

TECHNICAL DATA SHEET

SEALER - 20

SEALER – 20 can be used on top of all passivate of zinc and zinc alloys for improving corrosion protection.

SEALER – 20 is a water based dilutable product and gives transparent film thickness of 2 – 6 microns on blue and yellow passivation.

OPERATING CONDITION:

	RANGE	OPTIMUM
SEALER – 20	60 – 120 ml/l	100 ml/l
pH	9 – 11	10
Time	10 – 30 sec	20 sec
Curing Temperature	50 – 90°C	70°C
Agitation	Mechanical	

EQUIPMENT:

TANKS:

Steel tanks can be used. steel tanks with PVC / PP lined can also be used.

HEATING:

Stainless steel coil can be used.

PROCESS:

- Zinc plating
- Water rinse
- Water rinse
- Passivation
- Water rinse
- Water rinse
- SEALER – 20 (time 20 – 40 sec)
- Drain
- Hot air dry.

BATH CONTROL:

Take 10 ml bath solution in 250 ml conical flask.

Add 2 – 4 drops phenolphthalein indicator and titrate against 0.1 N sulphuric acid till colour less end point.

% of solution = reading x normality of H₂SO₄ x 5.42

REPLENISHMENT:

12 ml of SEALER – 20 is required to increase concentration by 1 %.

DISCLAIMER :

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