

TECHNICAL DATA SHEET

PHOS-PREP® PP 937 Acid Etch Cleaner (PHOS)

GENERAL

PHOS-PREP® PP937 is an acidic cleaner and deoxidiser system designed to ensure a completely clean surface on steel & cast iron surfaces, PHOS-PREP®PP937 is used as an activator before Iron / zinc phosphates such as PHOS-PREP® PP970IZ & PP970M.

PHOS-PREP® PP937 may be used to remove scale and white rust before chemical pre-treatment and painting/powder coating, when used at 2% in water, care must be taken on zinc based surfaces not exceed determined dwell times as removal of the zinc coating will occur. PHOS-PREP® PP 937 may also be used to remove the oxide created by the laser cutting process, to remove this the PHOS-PREP® PP 937 should be used at 10 – 20 % strength depending on severity of the oxide present

OPERATION

For the make up of a new bath, fill the tank two thirds full with water and add the required volume of PHOS-PREP® PP937. The addition should be made slowly, as heat may be generated during the mixing of the acids with water.

The typical strength of a working bath is between 2 and 20% PHOS-PREP® PP937. Additions are made to the bath to maintain its acidity during operation, and thereby the consistency of its performance. The additions needed are determined by a simple laboratory control method.

PHOS-PREP® PP937 is operated at temperatures between ambient and 60°C, in spray systems or with air agitation to improve the efficiency of operation. The time of processing should be sufficient to produce a completely clean surface, normally between 1 and 15 minutes in most cases. The PHOS-PREP® PP937 stage should be followed by thorough rinsing with clean water.

LABORATORY CONTROL

To a 10ml sample of the PHOS-PREP® PP937 bath add 5 drops of phenolphthalein indicator. Titrate with normal sodium hydroxide solution to a pink end point.

$$\% \text{ vol/vol PHOS-PREP® PP935} = \text{Titre} \div 2$$

The working bath should be maintained at the required strength by the addition of PHOS-PREP® PP 937 concentrate. Addition of 10 litres PHOS-PREP® PP937 concentrate per 1000 litres bath volume will increase the concentration by 1% vol/vol.

EQUIPMENT

All tanks and pipe work for use with PHOS-PREP® PP935 should be constructed from stainless steel grade 316 or other acid resistant material.

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