



Phos Oil #168 Inhibitor

Corrosion Inhibiting Emulsion Oil

zinc phosphate coatings. #168 can provide up to 240 hours of salt spray resistance when applied over coatings which are over 2,000 mg/ft² and applied to dry phosphate coatings.

Excellent results can be achieved on lighter coating weights also. 72-96 hours is typical for standard operating processlines with 1500 - 2500 mg/ft².

#168 is a stable emulsion and resistant to degradation. Providing an emulsion in water that coats surfaces evenly. #168 is approved and meets requirements of FCA (DCX /Chrysler) spec PS.50034 (formerly PS-80), GM 4435, Ford S-2 and other specifications. Meets Torque Tension requirements of .08-.14

Features & Benefits

- Dilutes with water providing a low cost system.
- Low oil residue, without tackiness. Ideal for parts with torque tension requirements.
- Stable emulsion when good rinsing procedures are used.
- Meets various automotive and government specifications for corrosion resistance.
- Provides extended corrosion resistance over zinc phosphate coatings of up to 200+ hours in salt spray.

Physical Data

pH	9+
Product Type	Oil
Spec. Gravity	.92
lbs./gal.	7.67
Foam, 0 = Low, 9 = High	
Shelf-Life Years	10 years
Freeze Information	Not damaged by freezing



Typical Processing

1. Wash, Rinse, Acid Pickle, Zinc Phosphate Coating, Etc.
2. Rinse
3. Rinse, (neutralize to ph of 8.0 to 10.0 if necessary), see POLY FILM 2555
4. #168 Oil, 10-20% by volume, 1-5 minutes. , ph= 9.0 - 10.0
(Double dip tightly packed parts or over filled barrels- or more)
Note: Do not drag acid/s salts, dirty rinse water or alkali into bath.

Note: To control ph: PH controller phc 20, Triethanolamine, or Monoethanolamine to raise ph. Agitation necessary with new bath or bath recharge. Continuous agitation suggested for optimal performance.

Packaging

Container Type	Steel
Net Units	450
Tare Wt.	25
Gross Wt.	447
DOT_Name	Not regulated by DOT
DOT Hazard	Not regulated by DOT
Tarriff ID	3403.11

Use Parameters

Concentration Range	10% - 20% by volume
Temperature Range	80 – 150 deg. F.
Time Range	Dip 1 – 5 minutes
Agitation	Mild recommended

Waste Disposal

Neutralize pH, remove fats, oils, grease and heavy metals

Holding Tank Materials of Construction

Steel, Stainless or Poly

Other Information

It is important that the OSHA DATA, "Material Safety Data Sheet" be carefully read and reviewed with the users of this product. OSHA data is required to be posted in the work area by law



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For more information on this process,
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