

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

ORGNC-EZINC-BAKE-CHROMATE

QN

2

REV DATE: 4/1/2007

GENERAL DESCRIPTION

BLACK ORGANIC RESIN OVER .00035 MIN ELECTROPLATED ZINC & BLACK CHROMATE (ZINC PLUS)

APPEARANCE

SMOOTH GLOSSY BLACK APPEARANCE

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 800

WHITE CORROSION: 300

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN THICKNESS: ZINC :.00035 ORGANIC RESIN: 30% VISCOSITY
THICKNESS:ZINC: .00055 ORGANIC RESIN 35% VISCOSITY
E376

THICKNESS SHALL BE TESTED PER ASTM
MAX

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 & SURFACE APPEARANCE, FREEDOM FROM TEARS, BARE SPOT,
POWDERY FILM. SLOUGHING OFF OF FILM & BLISTERING

EQUIVALENT SPECS

APPROVED SUPPLIERS:

PRINT DATE:
3/19/2007