

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

XP-0 EZINC-BAKE-PTHEAD-ROHS

XP

0

REV DATE: 5/6/2011

GENERAL DESCRIPTION

.0005 MIN. ELECTROZINC WITH TRI-CHROME (HIGH BUILD, NO SEALER), PAINT HEAD PER GE COLOR CHIP NO. 12H2427. 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. HEADS TO BE PAINTED WHITE AND HAVE A SMOOTH APPEARANCE.

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 196

WHITE CORRIOSION: 96

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

.0005 MIN. THICKNESS TO BE TESTED PER ASTM E376

STRESS RELIEF

PARTS TO BE BAKED AT 400 DEGRESS 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 12H2427

PRINT DATE:

6/14/2016