

# ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH  
CODE

REVISION  
LEVEL

**BRIEF DESCRIPTION:**

XF-1 EZINC-BAKE-PTHEAD-RoHS

**XF**

**1**

REV DATE: 1/6/2010

**GENERAL DESCRIPTION**

.0002 MINIMUM ELECTRO ZINC, WITH TRIVALENT CHROMATE (MUST BE HEX FREE) PAINT HEAD PER GE COLOR CHIP NO 12H2455. 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 FRICTION FEEL. HEAD TO BE PAINTED BLACK 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 12H2455

PRINT DATE:

6/14/2016