

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

VF-2 RIE 4001-BLACK-ROHS

VF

2

REV DATE: 4/20/2017

GENERAL DESCRIPTION

RIE 4001 IS A DRY TO THE TOUCH THERMOSETTING EPOXY COATING. THIS TOP COAT IS RoHS COMPLIANT. TOP COAT APPLIED OVER .0003 MIN ELECTROZINC FOLLOWED BY YELLOW DYE MUST BE RoHS COMPLIANT.

APPEARANCE

LOW GLOSS BLACK

ADHESION AND DUCTILITY

PER RIE 4001 PROCESS

CORROSION REQUIREMENTS

RED RUST: 1000

WHITE CORRIOSION:

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

BASE COAT: MIN. THICKNESS: .0003 MAX THICKNESS: .0005 CORROSION: 120 RED 72 WHITE
TOP COAT PER RIE 4001 PROCESS

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

PRINT DATE:

3/22/2018