

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

**FINISH
CODE**

**REVISION
LEVEL**

BRIEF DESCRIPTION:

XD-R EZINC-BAKE-CHRMT-PTHD

XD

0

REV DATE: 04/01/2007

GENERAL DESCRIPTION

.0002 MINIMUM LECTRO ZINC, WITH TRIVALENT CHROMATE (MUST BE HEXAVALENT FREE). PAINT HEAD PER GE COLOR CHIP NO 12H2428. USE ONLY POLY-URETHANE PAINT TO PREVENT CHIPPING

APPEARANCE

CLEAR BRIGHT COLOR REFLECTING THE BRIGHT SHINY ZINC WITH A SMOOTH LOW FRICTION FEEL. HEAD TO BE PAINTED ALMOND (TAN) AND HAVE A SMOOTH FINISH

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 1685

WHITE CORRIOSION: 96

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN THICKNESS: .0002 MAX THICKNESS: .0004 SALT SPRAY TESTS TO BE PERFORMED 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

PAINT CHIP: GE 12H2428 (ALMOND)

APPROVED SUPPLIERS:

PRINT DATE:

08/27/2008
