

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

WD-2 EZINC-BAKE-CHROMATE-ROHS

WD

2

REV DATE: 4/1/2007

GENERAL DESCRIPTION

.0002 MINIMUM ELECTROPLATED ZINC, WITH SINGLE DIP BLUE-BRIGHT TRIVALENT CHROMATE (MUST BE HEXAVALENT FREE) !!!MUST BE RoHS COMPLIANT!!!

APPEARANCE

CLEAR, BLUE-BRIGHT COLOR REFLECTING THE BRIGHT SHINY ZINC

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 168

WHITE CORRIOSION: 96

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 8 HOURS WITHIN 1 HOUR OF BASE PLATE

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

ROCKWELL (AB) NO 40001-051-16

PRINT DATE:

6/13/2016