

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

QH-0 EZINC-BAKE-DICHRMTE-UVWAX

QH

0

REV DATE: 4/1/2007

GENERAL DESCRIPTION

.0003 MIN ELECTROPLATED ZINC, YELLOW DICHROMATE & TODCO V105 (OR EQUIV) WAX WITH UV TRACER

APPEARANCE

IRREDESCENT GOLDISH YELLOW APPEARANCE

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: .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 BASE PLATING

QUALITY CONTROL

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

PROCESS TO

PRINT DATE:

6/3/2016