

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

RA-0 EZINC-BAKE-CHROMAT-RoHS

RA

0

REV DATE: 4/1/2007

GENERAL DESCRIPTION

ELECTRO-ZINC---.0003 MIN. TRIVALENT CHROMATE, LEACHED AND SEALED, INTEGRAL TORQUE LUBRICANT !!!MUST BE RoHS COMPLIANT!!!

APPEARANCE

GLOSSY UNIFORM COLOR LEACHED TO A SILVER-WHITE IN A SEALER

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 384

WHITE CORRIOSION: 96

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 8 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

FORD S437(WSS-M21P17-B3) GE F70B21C2 ASTM F1941-2015 FE/ZN 3AN CORE < R"C" 40

PRINT DATE:

3/31/2017