

PMD (UK) LTD PROCESS DATA

PMD (UK) Ltd, Broad Lane, Coventry, CV5 7AY, England. Telephone 024 7646 6691 Fax 024 7647 3034
Web Site: www.pmdgroup.co.uk Email: sales@pmdgroup.co.uk

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PREV

ZINCOPASS 3 BLUE 4

INTRODUCTION

Zincopass 3 Blue 4 in a single stage trivalent dip process designed to give products a bright, haze free, blue chromate finish on zinc plate.

BENEFITS

- Inhibits tarnishing
- Provides good corrosion protection
- Easy to control
- Does not contain hexavalent chromium

SOLUTION MAKE-UP

	Rack	Barrel
Zincopass 3 Blue 4 Part A	2%	-
Zincopass 3 Blue 4 Part B	2%	2%

OPERATING DATA

Zincopass 3 Blue 4 Part A	1-3% rack
Zincopass 3 Blue 4 Part B	1-3% rack and barrel
PH	1.8-2.2
Temperature	16-25°C
Immersion time	20-60 secs
Agitation	Rack – air Barrel – rotation
Extraction	Recommended

EQUIPMENT

Tanks	Polypropylene or PVC
Heaters	PTFE control immersion heaters with Thermostatic control

INSTALLATION

It is essential that the tanks to be used for Zincopass 3 Blue 4 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. Half fill tank with water.
2. Add the required volume of Zincopass 3 Blue 4 Parts A and B.
3. Top up to working level and mix well.
4. The solution is now ready for use.

PROCESS SEQUENCE

1. Zinc plate.
2. Rinse.
3. Rinse.
4. 0.5% nitric acid.
5. Rinse.
6. Zincopass 3 Blue 4.
7. Rinse.
8. Warm water rinse.
9. Dry.

MAINTENANCE AND CONTROL

Zincopass 3 Blue 4 Part A is used on make-up only. Maintain finish by small frequent additions of Zincopass 3 Blue 4 Part B. When additions fail to be effective the solution should be discarded and a new passivate made up.

Any components that fall into the solution should be removed immediately.

pH should be raised with sodium hydroxide solution or lowered with dilute nitric acid.

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>
Zincopass 3 Blue 4 Part A	237025
Zincopass 3 Blue 4 Part B	237026

Whilst every endeavour has been made to ensure that the information given in this data sheet is correct, PMD (UK) gives no warranty, express or implied, relating to the use or performance of this product.