

# ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH  
CODE

REVISION  
LEVEL

**BRIEF DESCRIPTION:**

WP-0 GMW4205-ZINC-BAKE-ROHS

**WP**

**0**

REV DATE: 4/1/2007

**GENERAL DESCRIPTION**

HEXAVALENT FREE ZINC / NICKEL, FOLLOWED BY A CORROSION RESISTANT BLACK FINISH PER GMW4205  
!!!MUST BE RoHS COMPLIANT!!!

**APPEARANCE**

MUST CONFORM TO REQUIREMENTS OF GMW4205

**ADHESION AND DUCTILITY**

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

**CORROSION REQUIREMENTS**

RED RUST: 480

WHITE CORRIOSION: 144

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

**COATING THICKNESS REQUIREMENTS**

MAX THICKNESS 45 MICRONS

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. MUST CONFORM TO REQUIREMENTS OF GMW4205

**PROCESS TO**

GMW4205 (ZINC/NICKEL ALLOY)

PRINT DATE:

6/13/2016