

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

RV-0 EZINC-BLACK-RIE 4037A-RIE 5250

RV

0

REV DATE: 3/13/2017

GENERAL DESCRIPTION

.0002 MIN. EZINC, BAKE, FOLLOWED BY CLEAR CHROMATE. 2 TOPCOATS OF RIE 4037A AND 1 FINAL COAT OF 5250 CLEAR COAT

APPEARANCE

BLACK

ADHESION AND DUCTILITY

TO BE TESTED IN ACCORDANCE WITH ASTM B571 FOR BASE PLATE.
COEFFICIENT OF FRICTION: .09-.15 FOR RIE 4037A

CORROSION REQUIREMENTS

RED RUST: 500

WHITE CORRIOSION: 72

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

BASE COAT: MIN THICKNESS: .0002 MAX THICKNESS: .0005
DRY FILM THICKNESS: MIN THICKNESS: .00024-.00031
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

ARCTIC CAT 1623-178 RIE 4037A RIE 5250

PRINT DATE:

3/13/2017