

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

XA-2 EZINC-BAKE-PTHEAD-RoHS

XA

2

REV DATE: 9/11/2017

GENERAL DESCRIPTION

.0002 MINIMUM ELECTROPLATED ZINC, WITH TRIVALENT CHROMATE (MUST BE HEXAVALENT FREE). PAINT HEADS PER GE COLOR CHIP NO. 14H2322. USE ONLY POLY-URETHANE PAINT TO PREVENT CHIPPING !!!MUST BE RoHS COMPLIANT!!!

APPEARANCE

CLEAR BRIGHT COLOR REFLECTING THE BRIGHT SHINY ZINC WITH A SMOOTH LOW FRICITON FEEL. HEAD TO BE PAINTED BISCUIT (BROWN) AND HAVE A SMOOTH APPEARANCE

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 168

WHITE CORRIOSION: 96

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN THICKNESS: .0002 MAX THICKNESS: .0004
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

GE COLOR CHIP 14H2322 (BISQUE)

PRINT DATE:

9/11/2017