PROTOCOAT CLR - 500

CHROME FREE SEALER FOR IMPROVED CORROSION RESISTANCE

PROTOCOAT CLR - 500 is used for applying transparent water based lacquer coatings on various metallic deposits. PROTOCOAT CLR - 500 is water soluble and is especially designed for providing a transparent coating on chromate passivated zinc deposits to improve the service life of the plated components to a remarkable extent. The clear coating of PROTOCOAT CLR - 500 can also be used to improve the weather resistance on copper and its alloys, nickel deposits, blackened and phosphatised coatings.

OPERATING CONDITIONS

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Specification</th>
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</thead>
<tbody>
<tr>
<td>Concentration</td>
<td>20 – 50 % by volume</td>
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<tr>
<td>Temperature</td>
<td>Room</td>
</tr>
<tr>
<td>Immersion Time</td>
<td>20 - 60 seconds</td>
</tr>
<tr>
<td>pH</td>
<td>8.5 - 9.0</td>
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<tr>
<td>Drying temperature</td>
<td>60 - 80°C</td>
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SOLUTION MAKE UP

Fill up the make up tank with clean water to half its volume. Add the required quantity of PROTOCOAT CLR – 500 and stir to make an homogenous solution.

OPERATION

The dilution of PROTOCOAT CLR - 500 in the ratio of 20 to 50 % by volume in water provides the proper coating characteristics for most applications. A solution having 40 – 50 % by volume of PROTOCOAT CLR 500 will give the maximum corrosion resistance for applications where a lesser protection is sufficient. A solution of 10 – 20 % v/v can be used.

It is advisable to introduce wet components in to PROTOCOAT CLR - 500 working solution. However, work should be rinsed well after pickling, blackening or cleaning to remove any acidic or alkaline material before immersing in PROTOCOAT CLR 500 solution. Acidic or alkaline materials left on the surface of the parts will reduce the corrosion resistance of the coating.

An operating temperature of 20 to 30°C is recommended and a uniform temperature is to be maintained throughout the operating solution.

To achieve optimum corrosion protection the parts should be dried in a drying oven or in case of small parts in a centrifugal drier. (minimum temp 50°C). The drying temperature of chromate parts should not exceed 60 – 80°C. When drying in centrifugal dryer, the revolution per minutes should be 40 – 70 in order to avoid excessive throw off of the PROTOCOAT CLR - 500 coating.

EQUIPMENT

Stainless steel, PVC or polypropylene tanks can be used.

CONTROL

To avoid precipitation of solid components the pH value of PROTOCOAT CLR 500 has to be maintained between 8.0 - 8.5 by adding chemically pure ammonium hydroxide.

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NOTE:

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