

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

RX-1 EZINC-BLACK-MAGNI23

RX

1

REV DATE: 7/24/2009

GENERAL DESCRIPTION

.0002 MIN ELECTROZINC WITH BLACK CHROMATE PLUS 2 COATS OF MAGNIGARD BLACK 23

APPEARANCE

MATTE BLACK APPEARANCE

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 108

WHITE CORRIOSION: 72

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN. THICKNESS .0002 MAX THICKNESS .0004 TESTED PER ASTM E376

STRESS RELIEF

CURE EACH COAT AT 400-425 DEGREES F PMT MAXIMUM ALLOWABLE HEAD FILL OR SHRINKAGE 3%

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