

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

QL-0 EZINC-BAKE-CHROMATE-UVWAX

QL

0

REV DATE: 4/1/2007

GENERAL DESCRIPTION

.00035 MIN ELECTROPLATED ZINC/ COBALT ALLOY, BLACK CHROMATE & TODCO V5 (OR EQUIV) WAX WITH UV TRACER

APPEARANCE

INCONSISTENT BRIGHT BLACK APPEARANCE

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 400

WHITE CORRIOSION: 168

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN THICKNESS: .00035 MAX THICKNESS: .00055
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, AND BLISTERING

PROCESS TO

GM 6280M

FORD: WHS-MIP86-A

CHRYSLER:PS-8955CO

PRINT DATE:

6/3/2016