

# ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH  
CODE

REVISION  
LEVEL

**BRIEF DESCRIPTION:**

TD-6 MZINC-TIN-YELLOW-SEAL

**TD**

**6**

REV DATE: 5/16/2008

**GENERAL DESCRIPTION**

ZINC, TIN ALLOY , 25% +/- 5% ALUMINUM. 75%+/-5% ZINC MECHANICALLY DEPOSITED WITH A MINIMUM THICKNESS OF .0025, YELLOW DICHROMATE. PARTS SHALL ADDITIONALLY BE COATED WITH A LEACHANT/ SEALANT AFTER DICHROMATING

**APPEARANCE**

A LIGHT YELLOW TO A DULL GREY-YELLOW COLOR WITH A UNIFORM APPEARANCE, FREE FROM BLISTERS AND VOIDS

**ADHESION AND DUCTILITY**

BURNISH BY WATER POLISHING TO CONSOLIDATE THE COATING. TO BE TESTED IN ACCORDANCE TO ASTM B571 (SCOTCH TAPE TEST)

**CORROSION REQUIREMENTS**

RED RUST: 1500

WHITE CORRIOSION: 0

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

**COATING THICKNESS REQUIREMENTS**

MECHANICAL ZINC TIN ALLOY .0025" MINIMUM

**STRESS RELIEF**

NOT REQUIRED

**QUALITY CONTROL**

PROBE RECESS FOR LOOSE PARTICLES AND SCOTCH TAPE TEST. SALT SPRAY THICKNESS BY MICROSCOPIC SECTION  
VISUALLY INSPECT FOR UNIFORMITY OF COLOR AND SURFACE APPEARANCE, FREEDOM FROM TEARS, BARE SPOTS, POWDERY FILM, SLOUGHING OFF OF FILM, AND BLISTERING

**PROCESS TO**

NOTE: THIS FINISH IS A ACCEPTABLE SUBSTITUTE FOR MECHANICAL CAD

PRINT DATE:

6/7/2016