

ENGINEERING SPECIFICATION

Hyster-Yale Group, Inc. Title: 96 HOUR (MINIMUM) SALT SPRAY COATING	Document Control Number: HC-404
Page 1 of 2 Document Author: Bob Downey	Effective Date: 01-Jul-2016 Revision No. 2016-07

ANY ACCESS TO THIS DOCUMENT OUTSIDE THE PRIMARY ELECTRONIC SOURCE IS UNCONTROLLED, UNLESS STAMPED, INITIALED AND DATED. THIS DOCUMENT IS CONFIDENTIAL. BY ACCEPTING THIS INFORMATION THE BORROWER AGREES THAT IT WILL NOT BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT IS LOANED.

OBJECTIVE: To provide a minimum 96 hour salt spray coating for the protection of components against corrosion.

SCOPE: Coating per this specification may be used on HYG product.

Transition:

This specification was previously limited to zinc-chromate conversion coating. However, the use of hexavalent chromium is being discontinued.

CITED: See [Master Index](#) or attached Annex for a complete list of Citing & Cited Documents.

GENERAL: The purpose of this specification is to standardize on the method of applying protective coating to tubing prior to forming and flaring, to prevent corrosion prior to processing and to provide continued protection of tubing assemblies. It is also to be used for small parts which are normally not painted, but which require corrosion protection.

REQUIREMENTS: The following requirements apply unless otherwise specified on the drawing.

- Known toxic coatings are not allowed.
- Minimum 96 hours to red rust with neutral salt spray per ASTM B117 / ISO 9227
- Color is silver, blue or iridescent yellow (color requires HYG approval)
- For threaded parts, the torque coefficient K Factor (not coefficient of friction) is 0.15 +/- 0.03
- For electroplated parts
 - Refer to HC-411 for requirements of electroplated parts
- Prior HYG approval is required before changing to a different color/coating.

METHOD OF SPECIFYING: HC-404 COATING

SUGGESTED VENDOR: Technicoat 7050

ENGINEERING SPECIFICATION

Hyster-Yale Group, Inc. Title: 96 HOUR (MINIMUM) SALT SPRAY COATING	Document Control Number: HC-404
Page 2 of 2 Document Author: Bob Downey	Effective Date: 01-Jul-2016 Revision No. 2016-07

ANY ACCESS TO THIS DOCUMENT OUTSIDE THE PRIMARY ELECTRONIC SOURCE IS UNCONTROLLED, UNLESS STAMPED, INITIALED AND DATED. THIS DOCUMENT IS CONFIDENTIAL. BY ACCEPTING THIS INFORMATION THE BORROWER AGREES THAT IT WILL NOT BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT IS LOANED.

Annex

ASTM B117, Standard Practice for Operating Salt Spray (Fog) Apparatus
ISO 9227, Corrosion Tests in Artificial Atmospheres - Salt Spray Tests
HC-411, Electro Plated Parts