

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

QN-4 ORGNC-EZINC-BAKE-CHROMATE-RoHS

QN

4

REV DATE: 3/24/2016

GENERAL DESCRIPTION

BLACK ORGANIC RESIN OVER .00035 MIN ELECTROPLATED ZINC & BLACK CHROMATE (ZINC PLUS)
!!!MUST BE RoHS COMPLIANT!!!

APPEARANCE

SMOOTH GLOSSY BLACK APPEARANCE

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 500

WHITE CORRIOSION: 240

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN THICKNESS: ZINC :.0003 ORGANIC RESIN: 30% VISCOSITY.
MAX THICKNESS: ZINC: .0005 ORGANIC RESIN 35% VISCOSITY.
PER ASTM E376

THICKNESS SHALL BE TESTED

STRESS RELIEF

PARTS TO BE BAKED AT 400 DEGREES F FOR 4 HOURS WITHIN 2 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

MILLER SPEC 168469 REV J

PRINT DATE:

6/3/2016