CHROLITE OLIVE – 275

COMPOSITE OLIVE GREEN CHROMATE COATING

CHROLITE OLIVE - 275 is a single dip immersion process to produce dark olive green passivation on chloride zinc electro deposits. The chromate coatings produced gives a very high corrosion resistance of over 150 hours in a salt spray test. CHROLITE OLIVE - 275 is supplied as a liquid concentrate and is to be diluted with known quantity of water to make the operating solution.

OPERATING CONDITIONS:

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Range</th>
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<tbody>
<tr>
<td>CHROLITE OLIVE-275</td>
<td>60 - 120 ml/ltr.</td>
</tr>
<tr>
<td>Temperature</td>
<td>25 – 35°C</td>
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<tr>
<td>Time</td>
<td>30 - 90 sec.</td>
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<tr>
<td>pH (Electrometric)</td>
<td>0.8 - 1.2</td>
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<tr>
<td>Agitation</td>
<td>Air or component movement.</td>
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BATH MAKE UP:

Fill the tank with 2/3rd full of clean water and add required quantity of CHROLITE OLIVE 275 and stir the solution. Make up the operating volume and stir well to ensure thorough mixing.

PROCESS CYCLE FOR CHROMATING IN CHROLITE OLIVE - 275:

1. Zinc plate (Minimum thickness of 6 - 8 Microns)
2. Cold water rinse.
3. 0.4% by volume nitric dip.
4. Cold water rinse.
6. Cold water rinse.
7. Air dry.

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

REPLENISHMENT:

Regular additions of CHROLITE OLIVE-275 should be made based on visual observations and consumption patterns. When the bath is used continuously, the olive green colour changes and coating becomes iridescent and this can be corrected by adding regularly CHROLITE OLIVE 275.

Normally an addition of 800-1000ml. of CHROLITE OLIVE 275 is required to treat a work area of around 150 sq.ft.

NOTE:

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