CHROLITE BK-75

(BLACK CHROMATE CONVERSION COATING ON ZINC)

CHROLITE BK-75 is a high efficiency single dip immersion process to produce jet black chromate conversion coatings on zinc deposits of cyanide, alkaline non cyanide and chloride zinc baths. The system can be used in manual and automatic rack operations and in basket and barrel operations.

The chromate coatings produced has a good adhesion to zinc plated surfaces and afford good corrosion and abrasion resistance. A zinc plate properly black chromated in CHROLITE BK-75 will withstand in excess of 50 hours of standard salt spray solution without white corrosion.

CHROLITE BK-75 is supplied as two liquid components namely CHROLITE BK-75 A and CHROLITE BK-75 B, used for both make up and replenishment.

OPERATING CONDITIONS:

<table>
<thead>
<tr>
<th>Component</th>
<th>Concentration</th>
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<td>CHROLITE BK-75 A</td>
<td>80 - 100 ml/ltr.</td>
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<tr>
<td>CHROLITE BK-75 B</td>
<td>80 - 120 ml/ltr.</td>
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Temperature: Room.
Time: 60 - 90 Sec.

BATH MAKE UP:

To make up 100 lts. of CHROLITE BK-75 operating solution:

- Fill the tank 2/3rd full of D.I. water.
- Add 8 lts. of CHROLITE BK-75 A and stir to mix.
- To this add 8 lts. of CHROLITE BK-75 B and stir to mix.
- Make up the volume to 100lts.

Do not pre mix CHROLITE BK-75 A and BK-75 B prior to adding to the processing tank. The operating solution prepared is slightly turbid and this turbidity is normal and does not have negative effect. Drag in of chloride ions should be avoided as it will increase the consumption of CHROLITE BK-75 B.

PROCESS CYCLES FOR BLACK CHROMATING:

1. Zinc plate (Minimum plating thickness 5 microns)
2. Cold water rinse.
3. 1 - 2% by volume sulphuric acid dip or bright dip in CHROLITE BL-50.
4. Cold water rinse.
5. Black chromating in CHROLITE BK-70 bath for 30 - 90 seconds at room temperature.
6. Cold water rinse.
7. Air dry. (65°C Maximum)

Hot water should not be used for drying, as it tends to dull the finish and reduce the corrosion resistance. The black chromate coatings formed are soft when wet and therefore care must be taken to minimise handling the work before it is dry.

REPLENISHMENT:

The bath is replenished by analysis or by physical observations and consumption patterns. Small additions of 1 to 2 parts of CHROLITE BK-75 A and 1 part of CHROLITE BK-75 B are to
be added to the bath with agitation. If the coating is iridescent after the replenishment the addition of CHROLITE BK-75 B can be further increased.

**EQUIPMENT:**

High density polyethylene, polypropylene, P.V.C. or steel tanks lined with these materials are recommended, baskets, barrels or racks made up of the same material are recommended for holding the work.

**NOTE:**

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