

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

UL-1 EZINC-BAKE-PTHEAD-UVWAX

UL

1

REV DATE: 4/1/2007

GENERAL DESCRIPTION

ZINC ELECTROPLATE .0002 MINIMUM WITH AN ALKALINE LEACHED DICHROMATE POST FINISH. PAINT HEAD APPLIANCE BLACK PER COLOR CHIP #0012. SOME FASTENERS MAY HAVE A MYLAR WASHER INSTALLED. THIS OPERATION MUST BE COMPLETED BETWEEN ELECTROPLATING AND PAINTING THE HEAD. A FINAL WAX FILM IS APPLIED AFTER PAINTING THE HEAD. ONLY USE POLY-ETHYLENE PAINT TO PREVENT CHIPPING

APPEARANCE

HEAD TO BE UNIFORM BLACK COLOR FREE FROM BLISTERS AND EXCESS PAINT IN THE RECESS. BODY OF SCREW TO BE CLEAR SILVER WHITE COLOR.

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 60

WHITE CORRIOSION: 24

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN THICKNESS: .0002 MAX THICKNESS: .0004
THICKNESS SHALL BE 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 F70B7B2 PAINTED PER GE F50L014 (12H2454)

PRINT DATE:

6/8/2016