

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

UU-1 EZINC-BAKE-MAGNI 536-RoHS

UU

1

REV DATE: 5/20/2019

GENERAL DESCRIPTION

.0002 MIN ELECTROPLATED ZINC TRICHROMATE FOLLOWED BY TOPCOAT OF MAGNI B36.
!!!MUST BE RoHS COMPLIANT!!!

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: 0

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

EZINC: MIN THICKNESS: .0002 MAX THICKNESS:. 0003
TOPCOAT: MIN THICKNESS: .0003 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

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 WSL-M1A325-A1

GM 6295M

PRINT DATE:

5/20/2019