

Phos Black #2

INTRODUCTION:

Phos Black #2 is a conditioning solution for incorporation into conventional zinc phosphate immersion systems to produce a matte black phosphate coating on steel parts.

Phos Black #2 is operated at ambient temperature, requires no accelerator and maintained by a minimum of chemical control.

EQUIPMENT: Phos Black #2 tanks should be constructed of fiberglass or rubber, PVC or Koroseal lined.

MAKE-UP:

Solution of Phos Black #2 is prepared as follows:

- Water 87% by volume
- Phos Black # 2 13% by volume

Phos Black #2 is designed for use in rack, basket, or barrel immersion systems. To avoid marking parts, while processing in barrel or basket, revolve the equipment very slowly, about 1 rpm.

PROCESS OPERATION:

1. Alkaline soak clean to remove oil and grease.
2. Cold water rinse to remove all traces of alkali cleaner.
3. Acid dip (25-50% hydrochloric acid) if necessary to remove rust or scale.
4. Warm water rinse
5. Phos Black #2 immersion time of 15 seconds to 3 minutes
6. Cold water rinse
7. Zinc Phosphate dip
8. Cold water rinse

CONTROL:

Once the bath is ready for use, record total acid and maintain at this operating level with additions of Phos Black #2.

1. Pipette 2 mls sample into a 100 ml beaker
2. Add 50 mls distilled water
3. Add 3-5 drops of phenolphthalein indicator
4. Titrate with 0.1N sodium hydroxide
5. Maintain total acid at new solution level

If the work is not black enough, add 0.25% by volume increments of Phos Black #2 until the desired color is obtained - 1 quart per 100 gallons of zinc phosphate dip solution.

Read the Material Safety Data Sheet before using this product.

DISCLAIMER:

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