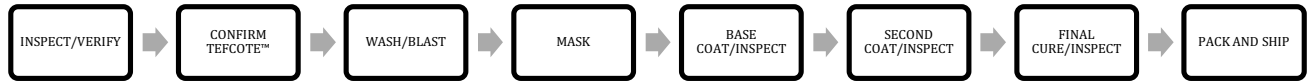


# TefCote™ Process Overview

Form:	SOP.CTG-TC		
Version:	150819		
Pages:	1		
Authors:	Kelly Kykkanen		Replaces Form(s) / Version(s): SOP.CTG-TC / 150422
Reviewed By:	Kim Edgar	Date: August 24, 2015	
Approved By:	Anthony Honke	Date: August 25, 2015	
<b>EFFECTIVE DATE:</b>	<b>August 25, 2015</b>		

## 1. Flowchart of the Coating Process



## 2. Customer Part received

- 2.1. Inspect all parts upon receipt for mechanical damage (e.g. Threads) and advise customer if any observed.
- 2.2. Part is compared to Customer's Order Entry Form to ensure proper quantity, part description and part material.
- 2.3. TefCote™ version, thickness and colour are confirmed (standard thickness and colour given in brackets)
  - 2.3.1. TC45 – FEP (**Thickness:** 0.8 to 1.2 mils, **Colour:** Med Blue)
  - 2.3.2. TC50 – PTFE (**Thickness:** 0.8 to 1.2mils, **Colour:** Red)
  - 2.3.3. TC51 – Food Grade (**Thickness:** 0.8 to 1.2mils, **Colour:** Black)
  - 2.3.4. TC60 – PFA (**Thickness:** 2 to 3mils, **Colour:** Black)

## 3. Cleaning and Inspection

- 3.1. Verify areas that require TefCote™ applied. Areas requiring TefCote™ must be free of slag or scale. Surface finish of 64µin or better is recommended to ensure proper coating of part.
- 3.2. Part must be cleaned and dried prior to TefCote™ process. All areas subjected to TefCote™ process must be cleaned using Burn off oven, pressure washer, and/or bead blaster.

## 4. Preparation

- 4.1. Specific areas that do not require coating are masked off. This is accomplished using platers tape, plugs or other masking agents.
- 4.2. The parts are hung using appropriate hanging methods depending on the geometry of the parts, ensuring minimal contact on the parts causing improper coating coverage.

## 5. Plating Procedure

- 5.1. Parts are placed in spray booth
- 5.2. Base Coat is applied then Flashed and cooled
- 5.3. Second Coat is applied, Flashed and cooled
- 5.4. Parts inspected for missed areas or overspray. If acceptable, then any forms of masking is removed and parts are cured in oven.

## 6. Inspection

- 6.1. A 100% visual inspection of part is performed to make sure there is no pits, cracks, spalling or blistering in the coating; this includes areas that required and did not require plating as well as any mechanical damage that may have occurred. If parts fail to meet criteria, then part is stripped and re-processed.
- 6.2. Verify ID tolerances of all Silver Fox flow control product such as Nipples and Slick Joints by drifting seal bores to ensure part still conforms to Silver Fox standards

## 7. Final sign off

- 7.1. All TefCote™ paperwork is to be completed at this time, if final process step, parts are then marked complete