

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

UQ-1 EZINC-BAKE-MAGNI 536-GRAY

UQ

1

REV DATE: 7/11/2011

GENERAL DESCRIPTION

.0002 MIN. ELECTRO ZINC WITH CLEAR TRIVALENT CHROMATE FOLLOWED BY MAGNI 536 GRAY

APPEARANCE

SILVER GRAY COLOR

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 1000

WHITE CORRIOSION:

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN. THICKNESS .0002 MAX. THICKNESS .0004 ELECTRO ZINC 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

PMT MAXIMUM ALLOWABLE HEADFILL AN OR SHRINKAGE 3% VISUALLY INSPECT FOR UNIFORMITY OF COLOR AND SURFACE APPEARANCE, FREEDOM FROM TEARS, BARE SPOTS, POWDERY FILM, SLOUGHING OFF OF FILM, AND BLISTERING

PROCESS TO

PRINT DATE:

6/8/2016