

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

UT-4 EZINC-BAKE-CHRMAT-MAGNGRD-RoHS

UT

4

REV DATE: 12/8/2017

GENERAL DESCRIPTION

MAGNIGARD SILVER 18 & MAGNIGARD DORRITECH B18 APPLIED OVER
.0002 MINIMUM ZINC TRIVALENT ELECTROPLATE
!!!MUST BE RoHS COMPLIANT!!!

APPEARANCE

MATTE SILVER GREY APPEARANCE

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 1000

WHITE CORRIOSION: 0

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN THICKNESS: .0002 MAX THICKNESS:. 0003
THICKNESS SHALL BE TESTED PER ASTM E376

STRESS RELIEF

CURE EACH COAT AT 400-425 DEGREES F

QUALITY CONTROL

PMT MAXIMUM ALLOWABLE HEADFILL AND/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

FORD WSA-M21P26-A2

PRINT DATE:

11/27/2018