

Document Number: D20937

Rev. Date: 3/7/19

Rev. Level: W

Title: Lytron Coating Specification

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Coating System	Type	Name & Color	Primary Manufacturer & Mfr. Part No.	Alt. Manufacturer & Mfr. Part No.
1	Paint	Powder Coat - Semi-gloss Textured Black	Cardinal Paint (T241-BK59)	TCI Powder (9012-9000)
2	Paint	Mini Tex Gray * Formerly (8/31/09) O'Brien - Mini Tex Gray (UFH-506-T2)	Sherwin-Williams Sandtex (HHT2-C001-C50)	None
3	Paint	Heidelberg - Gray	Heidelberg Gray (5350868)	Sherwin-Williams (F63VXA4030-5267)
4	Silkscreen	Markem Series 4166	Black	None
5	Silkscreen	Markem Series 4166	White	None
6	Paint	Dark Gray	Spectrum Coatings Inc (P-1038)	None
7	Paint	Black Textured Gloss	Sherwin-Williams (EBT2-C000)	None
8	Paint	Light Gray (Pearl Oyster) Semi-Gloss	(RAL 1013) Sherwin-Williams (F63TXW14620)	None
9	Paint	Powder Coat - Semi-gloss Textured Black	Cardinal Paint (T241-BK59)	TCI Powder (9012-9000)
10	Paint	Parchment White Medium Fine Texture	Sherwin Williams (F63TXW9370-5267)	None
11	Paint	Liquid Paint Dark Gray	Eastern Chem Lac (W8550)	None
12	Paint	Liquid Paint Light Gray	Eastern Chem Lac (W8551)	None

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13	Paint	Liquid Polyurethane Enamel, Rhinstone SW 1235	Sherwin Williams (F63W76)	None
14	Nickel Plating of Brass (OP NP)	Specification AMS-2404 ; 0.0003" - 0.0005"	Any Approved Supplier	
15	Passivation (OP PASS)	Specification ASTM-A967 ; Grade of SS must be specified on P.O. Certificate of Compliance required.	Any Approved Supplier	
16	Electro- polishing (OP EP)	No MIL or ASTM specification. Parts must be free of dirt and oil. Parts must be bagged. Certificate of Compliance required.	Any Approved Supplier	
17	Paint	Beige Texture	Sherman Williams (PHT6-0G004)	
18	Paint	Blue Texture	Sherwin Williams (PLT2-00236)	
19	Paint	Powder Coat – Semi gloss Mediun Fine Texture RAL7016	Sherwin Williams (HAT4-00111 )	None
20	Zinc Plating (OP ZP)	Per ASTM-B633 SC1 or SC2 Type V (Clear)	Any Approved Supplier	
21	Clear Iridite with Non- Chrome Passivate	RoHS Compliant per MIL-C- 5541, Type III (trivalent chrome conversion acceptable with written permission)	Any Approved Supplier	

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Coating System	Type	Name & Color	Primary Manufacturer & Mfr. Part No.	Alt. Manufacturer & Mfr. Part No.
22	Paint	F63VXH22499 (matches color paint system 17 but for plastics)	SHERWIN WILLIAMS POLANE SERIES PAINT AND CATALYST R7K84, (See Note 4 for preparation steps).	

**Notes:**

- 1) **This document supersedes all other documents and drawings related to the specification of paints, unless an exception to D20937 is specifically noted.**
- 2) **Equivalent paints are acceptable only with written approval from Lytron Engineering.**
- 3) **All paints specified on this document, and any paints used on Lytron products, are to be RoHS Compliant in accordance with the European Directive 2011/65/EU and Directive (EU) 2015/863.**
- 4) **Preparation notes for painting plastic surfaces paint code 22:**
  - A. LIGHT SANDING MAY BE NECESSARY TO AID IN PROVIDING A SUITABLE BONDING SURFACE.
  - B. ALL SURFACES ARE TO BE CLEAN OF DIRT, DUST, OIL, GREASE OR OTHER CONTAMINANTS.
  - PAINTING: SUBSEQUENT TO THE CLEANING/TREATMENT OF THE SURFACES, PROCEED AS FOLLOWS:
    - A. MASKING-ALL TAPPED HOLES AND AS SPECIFIED BY THE APPLICABLE DRAWING.
    - B. APPLY SHERWIN WILLIAMS INDUSTRIAL WASH PRIMER (EX. R7K44) OR POLANE PLUS SPRAY FIL.
    - C. FINISH COAT-PAINT WITH POLANE T PLUS PAINT AND CATALYST R7K84 MIXTURE.
    - D. METHOD OF APPLICATION IS OPTIONAL, DEPENDING ON REQUIREMENTS.
    - E. TEXTURE AS PER DRAWING SPECIFICATIONS.
    - F. ASSURE COLOR USING APPROPRIATE PAINT CHIP.
    - G. DRYING-24 HOURS AT AMBIENT TEMPERATURE. AVOID OVEN DRYING.
- 5) **Any revisions to this specification must be uploaded to the Lytron website (under Suppliers & Supplier Requirements) for access by Lytron’s suppliers.**

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**REVISION RECORD**

Revision	Date	ECN	Description of Change	Initials
A	10/27/08	1698	Initial Release	TAK
B	12/02/08	1722	Added Cardinal Ind. Powder Coat & Alternate: Added Black Textured Sherwin Williams: Added Light Gray (Pearl Oyster).	TAK
C	02/24/09		Added Parchment White Medium Fine Texture, system #10.	TAK
D	03/27/09		Added coating system number column: Added coating system numbers 11, 12 and 13: Updated coating system number 8 showing Sherwin Williams part number.	JAH
E	8/03/09	2039	Added coating system numbers 14, 15 and 16. Updated format of primary and secondary suppliers. Added special instructions to #15 & #16.	JAH
F	8/31/09	2105	Updated coating system #2 to a single supplier for consistency in color and finish.	ESR
G	10/01/09	2210	Updated coating system #1 to be the same as #9	ESR
H	11/20/09		Updated coating system #10, to correct Sherwin-Williams P/N. F63TXW1815-5229 is obsolete.	JAH
I	11/20/09	2278	Added coating system #17 and #18	JAH
J	12/1/09		Added coating system #19 and certificate note to #15 & #16	SJM
K	5/14/10	2286	Update notes for coating system #15 & #16.	JAH
L	5/17/10	2286	Corrected notes for coating system #16.	JAH
M	7/1/10	2615	Added system #20, zinc plating	SJM
N	12/10/10	2990	Added system #21, clear iridite	JAH
P	4/8/11	-----	Clarify coating system for outside processing	JAH
Q	4/19/12 5/2/12	100005	Update system 17, add system 22 and note 3 Corrected typo	ROO
R	10/30/12	100502	Paint sys 22 revised	ROO
S	10/16/14	100910	Note 3 added for RoHS compliancy of all paints.	KEC
T	09/07/18	201000	Corrected system 17 typo	NZ
U	09/13/18	201007	Corrected manufacturer P/N on system 17	NZ
V	12/13/18	201290	Updated coating suppliers for plating to only require the supplier to be approved.	JAH
W	3/7/19	201542	Updated coating System 20 and per ECN 201542	JAH