

# ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH  
CODE

REVISION  
LEVEL

**BRIEF DESCRIPTION:**

ORGANIC- ZINC PHOS

**KM**

**0**

REV DATE: 4/1/2007

**GENERAL DESCRIPTION**

BLACK FLOUROCARBON ORGANIC COATING OVER ZINC PHOSPHATE

**APPEARANCE**

SMOOTH, BLACK FINISH

**ADHESION AND DUCTILITY**

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

**CORROSION REQUIREMENTS**

RED RUST: 240

WHITE CORRIOSION: 0

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

**COATING THICKNESS REQUIREMENTS**

MIN THICKNESS: PHOSPHATE: 500 MILLIGRAMS PER SQUARE FOOT, MAX THICKNESS: FLUOROCARBON: .0005  
APPROX THICKNESS SHALL BE TESTED PER ASTM E376

**STRESS RELIEF**

STANDARD BAKE AT 400 DEGREES FARENHEIGHT FOR 2 HOURS WITHIN 1 HOUR OF BASE PLATING.

**QUALITY CONTROL**

VISUAL INSPECTION: COATING SHALL BE UNIFORM FREE FROM BARE SPOTS RUNS, DRIPS AND BLISTERING

**EQUIVALENT SPECS**

GM 6046M(13T240)

**APPROVED SUPPLIERS:**

PRINT DATE:

3/19/2007