

TECHNICAL DATA SHEET

PHOS-PREP® PP 930 INHIBITED SPRAY IMMERSION CLEANER

GENERAL

PHOS-PREP® PP 930 Inhibited multi metal cleaner is formulated for the spray or immersion cleaning of steel or hot dip galvanised steel prior to further pre-treatment. The system is designed to produce a chemically clean surface to give uniformity of reaction during subsequent processing. It is particularly suited to spray operations, offers short term corrosion protection on mild steel parts

OPERATION

PHOS-PREP® PP 930 Cleaner should be made up in clean water at a nominal concentration of 40 to 60 litres per 1000 litres bath volume (i.e. 4 to 6% v/v), although this may be varied if appropriate.

The solution should be operated at temperatures between 45°C and 65°C. Typical processing times would be between 1 and 5 minutes, depending on the amount of cleaning required.

PLANT

The process tank and spray bars should be manufactured from mild steel, due to spray nozzles and pump impellers for spraying are subject to velocities these parts should be manufactured from 316 grade stainless steel, Cast iron is a suitable for the pump casings and volutes.

Aluminium, Copper, Zinc, or alloys that contain these materials such as brass and bronze are not suitable for use with the PHOS-PREP® PP 930

LABORATORY CONTROL

The working solution should be tested at regular intervals and replenished accordingly, thus ensuring consistent processing results. The working strength should be determined as follows:

Take a 50ml sample of the working solution, add 5 to 10 drops of Phenolphthalein Indicator Solution, and then titrate with 0.1M hydrochloric acid until the pink colour disappears.

$$\text{Titrate} \times 3.3 = \text{Bath concentration (litres per 1000 litres)}$$