316 Stainless Steel with Xylan Nut MJ Bolt Pack

The T-Head Bolts supplied shall be ASTM F593 316 Stainless Steel. T-Head Bolt shall be manufactured to the latest requirements of AWWA C111/A21.11-00. Bolts shall be manufactured with a class 2A thread fit and mate with class 2B Nuts.

Heavy Hex Nuts shall be manufactured to the latest requirements of AWWA C111/A21.11-00 and meet dimensional specification ANSI/ASME B16. Heavy Hex Nuts shall be ASTM F594 304 Stainless Steel. Please see following page for Nut coating information.

Gaskets for mechanical joints shall be manufactured from vulcanized styrene butadiene rubber (SBR). Gaskets shall meet the latest requirements of ANSI/AWWA C111/A21.11-00. MJ gaskets will meet the following specifications:

Property	**Required Value**
Hardness, Shore "A"	75 (+/- 5)
Minimum Tensile	1500 psi (10MPa)
Minimum Elongation	150%
Minimum Aging	60%
Maximum Compression Set	20%
Ozone cracking	No cracking

MJ Bolt Packs produced in Carrollton, Texas USA by EGW Utilities.

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Xylan Coating

Bolts & 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 adheshion, 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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