

## **TECHNICAL DATA SHEET**

### **METFIX P – 300 WD**

#### **(ZINC PHOSPHATE IMMERSION COATING)**

Metfix P – 300 WD is a accelerated process for producing zinc phosphate, coating on iron and steel surfaces prior to cold forming, wire drawing, heading, tube drawing both for wet and dry processes. The coating meets Indian standard specification IS 3618 – 1966.

#### **PROCESS :**

The surface of the wire should be free from oil, grease, dirt, rust and scale. The phosphating process consists of following steps.

- Degreasing
- Water Rinsing
- Pickling
- Water Rinsing
- Phosphating
- Water Rinsing
- Drying

#### **MAKE UP per 1000 ltr :**

- Fill the tank with water slightly below the operating level.
- Add 30 – 40 lts of Metfix P – 300 WD.
- Bring the level to the operating level by adding water.
- Heat the solution

#### **OPERATING PARAMETERS :**

- Total Acid                      20 – 25 pts
- Temperature                    65 – 75°C.
- Time                                10 - 15 min.

## TESTING AND CONTROL :

### Pointage : ( Total Acid )

- Pipette out 10 ml bath solution in a 500cc conical flask.
- Add about 25 – 50 ml of DM water.
- Add 4 – 5 drops of phenolphthalein Indicator and titrate with 0.1N NaOH till permanent pink colour.
- The no. of ml of 0.1N NaOH required for titration gives total acid points ( pointage ).
- Maintain the pointage between 20 – 25. If the pointage is below the given strength, add 2 ltrs / 1000 ltrs for each point .

## EQUIPMENT:

Tanks and housing can be fabricated from mild steel plate, SS314L and SS316L.

If gas fired burners are used they should be made of mild steel or equivalent.

## HANDLING AND SAFETY PRECAUTIONS:

Metfix P – 300 WD is acidic in nature. rubber gloves and aprons should be worn while handling. In case of contact with skin, flush with plenty of cold water.

## WASTE DISPOSAL:

Solution of Metfix P – 300 WD are acidic and contain zinc metal. Consult experts with regard to waste disposal regulations and process.

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