

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

VG-2 EZINC-BAKE-PTHEAD-UVWAX

VG

2

REV DATE: 9/11/2017

GENERAL DESCRIPTION

.0002 MIN ELECTROPLATE ZINC & DICHROMATE (ALKALINE LEACHED TO CLEAR). PAINT HEAD BISQUE PER GE 14H2322. A FINAL WAX WILM WITH UV TRACER WAX IS APPLIED AFTER PAINTING THE HEAD. USE ONLY POLY-URETHANE PAINT TO PREVENT CHIPPING. IF INSTALLING A MYLAR WASHER, THIS OPERATION MUST BE COMPLETED BETWEEN ELECTROPLATING AND PAINTING.

APPEARANCE

CLEAR BRIGHT COLOR REFLECTING THE BRIGHT SHINY ZINC WITH A SMOOTH LOW FRICTION FEEL. HEAD OF SCREW TO HAVE A BISCUIT (BROWN) APPEARANCE.

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 60

WHITE CORRIOSION: 24

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 COLOR CHIP 142322 (BISQUE)

PRINT DATE:

9/11/2017