

## CORROSION PROTECTION

Oshkosh Finishing Services delivers the complete range of manufacturing and finishing solutions to help you deliver the highest quality products to your customer. From Corrosion Protection and Top Coat to Welding, Fabrication and Assembly, our streamlined processes, unmatched capabilities and multi-industry experience help you receive premium products at the right price.



# CORROSION PROTECTION | HIGH-QUALITY CORROSION RESISTANCE

Oshkosh's electrocoating (E-Coat) immersion process provides coverage of complex parts and a uniform thickness without runs or drips. E-Coat delivers a superior corrosion and chemical resistance, while maintaining a high-quality, resilient surface for paint of any color or finish.

Operating out of one of the most expansive facilities in the nation, Oshkosh corrosion protection services feature E-Coat capabilities that other companies cannot match. Our 150,000 square foot facility is home to one of the country's largest Programmable Hoist Systems (PHS), as well as a state-of-the-art indexing system, which allows processing of parts of virtually all shapes and sizes.

In addition to our advanced systems and rigorous quality assurance processes, Oshkosh corrosion protection leverages expertise from Oshkosh's proven experience serving the Department of Defense. Our economic and efficient corrosion protection provides a durable resistance from the most severe conditions.

## Durable, consistent protection.

- High-performing cathodic epoxy coatings are paired with zinc-phosphate pre-treatment
- Final coatings provide superior salt spray, humidity and cyclic corrosion resistance
- PHS tank sizes: 36 ft. length, 3.5 ft. width and 8 ft. depth; maximum weight capacity of 5,000 lbs.
- Indexing system capabilities: 8 ft. length, 10 ft. width and 8 ft. depth; maximum part weight capacity of 2,500 lbs.
- Immersion process offers uniform coverage and thickness of complex parts
- Accredited laboratory for performance testing and certification of the overall coating process
- Process application range: military, maritime, agriculture & construction, automotive parts & accessories, heavy duty trucks, mining, recreation, electrical equipment
- Specifications including but not limited to: TT-C-490E, Mil-DTL-53084
- Substrates including but not limited to: armor, steel, aluminum (commercial applications), iron alloys, galvanized



Oshkosh Corporation  
2307 Oregon Street, P.O. Box 2566 • Oshkosh, WI, USA 54903-2566  
ph 1.920.235.9150 • fax 1.920.233.9506

For more information on Oshkosh Finishing Services, please contact  
Josh Verdon at [jverdon@defense.oshkoshcorp.com](mailto:jverdon@defense.oshkoshcorp.com) or **920.410.4693**

email: [oshkoshfinishingervices@oshkoshcorp.com](mailto:oshkoshfinishingervices@oshkoshcorp.com)  
website: [oshkoshfinishingervices.com](http://oshkoshfinishingervices.com)

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Pierce® Dash® CF Pumper

*"E-coat offers a superior corrosion and chemical resistance when compared to conventional priming and painting methods. We chose to E-Coat our frame rails and liners because of its proven corrosion protection, its durability and versatility."*

Jim Johnson  
President  
Pierce Manufacturing

## FILM TECHNICAL PROPERTIES

| PROPERTY            | TEST METHOD | PERFORMANCE            |
|---------------------|-------------|------------------------|
| Color               | –           | Black                  |
| Film Thickness      | –           | 0.5 - 1.5 Mills        |
| Gloss - 60 Degree   | ASTM D523   | 65 - 85                |
| Pencil Hardness     | ASTM D3363  | 2H Minimum             |
| Direct Impact       | ASTM D2794  | 100 in. - lbs. Minimum |
| Reverse Impact      | ASTM D2794  | 60 in. - lbs. Minimum  |
| Crosshatch Adhesion | ASTM D3359  | 4B - 5B                |
| Humidity            | ASTM D1735  | 1000 Hours Minimum     |
| Water Immersion     | ASTM D870   | 250 Hours Minimum      |
| Gravelometer        | GM9508P     | 6 Minimum              |
| Throwpower          | GM9535P     | 12 - 15 in.            |

Cold rolled steel lab panels, Zinc Phosphate pretreatment, 0.6 mils average film thickness, cured 20 minutes @ 350°F.

| PROPERTY             | SUBSTRATE PRETREATMENT       | SALT SPRAY* 1000 HOURS |
|----------------------|------------------------------|------------------------|
| Corrosion Resistance | CRS / Zinc Phos / Non-Chrome | 1 - 2 mm               |

\*Salt Spray - ASTM B117, cold rolled steel lab panels cured 20 minutes @ 350°F.  
(Average Total Scribe Creep)

CORROSION PROTECTION  
TOP COAT  
WELDING AND FABRICATION  
ASSEMBLY