

# ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH  
CODE

REVISION  
LEVEL

## BRIEF DESCRIPTION:

XR-2 EZINC-BAKE-CLR-TRIVALENT-RoHS

**XR**

**2**

REV DATE: 11/4/2019

## GENERAL DESCRIPTION

ZINC ELECTROPLATE, WITH A MINIMUM THICKNESS OF .00047" CLEAR TRIVALENT POST FINISH IS APPLIED TO PROVIDE A HIGHER DEGREE OF CORROSION PROTECTION.  
!!!MUST BE RoHS COMPLIANT!!!

## APPEARANCE

GLOSSY UNIFORM COLOR

## ADHESION AND DUCTILITY

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

## CORROSION REQUIREMENTS

RED RUST: 144

WHITE CORROSION:

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

## COATING THICKNESS REQUIREMENTS

MIN THICKNESS: .00047                      MAX THICKNESS: .00067  
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

ASTM B633 SC3 TYPE VI    SOUTHCO S-114-05

PRINT DATE:

11/4/2019