

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

TU-0 EZINC-BAKE-CHRMATE-PTHEAD

TU

0

REV DATE: 4/1/2007

GENERAL DESCRIPTION

.0002 MIN ZINC ELECTROPLATE WITH A CLEAR CHROMATE POST FINISH. PAINT HEAD STAINLESS PER GE COLOR CHIP #14H2242. MUST USE POLY-URETHANE PAINT TO PREVENT CHIPPING.

APPEARANCE

TOP OF HEAD TO HAVE A SMOOTH SHINY STAINLESS APPEARANCE

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST:

WHITE CORRIOSION:

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN THICKNESS: .0002 MAX THICKNESS: .0004
SHALL BE TESTED PER ASTM E376

THICKNESS

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. MUST USE POLYEURATHANE PAINT TO PREVENT CHIPPING

PROCESS TO

GE 14H2242-STAINLESS

PRINT DATE:

6/7/2016