

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

LA-1 PHOSPHATE (ZINC)-NO OIL-RoHS

LA

1

REV DATE: 4/1/2007

GENERAL DESCRIPTION

ZINC PHOSPHATE COATING ON STEEL PARTS.

!!!MUST BE RoHS COMPLIANT!!!

APPEARANCE

UNIFORM GRAY TO BLACK CRYSTALLINE MATTE FINISH. COATING WILL BE FINE GRAINED AND DENSE AND FREE OF BARE SPOTS, HOLE AND GREENISH YELLOW OR BLUISH GRAY COLOR.

ADHESION AND DUCTILITY

N/A

CORROSION REQUIREMENTS

RED RUST:

WHITE CORRIOSION:

N/A

COATING THICKNESS REQUIREMENTS

PHOSPHATE: 1200 MILLIGRAMS PER SQUARE FOOT MINIMUM THICKNESS OF COATING AS DETERMINED BY STRIP AND WEIGHT METHOD ON A 2" x 2" #1010 OR #1050 CARBON STEEL CONTROL PANELS.

STRESS RELIEF

NOT REQUIRED

QUALITY CONTROL

VISUALLY INSPECT FOR UNIFORMITY OF COLOR AND SURFACE APPEARANCE, FREEDOM FROM OILY RESIDUE, BARE SPOTS AND EXCESSIVE WAX VISUALLY INSPECT FOR UNIFORMITY OF COLOR & SURFACE APPEARANCE, FREEDOM FROM TEARS, BARE SPOTS, POWDERY FILM. SLOUGHING OFF OF FILM & BLISTERING

PROCESS TO

PRINT DATE:

6/3/2016