

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

XH-0 EZINC-SEAL 90C-ROHS

XH

0

REV DATE: 4/1/2007

GENERAL DESCRIPTION

ZINC ELECTROPLATE, WITH A MINIMUM THICKNESS OF .0003". CLEAR TRIVALENT PLUS SEALER POST FINISH IS APPLIED TO PROVIDE A HIGHER DEGREE OF CORROSION PROTECTION.
!!!MUST BE ROHS COMPLIANT!!!

APPEARANCE

GLOSY UNIFORM COLOR

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 500

WHITE CORROSION: 0

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

ZINC: MIN THICKNESS: .0003

MAX THICKNESS: .0005 THICKNESS SHALL BE TESTED PER ASTM E376

STRESS RELIEF

STANDARD BAKE AT 400 DEGREES F FOR 4 HOURS MINIMUM. 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 B633

SOUTHCO S-114-10

PRINT DATE:

6/14/2016