

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

TP-3 EZINC-BAKE-CHROMAT-PTHEAD-UVWAX-RoHS

TP

3

REV DATE: 8/21/2017

GENERAL DESCRIPTION

J&M PLATING: ZINC ELECTROPLATE WITH A THICKNESS OF .00015" TO .00035"
DLP: PAINT HEAD WHITE PER COLOR WURTH WHITE AND WAX WITH UV TRACER.
!!!MUST BE RoHS COMPLIANT!!!

APPEARANCE

BODY TO BE BRIGHT, SILVERY COLOR, UNIFORM SURFACE APPEARANCE, AND FREE OF BLISTERS
TOP OF HEAD TO BE A SMOOTH WHITE APPEARANCE

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 24

WHITE CORRIOSION: 8

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

ZINC: MIN THICKNESS: .00015" MAX THICKNESS: .00035"
THICKNESS SHALL BE TESTED PER ASTM E376

STRESS RELIEF

FERROUS PARTS: STANDARD BAKE AT 400° F FOR 4 HOURS MINIMUM

QUALITY CONTROL

VISUALLY INSPECT FOR UNIFORMITY OF COLOR AND SURFACE APPEARANCE, FREEDOM FROM TEARS, BARE SPOTS, POWDERY FILM, SLOUGHING OFF OF FILM, AND BLISTERING, EXCESSIVE WAX

PROCESS TO

COLOR WURTH WHITE

PRINT DATE:

8/21/2017