

# ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH  
CODE

REVISION  
LEVEL

**BRIEF DESCRIPTION:**

LL-3 ZINC PHOS-DRY OIL-ROHS

**LL**

**3**

REV DATE: 4/1/2007

**GENERAL DESCRIPTION**

ZINC PHOSPHATE COATING WITH A DRY TO TOUCH OIL FINISH SUCH THAT THERE IS NO OIL RESIDUE APPARENT WHEN HANDLED. **!!!MUST BE RoHS COMPLIANT!!!**

**APPEARANCE**

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

**ADHESION AND DUCTILITY**

NOT APPLICABLE

**CORROSION REQUIREMENTS**

RED RUST: 48

WHITE CORRIOSION:

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

**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 & SURFACE APPEARANCE, FREEDOM FROM TEARS, BARE SPOTS, POWDERY FILM. SLOUGHING OFF OF FILM & BLISTERING

**PROCESS TO**

GE F65A1A2 Ford S-58

PRINT DATE:

6/3/2016