

## PRODUCT OVERVIEW

**PMET 542** is a high tin, lead free Babbitt wire specifically designed for spraying in arc spray and flame spray systems. It produces dense, well-bonded coatings particularly applicable to high speed and heavy duty bearings.

### TYPICAL DEPOSIT CHARACTERISTICS:

⇒ Typical Hardness:	HRB 65
⇒ Bond Strength:	3000 psi
⇒ Deposit Rate:	48 lbs/hr/100A
⇒ Deposit Efficiency	70%
⇒ Wire Coverage:	0.9 oz/ft <sup>2</sup> / mil
⇒ Surface Texture	* Variable
⇒ Machineability	Good

\* Depends on air pressure used

### SURFACE PREPARATION

Surface should be clean, white metal, with no oxides (rust), dirt, grease, or oil on the surface to be coated. **Note:** It is best not to handle surfaces after cleaning.

Recommended method of preparation is to grit blast with 24 mesh aluminum oxide, rough grind, or rough machine in a lathe.

### APPLICATION

⇒ Bearing Surfaced

### SPECIFICATION

Babbitt

### NOMINAL CHEMICAL COMPOSITION (wt%)

<b>Sb</b>	<b>Cu</b>	<b>Sn</b>
7.0	3.0	Bal

### RECOMMENDED SPRAY PARAMETERS:

Diameter	Air Pressure	Voltage	1/8" Amperage	Standoff
1/16" (1.6mm)	*50-60 psi	*21-23	*100-200	*4-8 in (10-20 cm)
1/8" (3.2 mm)	Consult Equipment Manufacturer			

### STANDARD SIZES & PACKAGING:

Diameter	Packaging	Part Number
1/16" (1.6mm)	25# LWS	542062LWS00
1/8" (3.2 mm)	25# LWS	542125LWS00