

# ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH  
CODE

REVISION  
LEVEL

**BRIEF DESCRIPTION:**

ZD-0 EZINC-SEAL-PTHEAD-ROHS

**ZD**

**0**

REV DATE: 12/13/2011

**GENERAL DESCRIPTION**

.0003 MIN. ELECTRO ZINC WITH CLEAR TRICHROMATE AND SEALER. PAINT HEAD PER GE COLOR CHIP NO. 12H2427. USE ONLY POLY-URETHANE PAINT TO PREVENT CHIPPING.  
!!!MUST BE ROHS COMPLIANT!!!

**APPEARANCE**

CLEAR BRIGHT COLOR REFLECTING THE BRIGHT SHINY ZINC WITH A SMOOTH LOW FRICTION FEEL. HEADS TO BE PAINTED WHITE AND HAVE A SMOOTH APPEARANCE

**ADHESION AND DUCTILITY**

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

**CORROSION REQUIREMENTS**

RED RUST: 500

WHITE CORRIOSION: 144

SALT SPRAY TEST TO BE PERFORMED PER ASTM B117

**COATING THICKNESS REQUIREMENTS**

MIN. THICKNESS .0003 MAX. THICKNESS .0005 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 12H2427

PRINT DATE:

6/14/2016