

# ITW SHAKEPROOF INDUSTRIAL PRODUCTS

**FINISH  
CODE**

**REVISION  
LEVEL**

**BRIEF DESCRIPTION:**

RA-1 EZINC-BAKE-CHROMAT W/FINIGARD 113G -RoHS

**RA**

**1**

REV DATE: 3/10/2023

**GENERAL DESCRIPTION**

ELECTRO-ZINC---.0003 MIN. TRIVALENT CHROMATE, LEACHED AND SEALED, INTEGRAL TORQUE LUBRICANT W/ELV 1500LT/ FINIGARD 113G !!!MUST BE RoHS COMPLIANT!!!

**APPEARANCE**

GLOSSY UNIFORM COLOR LEACHED TO A SILVER-WHITE IN A SEALER

**ADHESION AND DUCTILITY**

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

**CORROSION REQUIREMENTS**

RED RUST: 384

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 8 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**

FORD S437(WSS-M21P17-B3) GE F70B21C2 ASTM F1941-2015 FE/ZN 3AN CORE < R"C" 40

PRINT DATE:

3/14/2023