

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

E ZINC-BAKE-CHROMATE

ND

2

REV DATE: 4/1/2007

GENERAL DESCRIPTION

.0002 MIN ELECTROPLATE ZINC & YELLOW DICHROMATE

APPEARANCE

GLOSSY UNIFORM YELLOW

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 108

WHITE CORROSION: 72

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN THICKNESS: .0002 MAX THICKNESS: .0004
THICKNESS SHALL BE TESTED PER ASTM E376

STRESS RELIEF

PASRTS TO BE BAKED AT 400 DEGREES F FOR 4 HURS WITHIN 1 HOUR OF BASE PLATING

QUALITY CONTROL

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

EQUIVALENT SPECS

GE F70B4A2(50-1251-2B)

FORD S36

GM 4345 6D96/46

APPROVED SUPPLIERS:

PRINT DATE:

3/19/2007