PROTECTALL 200B

BLACK ORGANO-MINERAL FINISH

INTRODUCTION

Protectall 200B is an organo-mineral topcoat which has been developed to improve the finish and corrosion resistance of trivalent black passivates.

BENEFITS

- More than 200 hours before white rust
- Enhanced black appearance

SOLUTION MAKE -UP

Protectall 200B 30 - 100%

1. Add the Protectall 200B to the tank.
2. Add the required volume of water.
3. Mix thoroughly.

OPERATING DATA

Concentration	30 - 100%
Temperature	18 - 25 °C
pH	9.0 – 9.5
Time	30 - 60 seconds
Drying	Warm (60-80°C) air drying: 10 - 15 minutes. During bulk processing, centrifuge at 250 rpm (for a basket of diameter 600 mm) in a current of warm air. The work piece temperature should be about 80°C

EQUIPMENT

Tanks	Polypropylene, PVC
Filtration	It is essential to filter using a cartridge of 50 - 150 µm porosity.
Agitation	Maintain constant agitation to ensure system stability

PROCESS SEQUENCE

1. Zinc plate
2. Rinse
3. Dilute acid dip
4. Rinse
5. Passivate
6. Rinse
7. Cold spin dry
8. Protectall 200B
9. Cold spin dry
10. Warm spin dry

MAINTENANCE AND CONTROL

The solution should be analysed regularly and replenished as necessary.
(See analysis method).

Concentration loses are corrected by the addition of Protectall 200B. This will also maintain the pH.

ANALYSIS METHOD

Method

1. Weigh an aluminium dish and record weight as A g.
2. Add approximately 10g of the bath into the dish and reweigh. Record weight as B g
3. Place the dish into an oven at 120°C and dry to constant weight.
4. Allow to cool in a desiccator and weigh. Record weight as C g.

Calculation

$$\% \text{ Protectall 200B} = \frac{(C-A)}{(B-A)} \times 407.2$$

Replenishment

For every 1% required add 10ml/L Protectall 200B

PRODUCT FAMILIES

The following products are referred to in this data sheet.

PRODUCT NAME	PRODUCT NUMBER
Protectall 200B	241028

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