

ZINCOLAC Si

INTRODUCTION

Zincolac Si has been developed for the sealing of zinc plated and blue or yellow chromated parts. Zincolac Si contains silicon compounds, which give increased corrosion protection and excellent lubricity.

BENEFITS

- Enhanced corrosion resistance
- Lacquer like finish
- Excellent lubricity
- Dip application
- No drying required before application

SOLUTION MAKE-UP

Zincolac Si 10-40% v/v with water

OPERATING DATA

pH	8.5 - 10.0
Concentration	10 - 20% (rack) 20 - 40% (barrel)
Temperature	20 - 35 deg C.
Immersion Time	20 - 60 secs
Drain Time	30 - 90 secs
Drying Temperature	60 - 85°C.

EQUIPMENT

Tanks	Stainless steel, PVC, polypropylene, coated steel
Heaters	Stainless steel, PTFE immersion with thermostatic control.

INSTALLATION

It is essential that the tanks to be used for Zincolac Si are thoroughly cleaned and leached before any product is introduced.

If in any doubt as to the cleaning procedure please contact PMD (UK) Limited Technical Department.

1. Thoroughly clean the process tank with water and pump out.
2. Fill the tank approximately 50% with water.
3. Add the required quantity of Zincolac Si, top up with water and mix thoroughly.
4. Heat to 20-35°C

MAINTENANCE AND CONTROL

The solution should be analysed regularly and replenished as necessary (see analysis methods.)

Maintain the pH at 8.5-10.0 with ammonia.

NOTES ON THE USE OF ZINCOLAC Si

Pre-treatment	Pre-clean the metal surface using normal degreasing cleaners to ensure no water breaks. When using in a plating process line the work can enter the Zincolac Si after thorough post-plate or post passivate rinsing.
Jigs	Clean jigs in 5% caustic solution at 60-80°C
Filtration	Filtration is not normally required. If particles are dragged in batch filtration through 80 - 150µm filter cartridge is recommended.
pH	pH must be maintained above 8.0. Below this irreversible precipitation will occur.

ANALYSIS METHOD

1. Weigh a dry watch glass and record weight as A gms.
2. Pipette approximately 15mls of the solution into the watch glass.
3. Weigh the watch glass and sample. Record weight as B gms.
4. Dry at 120°C to constant weight.
5. Allow to cool and re-weigh. Record weight as C gms.
6. Calculate % concentration.

Calculation

$$\frac{(C - A) \times 350}{(B - A)} = \% \text{ concentration Zincolac Si}$$

Replenishment

For every 1% low add 10ml/L Zincolac Si

DISPOSAL

Dispose of in accordance with local authority requirements.

PRODUCT FAMILIES

The following products are referred to in this data sheet.

<u>Product Name</u>	<u>Product Number</u>
Zincolac Si	241002

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