



304 Stainless Steel with Xylan Nut

The T-Head Bolts supplied shall meet ASTM F593 304 Stainless Steel. T-Head Bolt shall be manufactured to the latest requirements of AWWA C111/A21.11-00. Bolts shall be ANSI/ASME B1.1 Class 2A thread fit and mate with B1.2 Class 2B Nuts.

Heavy Hex Nuts shall be manufactured to I/A/W ANSI/ASME B18.2.2 specifications. Heavy Hex Nuts shall conform to ASTM F594 304 Stainless Steel material specifications. Please see following page for Nut coating information.



V0118



1424 Xylan Coating

Nuts supplied by EGW Utilities, Inc., will be coated using Xylan 1424 and color coded blue and applied using a Whitford qualified applicator. The Nuts supplied with these T-Head Bolts are tapped oversize 0.010" to prevent any seizing problems in regards to the thickness of the coating. The thickness range of the Xylan-coating will be between 0.0007" to .0012". Please see below for the Whiteford Xylan-coating procedure that will be used.

1. Remove all grease and soils with alkaline cleaning solution.
2. Rinse with cold water.
3. Dry parts with hot air.
4. Grit blast with 46-80 grit alum oxide to white metal surface.
5. Remove excess grit with compressed air.
6. Zinc phosphate part to an evenly deposited crystalline grain to a dark grey color.
7. Rinse thoroughly in cold clean water.
8. Rinse thoroughly in hot water.
9. Dry parts in heated spin dryer or with compressed air.
10. Pre-heat parts to 160 degrees f.
11. Apply first coat of 1424.
12. Flash off solvents at 200 degrees f.
13. Rotate part and apply second coat of 1424.
14. Cure the coating for 15 minutes at 400 degrees f. This is part temp not air.
15. Inspect parts for adhesion, cure, and thickness (0.0007"-0.0012").
16. Visual inspection for blisters, running or other variations.
17. Package parts according to customers request.

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