

# ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH  
CODE

REVISION  
LEVEL

**BRIEF DESCRIPTION:**

**XD-0 EZINC-BAKE-CHRMT-PTHD**

**XD**

**0**

REV DATE: 4/1/2007

**GENERAL DESCRIPTION**

.0002 MINIMUM ELECTRO ZINC, WITH TRIVALENT CHROMATE (MUST BE HEXAVALENT FREE). PAINT HEAD PER GE COLOR CHIP NO 12H2428. USE ONLY POLY-URETHANE PAINT TO PREVENT CHIPPING

**APPEARANCE**

CLEAR BRIGHT COLOR REFLECTING THE BRIGHT SHINY ZINC WITH A SMOOTH LOW FRICTION FEEL. HEAD TO BE PAINTED ALMOND (TAN) AND HAVE A SMOOTH FINISH

**ADHESION AND DUCTILITY**

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

**CORROSION REQUIREMENTS**

RED RUST: 1685

WHITE CORRIOSION: 96

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

**COATING THICKNESS REQUIREMENTS**

MIN THICKNESS: .0002

MAX THICKNESS: .0004 SALT SPRAY TESTS TO BE PERFORMED 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 12H2428 (ALMOND)

PRINT DATE:

6/14/2016