

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

VD-0 EZINC-BAKE-CHROMAT-PTHEAD

VD

0

REV DATE: 4/1/2007

GENERAL DESCRIPTION

ZINC ELECTROPLATE .0002 MINIMUM WITH A YELLOW DICHROMATE POST FINISH. PAINT HEAD BLACK PER COLOR CHIP #12H2455. USE POLY-URETHANE PAINT TO PREVENT CHIPPING.

APPEARANCE

HEAD OF SCREW TO BE UNIFORM BLACK

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 108

WHITE CORRIOSION: 72

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 F70B4D2 PAINTED PER GE F50L014

PRINT DATE:

6/8/2016