

ITW SHAKEPROOF INDUSTRIAL PRODUCTS

FINISH
CODE

REVISION
LEVEL

BRIEF DESCRIPTION:

LW-3 ZINC-PHOS-DRY OIL-RoHS

LW

3

REV DATE: 3/1/2017

GENERAL DESCRIPTION

ZINC PHOSPHATE COATING WITH A DRY TO TOUCH OIL FINISH, SUCH THAT THERE IS NO OIL RESIDUE APPARENT WHEN HANDLED.

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: 72

WHITE CORRIOSION: 0

SALT SPRAY TESTS TO BE PERFORMED PER ASTM B117

COATING THICKNESS REQUIREMENTS

PHOSPHATE: 2000 MILLIGRAMS PER SQUARE FOOT MINIMUM THICKNESS OF COATING.
THICKNESS SHALL BE TESTED PER ASTM E376

STRESS RELIEF

NOT REQUIRED

QUALITY CONTROL

PHOSPHATE THICKNESS TEST: 2000 MILIGRAMS PER SQUARE FOOT. 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.

PROCESS TO

GE F65A1A2

GM6035M

PRINT DATE:

3/1/2017