

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

WQ-0 GMW4700-ZINC-BAKE-ROHS

WQ

0

REV DATE: 4/1/2007

GENERAL DESCRIPTION

HEXAVALENT FREE ZINC/NICKEL WITH SUPPLEMENTARY BLACK TREATMENT, PER GMW4700 (Zi-Ni BLACK)
!!!MUST BE RoHS COMPLIANT!!!

APPEARANCE

CLEAN COMMERCIAL FINISH PER GMW4700

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 480

WHITE CORRIOSION: 0

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN THICKNESS: .0003 MAX THICKNESS: .0005
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

PROCESS TO

GMW4700 (Zi-Ni) BLACK

PRINT DATE:

6/13/2016