

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

PJ-0 EZINC-CLEAR-RoHS

PJ

0

REV DATE: 7/31/2007

GENERAL DESCRIPTION

.00025 MIN. ELECTROZINC AND CLEAR CHROMATE (MUST BE HEX FREE, TRIVALENT)

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: 8

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN THICKNESS: .00025 MAX THICKNESS: .00045
THICKNESS SHALL BE TESTED PER ASTM E376

STRESS RELIEF

PARTS TO BE BAKED AT 400 DEGREES F FOR 8 HOURS WITHIN 1 HOUR OF 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

QQ-2-325A TYPE II CLASS 2

PRINT DATE:

6/3/2016