

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

RS-0 EZINC-BLACK-RIE 4001

RS

0

REV DATE: 2/12/2013

GENERAL DESCRIPTION

.0005 MIN ELECTRO ZINC, BAKE, FOLLOWED BY BLACK CHROMATE FOLLOWED BY 2 COATS OF RIE 4001

APPEARANCE

BLACK APPEARANCE

ADHESION AND DUCTILITY

TO BE TESTED IN ACCORDANCE WITH ASTM B571 FOR BASE PLATE

CORROSION REQUIREMENTS

RED RUST: 400

WHITE CORROSION: 96

SALT SPRAY TESTS TO BE PERFORMED PER ASTM

COATING THICKNESS REQUIREMENTS

BASE PLATE MIN THICKNESS .0005 MAX THICKNESS
.0007

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

PRINT DATE:

6/6/2016