

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

TX-2 EZINC-BAKE-CHRMATE-PTHEAD

TX

2

REV DATE: 4/1/2007

GENERAL DESCRIPTION

.0002 ZINC ELECTROPLATE WITH A DICHROMATE POST FINISH. PAINT HEAD ALMOND PER COLOR CHIP #0005 (12H2428). MUST USE POLY-URETHANE PAINT TO PREVENT CHIPPING.

APPEARANCE

HEADS TO BE UNIFORM ALMOND COLOR, FREE FROM BLISTERS AND EXCESS PAINT IN THE RECESS. BODY OF SCREW TO BE UNIFORM YELLOW COLOR

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

THICKNESS 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

GE F70B4A2 PAINTED PER GE F50L014(12H2428)

PRINT DATE:

6/7/2016