

Technical Data Sheet

PHOS PREP® PP993 PHOSPHATE RINSE SEAL

1. DESCRIPTION & PROPERTIES

PHOS-PREP® PP993 is a liquid concentrate for adding to phosphate rinsing systems to passivate the phosphated surface, thereby increasing the corrosion resistance. PHOS-PREP® PP993 contains no chromate and the handling problems associated with chromates are eliminated.

2. PROCESS OPERATION

The normal concentration of PHOS-PREP® PP993 is between 0.5% and 2.0% (between 5 and 20 litres per 1000 litres bath volume). The concentration employed may be varied according to conditions.

PHOS-PREP® PP993 solution may be used at ambient temperature, but higher temperatures may be employed where desired. The immersion time can be as little as 15 seconds but where maximum corrosion resistance is required times of up to 3 minutes should be allowed.

The solution should be tested frequently and replenished as necessary with PHOS-PREP® PP993 concentrate. However, for optimum results and to minimise the effects of the build up of salts, the working solution should be discarded weekly and a fresh working bath made up.

3. LABORATORY TESTING & CONTROL

Take 100 ml of the working bath and to this add 15 - 20 drops of phenolphthalein indicator. Titrate against M/10 hydrochloric acid, the end point being from pink to colourless.

TITRE X 0.25 = % V/V PHOS-PREP PP 993