

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

WH-4 EZINC-BAKE-HEXFREE-ROHS

WH

4

REV DATE: 8/6/2015

GENERAL DESCRIPTION

.0002 MINIMUM ELECTROPLATED ZINC/TIN ALLOY WITH A SUPPLEMENTARY HEXAVALENT CHROMIUM FREE SURFACE TREATMENT. PLATING COMPOSITION 30% ZINC AND 70% TIN ALLOY, FOLLOWED BY WAX APPLICATION. !!!MUST BE RoHS COMPLIANT!!!

APPEARANCE

BRIGHT SILVERY APPEARANCE

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 288

WHITE CORROSION: 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 190° +/- 5 C 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

FORD WSS-M13P7-A

PRINT DATE:

6/13/2016