

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

UA-1 DORRLTECH GMW3359 TYPE B

UA

1

REV DATE: 6/23/2021

GENERAL DESCRIPTION

DIP AND SPIN PHOSPHATE, ZINC, ORGANIC COATING, NO ACID PICKLE

APPEARANCE

THE COATING SHALL HAVE A UNIFORM GRAY APPEARANCE AND SHALL BE FREE FROM TEARS AND SAGS, AND EXCESS COATING. THE COATING SHALL NOT BE OILY OR TACKY TO THE TOUCH.

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 480

WHITE CORRIOSION: 144

SALT SPRAY TESTS TO BE PERFORMED PER ISO 9227 (NSS)

COATING THICKNESS REQUIREMENTS

MIN THICKNESS: 12um MAX THICKNESS:20 um
THICKNESS SHALL BE TESTED PER ASTM E376

STRESS RELIEF

NOT REQUIRED

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

GMW3359 TYPE B

PRINT DATE:

6/23/2021