SEAL PASS 500

SEALER FOR IMPROVED CORROSION RESISTANCE

SEAL PASS 500 is used for applying transparent, uniform, bright water based lacquer film on various passivation layers. SEAL PASS 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. It also improves the heat resistance and reduces the coefficient of friction.

The clear coating of SEAL PASS 500 can also be used to improve the weather resistance on copper and its alloys, nickel deposits, blackened and phosphatised coatings.

The top coat can be easily removed in 10% sodium hydroxide solutions for re-work components and cleaning of racks.

OPERATING CONDITIONS

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Conditions</th>
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</thead>
<tbody>
<tr>
<td>Concentration</td>
<td>10 – 30 ml/l</td>
</tr>
<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 ºC</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 SEAL PASS 500 and stir to make a homogenous solution.

OPERATION

It is advisable to introduce wet components in to SEAL PASS 500 working solution. However, work should be rinsed well after prior to post treatment in SEAL PASS 500 to remove any carry over of contamination before immersing in SEAL PASS 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 ºC 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 50ºC). The drying temperature of chromate parts should not exceed 60 – 80º C. When drying in centrifugal dryer, the revolution per minutes should be 40 – 70º C in order to avoid excessive throw off of the SEAL PASS 500.

EQUIPMENT:

Stainless steel, PVC or polypropylene tanks can be used.
CONTROL:

Replenishment can be done by replenishing missing volume with fresh solution, corresponding to the first make up. To avoid precipitation of solid components, the pH value of SEAL PASS 500 has to be maintained between 8.0 - 8.5 by adding chemically pure ammonium hydroxide.

NOTE:

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