

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

LD-1 ZINC-PHOS-OIL DRY-RoHS

LD

1

REV DATE: 4/16/2019

GENERAL DESCRIPTION

ZINC PHOSPHATE COATING AND RUST PREVENTATIVE OIL FINISH ON STEEL PARTS.
MUST BE DRY TO TOUCH PER ASTM F1137.
!!!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: 24

WHITE CORRIOSION: 0

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

PHOSPHATE: 11 GRAMS PER SQUARE METER MINIMUM.
THICKNESS SHALL BE TESTED PER ASTM F1137 SECTION 5.3

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

B&S 612K CYCLE C

PRINT DATE:

4/16/2019