

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

EZINC-BAKE-PTHEAD-UVWAX

UJ

3

REV DATE: 4/1/2007

GENERAL DESCRIPTION

ZINC ELECTROPATED .0002 THICK MIN WITH AN ALKALINE LEACHED DICHROMATE POST FINISH. PAINT HEAD APPLIANCE WHITE PER CHIP 0007 12H2427. SOME FASTENERS MAY HAVE MYLAR WASHER INSTALLED, THIS OPERATION MUST BE COMPLETED BETWEEN ELECTROPLATING AND PAINTING THE HEAD. A FINAL WAX FILM IS APPLIED AFTER PAINTING HEAD. USE ONLY POLY-ETHYLENE PAINT TO PREVENT CHIPPING

APPEARANCE

HEAD TO BE UNIFORM WHITE COLOR, FREE FROM BLISTERS AND EXCESS PAINT IN THE RECESS. BODY OF SCREW TO BE 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 SHALL BE 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