



Aussiemet



AussieCoat Plus (concentrated)

Technical Chart

Aussiemet AussieCoat Plus concentrated, passivation process for tarnish resistance on ferrous and non ferrous metals. The characteristic as follows:

- ◆ Long lasting protection against oxidation
- ◆ Maintains shine and color
- ◆ Excellent skin tolerance
- ◆ Ideal for rack, barrel and continuous line plating
- ◆ Corrosion protection against hydrogen sulfide, UV radiation, synthetic sweat and humidity
- ◆ Can be used by both ways i.e. Electrolytic and Non Electrolytic
- ◆ Easy to dispose of used solution as it is biologically harmless

Technical Specification

OPERATING TEMPERATURE	40-60 °C
VOLTAGE	4-5 volts (electrolytic way)
TREATMENT TIME	7-10 minutes
ANODE	Platinised Titanium (Pt) or Mixed Metal Oxide (MMO)
AGITATION	Moderate
pH	5-7 and 3-4 after dissolution of OZ SALT

Deposition Data

COLOR	Transparent
THICKNESS	Approx 0.001-0.010 μm
ASPECT	Totally Transparent

Equipment

Preferably PP Tank or Glass Tank provided with thermostat controlled heaters. Rectifier with adjustable voltage up to at least 10 volts only for Electrolytic way.

Application Instructions

Non Electrolytic Use:- For optimum results the solution must be in a transparent state. Heat to 60°C. The solution becomes transparent in this range as higher temperatures will destroy the bath components and at lower temperatures solution will not work effectively.

Electrolytic Use:- In case of electrolytic usage through direct current application add 2.5 gms of OZ SALT (conducting salt) per liter of ready to use solution and wait their complete dissolution. Then heat up at the same temperature of the non Electrolytic usage and apply a voltage using a DC power-rectifier in the range of 3.5 - 4.5 V for 6-7 minutes.

PRETREATMENT

- ◆ Electroclean or ultrasonic clean parts to ensure they are free from grease
- ◆ Rinse with deionised water
- ◆ Activate parts in 10% v/v Sulphuric Acid for about 10 - 20 secs
- ◆ Dry

Non Electrolytic Usage:- Dip in AussieCoat Plus solution for 10 minutes (with moderate agitation)

Electrolytic Usage:- Dip in AussieCoat Plus with OZ SALT (conducting salts) previously dissolved in for 6-7 minutes with moderate agitation at about 3.5 - 4.5 V

- ◆ Rinse with deionised water
- ◆ Rinse in hot water (75-80°C)
- ◆ Dry using hot air (Avoid using pressure steam which could remove passivation)

Additional Information

Bath Make-up

Add 10ml-20ml per liter of Aussiecoat plus concentrated into DI water.

Storage:-

Store at temperatures below 35°C, avoid direct sunlight. In the closed original package the solution is stable for about 24 months. Once open it is recommended to use it within 6 months. A color change from white to yellow may be sometimes observed during the storage, even in a sealed new bottle. This change in color doesn't affect the properties of the product.

Removal of Passivation Layer:-

The passivation layer can be completely removed by cathodic degreasing in an alkaline degreasing bath such as AussieClean 505.

Replacing the Passivation Solution:-

In case of reduction of the volume due to water evaporation, solution has to be replenished by deionised water. AussieCoat Plus concentrate should be added to the solution if the effectiveness of the passivating solution becomes weaker. Effectiveness of the solution can be checked by the level of the surface hydrophobicity. Properly working solution should give a surface with low water adherence, where water drops slip away easily.

Filtration:-

Not recommended as active compound might be absorbed by the filter.

pH Value:-

No control required. Weakly alkaline.

Disposal of Spent Solutions:-

Aussiemet always recommends treat spent solutions in accordance with the in place regulations.



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