

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

YM-3 EZINC-CLR-RoHS-E37 TOPCOAT BLK

YM

3

REV DATE: 10/23/2018

GENERAL DESCRIPTION

.0003 MIN. ELECTRO ZINC CLEAR TRIVALENT CHROMATE (NO SEALER)
FOLLOWED BY TWO COATS OF E37 TOP COAT BLACK
!!!MUST BE RoHS COMPLIANT!!!

APPEARANCE

BLACK

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: TBD

WHITE CORRIOSION: TBD

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

ZINC PLATING: MIN. THICKNESS .0003 MAX. THICKNESS .0005
TESTED PER ASTM E376

STRESS RELIEF

BAKE 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.

TORX RECESSES MAY NOT GAGE PROPERLY AFTER PLATING

PROCESS TO

PRINT DATE:

10/23/2018