCRIPTION

.0002 MIN ELECTROPLATED ZINC, OLIVE DRAB CHROMATE DYED BLACK

APPEARANCE

GLOSSY BLACK WITH SILVER SCRATCHES SHOWING THROUGH

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 120

WHITE CORRIOSION: 72

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

CH500-407-3(50-1251-2C)

PRINT DATE:

6/3/2016