

# ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH  
CODE

REVISION  
LEVEL

**BRIEF DESCRIPTION:**

QM-0 HM SI-179 FINISH 3 BLACK-RoHS

**QM**

**0**

REV DATE: 6/12/2012

**GENERAL DESCRIPTION**

.0003 MIN ELECTRO ZINC AND BLACK CHROMATE. PER HERMAN MILLER SI-179 FINISH THREE. !!!MUST BE ROHS COMPLIANT!!!

**APPEARANCE**

BLACK

**ADHESION AND DUCTILITY**

PER SI-179 FINISH THREE

**CORROSION REQUIREMENTS**

RED RUST: 96

WHITE CORRIOSION:

PER SI-179 FINISH THREE

**COATING THICKNESS REQUIREMENTS**

PER SI-179 FINISH THREE

**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**

HERMAN MILLER SI-179 FINISH THREE

PRINT DATE:

6/3/2016