

# ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH  
CODE

REVISION  
LEVEL

**BRIEF DESCRIPTION:**

YF-0 EZINC-BAK-PTHD-UVWAX-RoHS

**YF**

**0**

REV DATE: 4/9/2007

**GENERAL DESCRIPTION**

.0002 MINIMUM ELECTRO ZINC, HIGH BUILD TRI-CHROME. PAINT HEAD BLACK PER GE COLOR CHIP NO 12H2454. 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 BLACK (GE 12H2454) AND HAVE A SMOOTH FINISH

**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 TO 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 12H2454 (BLACK)

PRINT DATE:

6/14/2016