



Xylan Coated (Blue) A242 T-Head Bolts & Heavy Hex Nuts

The T-Head Bolts & Heavy Hex Nuts supplied shall be ASTM A242 High Strength Low Alloy weathering steel. T-Head Bolts shall be manufactured to the latest requirements of AWWA C111/A21.11-00 and meet dimensional requirements of ANSI/ASME B18.5. Bolts shall be manufactured with a class 2A thread fit and mate with class 2B nuts, UNC, Coarse Pitch.

Heavy Hex Nuts shall be manufactured to the latest requirements of AWWA C111/A21.11-00 and dimensional specification ASME B18.2.2.

T-Head 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 Tee 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 Whitford 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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