

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

WS-1 EZINC-BAKE-CHROMATE-UVWAX

WS

1

REV DATE: 8/10/2021

GENERAL DESCRIPTION

.00015 MINIMUM ELECTROPLATED ZINC, 8 HOUR BAKE AND GREEN TRIVALENT CHROMATE (MUST BE HEXAVALENT FREE), FOLLOWED BY A WAX DIP WITH UV TRACER

APPEARANCE

BRIGHT IRRIDESCENT GREEN APPEARANCE

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

PARTS TO BE BAKED AT 400 DEGREES F FOR 8 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

ROCKWELL (AB) 40001-051-18

PRINT DATE:

8/10/2021