

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

ZINC PHOS-ENAMEL-BAKE-OIL

JN

0

REV DATE: 4/1/2007

GENERAL DESCRIPTION

ELECTROPLATED BAKE ENAMEL (BLACK) & OIL DRY TO TOUCH OVER ZINC PHOSPHATE

APPEARANCE

SMOOTH DENSE BLACK APPEARANCE

ADHESION AND DUCTILITY

PER SM 9071P (SCOTCH TAPE TEST)

CORROSION REQUIREMENTS

RED RUST: 240

WHITE CORROSION: 0

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN THICKNESS: PHOSPHATE:1500 MIL/FT2 MAX THICKNESS: PAINT .0005 THICKNESS SHALL BE TESTED PER ASTM E376

STRESS RELIEF

PARTS TO BE BAKED AT 225 DEGREES F FOR 2 HOURS WITHIN 1 HOUR OF BASE PLATING.

QUALITY CONTROL

VISUALLY INSPECT FOR UNIFORMITY OF COLOR AND SURFACE APPEARANCE, FREEDOM FROM RUNS, BLISTERING AND EXCESSIVE OIL VISUALLY INSPECT FOR UNIFORMITY OF COLOR & SURFACE APPEARANCE, FREEDOM FROM TEARS, BARE SPOT, POWDERY FILM. SLOUGHING OFF OF FILM & BLISTERING

EQUIVALENT SPECS

GM 6047M CHRYSLER PS-7902

APPROVED SUPPLIERS:

PRINT DATE:

3/19/2007