

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

EZINC-BAKE-CHRMATE-PTHEAD

TV

2

REV DATE: 4/1/2007

GENERAL DESCRIPTION

.0002 ZINC ELECTROPLATE WITH AN ALKALINE LEACHED DICHROMATE POST FINISH. PAINT HEAD APPLIANCE WHITE PER COLOR CHIP #0007 (12H2427). MUST USE POLY-URETHANE PAINT TO PREVENT CHIPPING.

APPEARANCE

HEAD TO BE UNIFORM WHITE COLOR FREE FROM BLISTER AND EXCESS PAINT IN THE RECESS. BODY OF SCREW TO BE CLEAR SILVER WHITE COLOR

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 60

WHITE CORROSION: 24

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN THICKNESS: .0002

MAX THICKNESS: .0004

THICKNESS TESTED PER ASTM E376

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

GE F70B7B2 PAINTED PER GE F50L014 (12H2427)

APPROVED SUPPLIERS:

PRINT DATE:

3/19/2007