

# ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH  
CODE

REVISION  
LEVEL

**BRIEF DESCRIPTION:**

WR-0 EZINC-BAKE-CHROMATE-ROHS

**WR**

**0**

REV DATE: 4/1/2007

**GENERAL DESCRIPTION**

ELECTROPLATED ZINC WITH A MINIMUM OF .00015" YELLOW TRIVALENT CHROMATE POST FINISH TO PROVIDE A HIGHER DEGREE OF CORROSION PROTECTION !!!MUST BE RoHS COMPLIANT!!!

**APPEARANCE**

GLOSSY, UNIFORM YELLOW COLOR

**ADHESION AND DUCTILITY**

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

**CORROSION REQUIREMENTS**

RED RUST: 48

WHITE CORRIOSION: 24

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

**COATING THICKNESS REQUIREMENTS**

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

**STRESS RELIEF**

HYDROGEN EMBRITTEMENT: FERROUS PARTS: STANDARD BAKE AT 400 DEGREES F FOR 4 HOURS MINIMUM. BAKING MUST PRECEED ANY POST FINISH PROCEDURE.

**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