

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

WM-0 MZINC-BAKE-ROHS

WM

0

REV DATE: 4/1/2007

GENERAL DESCRIPTION

MECHANICALLY DEPOSITED ZINC PLATING ON STEEL WITH A MINIMUM THICKNESS OF .00015" WITH A SINGLE DIP OF CLEAR CHROMATE FINISH TRIVALENT !!!MUST BE RoHS COMPLIANT!!!

APPEARANCE

CLEAR, SILVERY FINISH IS REQUIRED WITH UNIFORM SURFACE APPEARANCE, AND FREEDOM FROM BLISTERS, VOIDS IN DEPOSITS AND BARE SPOTS SHOWING THE BASE METAL.

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 24

WHITE CORRIOSION: 12

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN THICKNESS: .00015 MAX THICKNESS: .00035
THICKNESS SHALL BE TESTED PER ASTM E376

STRESS RELIEF

NOT REQUIRED

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:

6/13/2016