



ABPHOS 201M

COMBINATION CLEANER/PHOSPHATE PROCESS

INTRODUCTION

ABPHOS 201M is a clear, light amber acidic liquid. The ABPHOS 201M process has been formulated to simultaneously degrease and phosphate mild steel components prior to painting operations. Applied by either spray or immersion techniques, ABPHOS 201M will produce lightweight coatings of amorphous iron phosphate conforming to the requirements of (a) EN 12476:2000 Type Fe p h and (b) D.E.F. Stan 03-11 Class IV specifications.

Zinc and aluminium components can also be satisfactorily processed, provided that they are in mixed metal production along with mild steel.

ABPHOS 201M is extremely low sludging and will produce coating weights in the range of 0.3 - 1.0g/square metre.

SOLUTION MAKE-UP

Abphos 201M 2 – 3%

1. Add water to tank
2. Add Abphos 201M and mix.
3. Heat to operating temperature.

OPERATING DATA

Concentration	1 – 5%
Temperature	35 – 65°C (optimum 55°C)
Time	1 – 10 mins

For immersion applications, operation at the higher end of the ranges is normally recommended.

EQUIPMENT

Tanks	Stainless steel or plastic lined
Heaters	Stainless steel



MAINTENANCE AND CONTROL

Whilst ABPHOS 201M produces very small amounts of sludge, it is necessary to periodically remove it, along with debris accumulated off the work. This can build up particularly on heating coils, spray jets etc where it may interfere with the performance of the system. Any floating oil or grease should likewise be skimmed off the surface.

ANALYSIS METHOD

Reagents

0.1N sodium hydroxide
Phenolphthalein indicator

Method

1. Pipette 10ml of the solution into a flask
2. Add 100ml deionised water
3. Titrate with 0.1N sodium hydroxide to a pink endpoint.
4. record titre = t mls

Calculation

$t \times 0.31 = \% \text{ concentration Abphos 201M}$

Replenishment

For every 1% required add 10ml/l Abphos 201M

DISPOSAL

Dispose of in accordance with local authority requirements.

PRODUCT FAMILIES

The following products are referred to in this data sheet.

PRODUCT NAME	PRODUCT NUMBER
ABPHOS 201M	ABPH/201M/1220KG/1000L

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