



Phos Oil #168 Inhibitor (17.5% Pre-Dilute)

Corrosion Inhibiting Emulsion Oil

#168 is a corrosion inhibiting soluble oil which is used to provide extended salt spray resistance when applied over zinc phosphate coatings. #168 (@ 18%) can provide up to 200 hours of salt spray resistance when applied over coatings which are over 2,000 mg/ft² and applied to dry phosphate coatings after neutral D.I. water rinsing.

Excellent results can be achieved on lighter coating weights also. 72-96 hours is typical for standard operating process lines with 1500 - 2500 mg/ft² with the bath operating at 12-16%

#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	Liquid
Spec. Gravity	0.99
lbs./gal.	8.26
Foam, 0 = Low, 9 = High	2
Shelf-Life Years	1 year
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 (double dip tightly packed parts or over filled barrels- or more) Note: Do not drag acid salts, dirty rinse water or alkali into bath.

Note: To control ph if required: use Poly Lube Ph Adjuster or Ph Controller PHC -20, PH Adjuster 45, OR Triethanolamine.

Packaging

Container Type	Steel
Net Units	455
Tare Wt.	25
Gross Wt.	480
DOT_Name	Not regulated by DOT Not Subject to IATA Regulations for Air
DOT Hazard	Not regulated by DOT
Tarriff ID	3403.11

Use Parameters

Concentration Range	10 - 20% by volume
Temperature Range	80 – 160 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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