

ZINCOPASS 3 YELLOW

INTRODUCTION

Zincopass 3 Yellow is a single stage trivalent dip process designed to produce a bright colourless to yellow/iridescent passivation on zinc plate. The process is economical and simple to operate giving high quality results.

BENEFITS

- Fluoride free
- Inhibits tarnishing
- Provides good corrosion protection
- Easy to control
- Does not contain hexavalent chromium
- Heat resistant finish to 150°C

SOLUTION MAKE-UP

Zincopass 3 Yellow 15 -20% v/v with water

OPERATING DATA

Concentration	15-20%
pH	2.2-2.5 (optimum 2.4)
Temperature	20-25°C
Immersion Time	45 - 90 seconds
Agitation	Work movement preferred
Extraction	Recommended.

EQUIPMENT

Tanks Polypropylene or polyethylene

INSTALLATION

It is essential that the tanks to be used for Zincopass 3 Yellow 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 Yellow.
3. Top up to working level and mix well.
4. Heat to operating temperature.
5. 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 Yellow.
7. Cold water rinse.
8. Hot water rinse.
9. Dry. (>85°C)

MAINTENANCE AND CONTROL

To maintain the recommended operating range small frequent additions of Zincopass 3 Yellow 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.
Contamination	Iron content of more than 800ppm and zinc of more than 5g/L will give a more yellow passivation colour.

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 Yellow	237016

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