

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

QA-2 EZINC-BAKE-CHROMAT-RoHS

QA

2

REV DATE: 6/8/2011

GENERAL DESCRIPTION

ZINC ELECTROPLATE, WITH A MINIMUM THICKNESS OF .0003 AND A SINGLE DIP CHROMATE FINISH !!!MUST BE RoHS COMPLIANT!!!

APPEARANCE

SHINY ZINC ELECTROPLATE WITH A BLuish TINGE CAUSED FROM THE SINGLE DIP CLEAR CHROMATE

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 300

WHITE CORRIOSION: 120

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN THICKNESS: .0003
.0005

MAX THICKNESS:

THICKNESS SHALL BE TESTED PER ASTM E376

STRESS RELIEF

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

QUALITY CONTROL

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

PROCESS TO

GE F70B1E2 ASTM B633 TYPE III SC2

PRINT DATE:

6/3/2016