



So Clean 801 Zincate Concentrate

So Clean 801 Zincate Concentrate is a non-cyanide, liquid material which is used to produce a thin zincate film on aluminum and aluminum alloys.

MAKE-UP AND CONTROL:

So Clean 801 Zincate Concentrate	3 gallons
Water	7 gallons
Temperature range	60 to 115°F

Zincate solutions run at room temperature. For treating very passive aluminum surfaces or shorter immersions times, heating to a maximum of 115°F may be required.

The immersion time depends on the temperature, the alloy being processed, and the passivity of the aluminum surface.

The correct immersion time necessary for any particular alloy can be quickly determined. If the alloy reacts vigorously with the solution, the immersion time must be short. If there is no visible reaction, the immersion time will be from 30 seconds to 2 minutes.

Too long an immersion time will result in a spongy, poorly adherent coating. A uniform, light gray coating should be deposited. If the coating is spotty or bare in certain areas, the preparation of the aluminum surface may be faulty. Occasionally, a consistent dark coating occurs, particularly on 2011 aluminum. However, the film is still satisfactory for plating and gives excellent adhesion.

The best operating temperature range is from 60 to 75°F. Higher temperatures tend to accelerate the formation of the zinc film to a degree where it may become porous or spongy. This is particularly true of some of the more active alloys. Thus, it is advisable to have a cooling coil available for use during hot weather.

Control can be maintained by chemical analysis for density and/or zinc metal.

Standard conditions

Specific Gravity	1.17 (21 Baume)
Zinc Concentration	2.2 oz/gal (16,400 ppm)

In some cases, these operating values may be adjusted for particular alloys if immersion time is not easily changed.

CAUTION: This product is extremely caustic in nature. Contact of the solution with skin or eyes should be avoided. In case of contact, flush contaminated area with a large amount of water. When handling this product, protective clothing, i.e. rubber apron, gloves, boots, and goggles should be worn.

Read Material Safety Data Sheet before using this product.

DISCLAIMER:

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