

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

XS-0 EZINC-BAKE-TRI-DYE-RoHS

XS

1

REV DATE: 10/19/2016

GENERAL DESCRIPTION

.0003 MINIMUM ELECTROPLATED ZINC, WITH TRI-CHROME (CLEAR, HEX-CHROME FREE, NO SEALER) HIGH BUILD WITH GREEN DYE AND UV TRACER WAX
!!!MUST BE RoHS COMPLIANT!!!

APPEARANCE

GLOSSY GREEN

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 4 HOURS WITH 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

PRINT DATE:

10/19/2016