

Jim Hartley

Subject: COC for Roylco order po # 16195

LSM---COC

Material produced for this order as follows:

Substrate: Cold Roll produced per USA- ASTM A 1008 standards ----- see attached metal chemistries for individual master coils applied.

28 gage thickness; bare unpainted metal , .0142 min .0162 max.

Specified Hardness ordered RB 40/55.

Electro-Galvanize Method:

12 Grams applied both sides in accordance to USA- ASTM A 879 standard.

Paint process;

Dura Coat Paint System—Huntsville Alabama.USA.

Face side painted primer DC477K-2000 per MFG recommendations.

Face side painted black DC146K-2022 per MFG recommendations.

Reverse side painted rust inhibitor DC451C-2001 per MFG recommendations.

Above system applied meets or exceeds MIL-P-19602, and Class 2 of Mil-E-19603 accordance.

Above system applied passed 96 hour minimum 5% salt fog test per Mil –B-117 standard, and DTL12977500.

Above system applied is 35 max gloss or less in finish product.

Slit finish process:

4.25 x coil width

6.50 x coil width

Tolerance: plus or minus .005

Submitted:

4-17-2014

James J . Hartley

Lakeside Metals Inc.

Chicago Illinois.

630-247-7685



DURA COAT PRODUCTS INC.
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April 01, 2014

Salt Spray Report

Item: #1 - DC146K-2022 M/G Black over DC477K-2000 Non-Chrome Primer on 0.0170 EGS

Material Manufacturer: Dura Coat Products (paint manufacturer)/Lakeside Metals (metal supplier)/Canfield Coil Coating (Coil Coater)

Test Method: ASTM B-117 and DTL12977500

Testing Apparatus: Q-FOG Salt Spray Testing Apparatus manufactured by Q-Panel

Salt: Culonix 999 by Morton

Salt Concentration: 12.8 pounds per 30 gallons of Deionized Water

Chamber Temperature: 95-97° F

Volume of Salt Collected: 1.69 – 1.70 ml per hour (side – center – side)

Spray Nozzle Pressure: 10 psi

Specific Gravity: 1.04

pH value: 7.0

Panel edges taped for protection

Exposure Time: 96 Hours

Test Results:

Item #1 DC146K-2022 M/G Black over DC477K-2000 Non-Chrome Primer on 0.0170 EGS

No face rust - <1/16" scribe rust or creepage

Test Initiated: 9:00AM March 31, 2014

Test Terminated: 9:00AM April 01, 2014

Test conducted By: Dexter F. Sunderman – Technical Director – Huntsville Facility

Dexter F. Sunderman