

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

RW-0 EZINC-BLACK CHROMATE

RW

0

REV DATE: 5/15/2008

GENERAL DESCRIPTION

.00035 MIN. ELECTRO ZINC AND BLACK CHROMATE

APPEARANCE

SHINY BLACK

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 120

WHITE CORRIOSION: 48

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN. THICKNESS .00035 MAX. THICKNESS .00055 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

GM4345M 9D 120/48 (BLACK)

PRINT DATE:

6/6/2016