

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

PL-1 EZINC-BLACK-UV WAX-RoHS

PL

2

REV DATE: 9/30/2019

GENERAL DESCRIPTION

.0003 MINIMUM ELECTROPLATED ZINC WITH BLACK TRI-CHROMATE AND WAX WITH UV TRACER
!!!MUST BE RoHS COMPLIANT!!!

APPEARANCE

GLOSSY BLACK

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 300

WHITE CORRIOSION: 96

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN THICKNESS: .0003 MAX THICKNESS: .0005
THICKNESS SHALL BE TESTED PER ASTM E376

STRESS RELIEF

PARTS TO BE BAKED AT 400 DEGREES F FOR 4 HOURS WITHIN 1 HOUR OF PLATING

QUALITY CONTROL

VISUALLY INSPECT FOR UNIFORMITY OF COLOR AND SURFACE APPEARANCE, FREEDOM FROM TEARS, BARE SPOTS, POWDERY FILM, SLOUGING OFF OF FILM, BLISTERING AND EXCESSIVE WAX

PROCESS TO

PRINT DATE:

9/30/2019