

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

WW-0 EZINC-BAK-UNICOTC120-RoHS

WW

0

REV DATE: 4/1/2007

GENERAL DESCRIPTION

ELECTRO ZINC .0003 THICK, WITH TRIVALENT CLEAR CHROMATE POST FINISH TO PROVIDE A HIGHER DEGREE OF CORROSION PROTECTION !!!MUST BE RoHS COMPLIANT!!!

APPEARANCE

GLOSSY UNIFORM COLOR SILVER IN APPEARANCE

ADHESION AND DUCTILITY

COATING MUST BE UNIFORM IN COLOR, FREE OF POWDERYNESS, AND SLOUGHING OFF OF FILM. ADHESION AND DUCTILITY WILL BE TESTED IN ACCORDANCE WITH ASTM B571

CORROSION REQUIREMENTS

RED RUST: 500

WHITE CORRIOSION: 120

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

ZINC: MIN THICKNESS: .0003" MAX THICKNESS: .0005"
THICKNESS TO BE TESTED IN ACCORDANCE WITH ASTM E376

STRESS RELIEF

STANDARD BAKE AT 400 DEGREES F FOR 4 HOURS MINIMUM AFTER ZINC ELECTROPLATE AND PRIOR TO CHROMATE BEING APPLIED

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

UNICOTE C120 CHEM PLATE INDUSTRIES

PRINT DATE:

6/13/2016