

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

LR-0 EZINC IRON CLEAR- PHOS-WAX-UV

LR

0

REV DATE: 6/27/2016

GENERAL DESCRIPTION

E-ZINC BAKE IRON PHOSPHATE COATING AND UV WAX FINISH ON STEEL PARTS MUST BE DRY TO TOUCH

APPEARANCE

DRY SURFACE, UNIFORM SILVER APPEARANCE

ADHESION AND DUCTILITY

NOT APPLICABLE

CORROSION REQUIREMENTS

RED RUST: 36

WHITE CORRIOSION:

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

PHOSPHATE: 1000-4000 MILLIGRAMS PER SQ. FT MINIMUM THICKNESS OF COATING

STRESS RELIEF

-8 HOUR BAKE REQUIRED PER GE F65A1-

QUALITY CONTROL

PHOSPHATE THICKNESS TEST: 1000 MILLIGRAMS PER SQ. FT. MINIMUM THICKNESS OF COATING AS DETERMINED BY AN IN PROCESS TEST, INVOLVING A STRIP AND WEIGHT METHOD ON CONTROL PANELS OF #1010 OR #1015 CARBON STEEL. NO APPEARANCE OF EXCESS WAX AND CLEAN, UNIFORM SURFACE FREE FROM DIRT AND DRY TO TOUCH.

PROCESS TO

GE F65A1A4

PRINT DATE:

6/29/2016