SEAL RINSE AM-25

RINSE PASSIVATOR TONER. AM- #25 is a final rinse passivation treatment for Iron and Zinc phosphate treatment processes. Provides a material with an alkaline ph of 8+ (typical) which controls flash rusting and oxide formation on steel parts.

#25 provides a superior surface which is receptive to painting, powder coatings and adhesive coatings. Provides enhanced bonding of all types of coatings. Does not interfere with quality corrosion resistance and bonding of coatings.

#25 will provide improved bonding and corrosion resistance of applied coatings. AM-25 has been used to help minimize the problems of out gassing on cast metals also. Provides surface activity.

Features & Benefits

Easy to control.
Non-phosphated

Operates at a wide chemical use range. 1/4- 1.0% typical or as needed.,
Excellent performance when used with a final deionized water rinse.

Prevents flash rust and oxide on zinc and iron coatings.
Can be used in spray and immersion applications.

Physical Data

Specific gravity	1.01
Product Type	Liquid
PH	10+
LBs/Gal	8.42
Foam, 0=Low 9=High	0
Shelf Life Years	10 Years
Freeze Information	Not Damaged by Freezing

Operating Conditions/Typical Processing

3 STAGE CLEAN & COAT PROCESS:
1) Clean and Phosphate in pretreatment process
2) Rinse
3) #25 treated rinse, .1% by volume, 120 deg. F., 25 seconds.,
PH CONTROL 7.5 - 10.0 Target: 8.5 (Note: Water break free sheeting is needed use: Rinse aid # 8, #202, SURFCON 5310, or RINSE AID SS)
4) Dry parts
5) Paint.
*Can be used as short term flash rust protection on bare steel as well. Typically 1 -2%

Packaging

Container Type	POLY
Net Units	463
Tare Wt.	25 Lb
Gross Wt.	488
DOT_NAME	Not regulated by D.O.T
DOT Hazard	Not regulated

Use Parameters

Concentration Range	¼-3% by volume
Temperature Range	75-140 F.
Time Range	20 sec. – min, or per process
Agitation	Spray or dip

Waste Disposal

NEUTRALIZE

Holding Tank Materials of Construction:

STEEL, STAINLESS, OR POLY

Testing, Operating, & Trouble Shooting Data

Titration: (free Alkalinity, Preferred Method)
(1) Transfer 10 Mls To A Flask.
(2) Add 5-10 Drops Of Phenol Indicator
(3) Titrate With 0.1n Sulfuric Acid Until Color Changes From Pink To Colorless
(4) Multiply Number Of Mls Used By A Factor 0.33 = % By Volume.

Other Indicators That Can Be Used: (total Alkalinity Method)
Bromophenol Blue, Bromocresol Purple, Or Total Alkalinity Indicator:
(1) Transfer 10 Mls To A Flask.
(2) Add 5-10 Drops Of Bromo Blue, Purple Or Phenol Indicator
(3) Titrate With 0.1n Sulfuric Acid Until Color Changes
(4) Multiply Number Of Mls Used By A Factor 0.33 = % By Volume.

Field Dropper Titration -nt 11/5/18
1) Take A 10 Ml Sample Of Solution
2) Add 5 Drops Of Indicator #6, Bromocresol Purple
3) Add Drop By Drop Of 1.0n Acid Until The Solution Changes From Purple To Yellow
4) The Number Of Drops Required Multiplied By 0.19 = % By Volume
Ex) 27 Drops = 5%

Conductivity Reference
5% Conductivity = 700

Other Information

It is important that the OSHA DATA, "Material Safety Data Sheet" be carefully read and reviewed with the users of this product. OSHA data is required to be posted in the work area by law.

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Our People. Your Problem Solvers.

For more information on this process,
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