

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

**FINISH
CODE**

**REVISION
LEVEL**

BRIEF DESCRIPTION:

XE-0 EZINC-CLEAR-PTHD-ROHS

XE

0

REV DATE: 04/01/2007

GENERAL DESCRIPTION

.0002 MIN. ELECTRO ZINC WITH CLEAR TRIVALENT CHROMATE HEX AVALENT FREE. PAINT HEAD PER GE COLOR CHIP 14H2322 COLOR BISQUE. 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 BISQUE AND HAVE A SMOOTH APPEARANCE

ADHESION AND DUCTILITY

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

CORROSION REQUIREMENTS

RED RUST: 168

WHITE CORROSION: 96

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

MIN THICKNESS .0002 MAX THICKNESS .0004

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 F70B4D2 COLOR BISQUE PER 14H2322

APPROVED SUPPLIERS:

PRINT DATE:

07/06/2009