

## **TECHNICAL DATA SHEET**

### **ALBOND S-52**

#### **ZINCATE PROCESS FOR PLATING ON ALUMINIUM**

Albond S-52 is a process for activating aluminium by producing dense, uniform zinc coating by immersing so that aluminium can be subsequently electroplated with copper, chromium, nickel, tin and cadmium and silver with excellent adhesion.

Albond S-52 can be used on aluminium strips, castings, forgings and all commercial aluminium alloys.

#### **OPERATING CONDITIONS:**

Concentration	Full as supplied
Temperature	Room
Time	20 seconds to 100 seconds

#### **MAKE – UP:**

Albond S-52 is a liquid ready to use product which is directly added to the tank for starting the operation. Immersion time can be observed visually to get uniform light gray coating. Excess immersion time causes spongy deposits. On certain high silicon containing alloys double zincating process is recommended.

#### **CYCLE:**

##### **(Aluminium alloys with containing copper)**

- Soak cleaning.
- Water rinse.
- Water rinse.
- Nitric acid dip. Concentration 50-70%
- Water rinse.
- Water rinse
- Zincating in ALBOND S-52.

- Water rinse.
- Water rinse.
- Electroplate.

**(Aluminium alloys containing high silicon and copper.)**

- Soak cleaning.
- Water rinse.
- Water rinse.
- Nitric acid                      500-700ml/l
- Acipivator 670                 90-100gm/l
- Water rinse.
- Water rinse
- Zincating in Albond S-52.
- Water rinse.
- Water rinse.
- Electroplate.

**EQUIPMENT:**

Albond S-52 solution may be contained in a steel tank or PVC or polypropylene lined tanks- fitted with air agitation oils to provide mild agitation during processing aluminium parts.

**CONTROL:**

- Concentration of Albond S-52 is observed visually.
- Increase in gassing indicates low concentration of Albond S-52. In such case the concentration should be increase by 10-15%.

**CAUTION:**

Albond S-52 is strongly alkaline in nature and contact of the skin or eyes should be avoided.

**DISCLAIMER:**

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