

PMD (UK) LTD PROCESS DATA

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PREV 1

ZINCOPASS 3 BLUE

INTRODUCTION

Zincopass 3 Blue is a single stage trivalent dip process designed to produce a bright, haze-free, blue chromate finish on zinc plate. The process is economical and simple to operate giving high quality results.

BENEFITS

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

SOLUTION MAKE-UP

Zincopass 3 Blue 4 -10% v/v with water

OPERATING DATA

Concentration	4-10% (optimum 4-6)
pH	1.8-2.4 (see notes)
Temperature	15-25°C
Immersion Time	20 - 60 seconds
Agitation	Work movement preferred
Extraction	Recommended.

EQUIPMENT

Tanks Polypropylene or polyethylene

Caution: Do not use glass or ceramic containers.

INSTALLATION

It is essential that the tanks to be used for Zincopass 3 Blue 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 clean water.
2. Add required quantity of Zincopass 3 Blue.
3. Top up to working level and mix well.
4. The solution is now ready for use.

PROCESS SEQUENCE

1. Zinc plate.
2. Cold water rinse.
3. Cold water rinse.
4. 0.5% v/v nitric acid.
5. Rinse.
6. Zincopass 3 Blue.
7. Cold water rinse.
8. Hot water rinse.
9. Dry. (>80°C)

MAINTENANCE AND CONTROL

To maintain the recommended operating range small frequent additions of Zincopass 3 Blue should be made. When additions fail to be effective the solution should be discarded and a new passivate made up.

Any components that fall into the passivate solution should be removed immediately. If components are left in solution the bath life will be greatly reduced.

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

NOTES

Zinc thickness	It is important that a minimum thickness of 5µm zinc plate is present before passivation.
pH	Optimum pH for alkaline non cyanide zincs is 2.2, for other types of zinc solution the optimum is 2.0.

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	237017

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