

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

WK-0 EZINC-BAKE-UVWAX-ROHS

WK

0

REV DATE: 4/1/2007

GENERAL DESCRIPTION

.0002 MINIMUM ELECTRO ZINC AND TRIVALENT CHROMATE WITH YELLOW DYE, FOLLOWED BY A WAX DIP WITH UV TRACER, TO MEET GM4345M CODE 5D104/72 !!!MUST BE RoHS COMPLAINT!!!

APPEARANCE

SHINY YELLOW APPEARANCE PER GM4345M CODE 5D104/72

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 4 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

GM4345M CODE 5D104/72

PRINT DATE:

6/13/2016