



EAGLE 300 LT

SPRAY ALLOY POWDER

Economical Low Temperature Bond Coat

APPLICATIONS

The **Eagle 300 LT** is a required bond coat for all Eagle Low Temperature Powders. This powder is excellent on shafts, inside and outside diameters, journals and bearings.

PROCEDURE

Clean and degrease part thoroughly. Undercut the worn area plus 1/2" on either side.

For ferrous metals undercut .015 minimum on the radius and for copper alloys undercut .030" minimum on the radius. Make sure to bevel all shoulders at 45°. Thread and undercut the area with fine threads 0.10" deep and coarse threads .030" deep. Leave about a 1/16" land between the end of the thread and the end of the undercut. **Do Not Touch Area After Machining.** Rotate work in the lathe at 50 – 125 RPM, set acetylene pressure at 5 psi and oxygen pressure at 6 psi. Set torch to a slightly carburizing flame and preheat base metal to 200° F. Place the torch in a horizontal position to the work piece at a distance of 6" – 7". Spray a minimum thickness of .005" - .007".

GENERAL CHARACTERISTICS

The **Eagle 300 LT** is a high quality bond coat powder for all metals except pure copper. This powder produces a metallurgical bond at temperatures below 500° F.

www.eaglealloys.ca