

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

XG-1 EZINC-YELLOW-RoHS

XG

1

REV DATE: 1/31/2012

GENERAL DESCRIPTION

ZINC ELECTROPLATE, WITH A MINIMUM THICKNESS OF .0003. YELLOW TRIVALENT POST FINISH IS APPLIED TO PROVIDE A HIGHER DEGREE OF CORROSION PROTECTION.
!!!MUST BE RoHS COMPLIANT!!!

APPEARANCE

GLOSSY UNIFORM YELLOW COLOR

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: .0003" MAX THICKNESS: .0005"
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
BAKING MUST PRECEDE ANY POST FINISH PROCEDURE

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

ASTM 0633

PRINT DATE:

6/14/2016