

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

LB-2 ZINC-PHOS-OIL-RoHS

LB

2

REV DATE: 5/31/2016

GENERAL DESCRIPTION

ZINC PHOSPHATE COATING AND RUST PREVENTATIVE OIL FINISH ON STEEL PARTS.
!!!MUST BE RoHS COMPLIANT!!!

APPEARANCE

COATING WILL BE UNIFORM GRAY TO BLACK CRYSTALLINE OILED APPEARANCE AND FREE OF BARE SPOTS, HOLES AND EXCESS OIL.

ADHESION AND DUCTILITY

NOT APPLICABLE

CORROSION REQUIREMENTS

RED RUST: 72

WHITE CORRIOSION: 0

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

PHOSPHATE: 1100 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. THICKNESS SHALL BE TESTED PER ASTM E376

STRESS RELIEF

NOT REQUIRED

QUALITY CONTROL

VISUALLY INSPECT FOR UNIFORMITY OF COLOR AND SURFACE APPEARANCE, FREEDOM FROM OILY RESIDUE, BARE SPOTS AND EXCESSIVE WAX

PROCESS TO

GE F65A1A3 Ford S-2 GM4435M CODEA CHRYSLER PS-80

PRINT DATE:

6/3/2016