

TECHNICAL DATA SHEET

GOLDEN PASSIVATION G-108

The Golden Passivation G-108 is a highly stable process which gives thick and bright chromate layers on zinc and cadmium coatings. The different shades like bronze iridescent, Yellow iridescent gold, blue bright and clear iridescent can be obtained by varying concentration of solution, immersion time and bleaching procedures.

OPERATING CONDITIONS :

Golden PassivationG-108	10-25 cc/l
Nitric acid (36° Be)	2-4 cc/l
Time	5-30 sec
pH	1.2-1.8
Temperature	Room

BATH PREPARATION :

Fill the tank 2/3rd of full water and add calculated amount of Golden Passivation G-108 and stir to mix. To this add calculated amount of 36°Be Nitric Acid and make up the level with water.

OPEARTION :

Zinc or Cadmium coated components are rinsed thoroughly and immersed in the Golden Passivation G-108 baths and is agitated thoroughly to wet the entire surface. Immersion time depends upon temperature, concentration and life of the solution. After passivations it should be rinsed thoroughly in running water.

DRYING :

A cold air centrifugal drying is recommended warm air or hot water drying below 60°C.

EQUIPMENT :

Stainless steel, plastic or plastic lined tanks are recommended.

CONTROL:**DETERMINATION OF GOLDEN PASSIVATION G-108:**

Transfer 10 ml sample into 500 ml Erlenmeyer flask. Add 250 ml distilled water and 10 ml of 10 % KI. Then add 10 ml 50% Sulphuric acid. Titrate with 0.1 N Sodium thiosulphate to within 1-2 cc of the end point. Add 1 ml of hot starch solution can continue titrating from a deep blue to colourless end point.

CALCULATION :

Golden Passivation G-108 (ml/ litre)= ml of Sodium thiosulphate X Normality X 8

DETERMINATION OF NITRIC ACID :

Transfer 1 ml sample into 500 ml Erlenmeyer flask. Add 5 droops of phenolphthalein. Titrate with 0.1 N Sodium hydroxide to a first definite pink which holds for several seconds.

CALCULATION :

ml Sodium Hydroxide X Normality X 0.3 = litre of 36°Be Nitric acid per 100 liters of solution.

CAUTION :

Golden Passivation G-108 solution is oxidizing in nature. In case of splash to the eyes or contact with the skin, flush it with plenty of water for minimum of 15 minutes. Contact Physician if necessary.

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