

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

YE-0 EZINC-BAK-PTHD-UVWAX-RoHS

YE

0

REV DATE: 4/9/2007

GENERAL DESCRIPTION

.0002" MINIMUM ELECTRO ZINC, HIGH BUILD TRI-CHROME. PAINT HEAD BISQUE PER GE COLOR CHIP NO.14H2322. USE ONLY POLY-URETHANE PAINT TO PREVENT CHIPPING . A FINAL WAX FILM IS APPLIED AFTER PAINTING THE HEAD. IF MYLAR WASHER REQUIRED, THIS OPERATION TO BE COMPLETED BETWEEN ELECTROPLATING AND PAINTING THE HEAD.

!!!MUST BE RoHS COMPLIANT!!!

APPEARANCE

CLEAR BRIGHT COLOR REFLECTING THE BRIGHT SHINY ZINC WITH A SMOOTH LOW FRICTION FEEL. HEAD TO BE PAINTED BISCUT (BROWN) AND HAVE A SMOOTH APPEARANCE.

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: .0002 MAX THICKNESS: .0004

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

GE COLOR CHIP 14H2322 (BISQUE)

PRINT DATE:

9/11/2017