



PT. SINAR CEMARAMAS ABADI

- VERCOPPER (ACID / CYANIDE COPPER)
- VERNICKEL
- VERCHROME
- VERZINC ACID / CYANIDE ZINC
- CLEANER (ELEKTRO / SOAK)
- PHOSPHATING
- CHROMATING
- ELECTROLESS NICKEL

FOR HIGHTECT ELECTROPLATING :

- ELECTROLESS NICKEL PLATING FOR ALUMINIUM AND ZINC DIE CAST, MAGNESIUM
- GOLD PLATING
- PTFE FORELECTROLESS NICKEL
- HARDCHROM
- SAND CAST ALUMINIUM ALLOYS PLATING
- MAGOXID – COAT FOR PROTECTING MAGNESIUM SUBSTRATES

- KEPLA – COATING FOR ALUMINIUM AND TITANIUM ALLOYS
- ELECTROLESS NICKEL PLATING WITH INTEGRATED SILICON CARBIDE PARTICLES (SIC)

- GLISS – COAT
A CLEAN SOLID FILM LUBRICATION FOR A MAINTENANCE FREE PERMANENT LUBRICATION OF ALL KIND OF FRICTION PAIRINGS
- SEPA – COAT
(ANTI ADHESIVE COATING AND ACTIVATOR) FOR THE REMOVAL OF PART FROM MOULDS

ISOCHROME 10 BLUE CHROMATING

1. DESCRIPTION

ISOCHROME 10 blue chromating produces deep blue uniform chromate coating on zinc deposits. It is suitable for zinc deposit from cyanide. Cyanide free and weak – acid baths.

ISOCHROME 10 is delivered as liquid concentrate. For bath make – up and replenishing only

ISOCHROME 10 is used, the application of e.g. nitric acid required.

ISOCHROME 10 shows a long service life, this makes it particularly economical.

ISOCHROME 10 can be applied both in rack and barrel operation.

2. OPERATING CONDITIONS

	Optimum	Operating range
ISOCHROME 10 Blue chromating	7 ml/l	5 – 10 ml/l
pH – value	1.7	1.3 – 2.0
Temperature	25 oC	20 – 30 oC
Immersion time	20 sec	10 – 30 sec
Agitation	air agitation	Agitation of pieces
Tanks	plastics tank or stainless tanks	

Head Office :

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3. SOLUTION MAKE - UP

First fill – up the working tank to $\frac{3}{4}$ with clean water. Under stirring add now the required quantity of ISOCHROME 10 (7 ml/l). After having filled – up to the final volume the solution must thoroughly be mixed.

The ISOCHROME 10 blue chromating is now ready for use.

4. MAINTENANCE

The ISOCHROME 10 is easy to maintain. Depending on the intensity of the blue chromating deposit, resp. when this weakens, approx, 1.5 – 1.7 ml/l ISOCHROME 10 must be added.

For make-up of a new ISOCHROME 10 bath, please take care that approx. 5% of the old bath solution remain in the bath. There by it is ensured that a new make-up immediately very good results.

If no improvement of the blue chromate deposit can be obtained anymore, after replenishments of 1.5 – 1.7 ml/l ISOCHROME 10 each time, it is more advantageous to make – up a new bath.

5. SAFETY PRECAUTIONS

During handling and operation with blue chromatings the necessary protective clothing are to wear, in order to avoid any contact with skin or eyes.

6. WASTE WATER

The ISOCHROME 10 Blue Chromating reacts acid and contains hexavalent chromium compounds.

The waste water solution must be treated as law requires before being admitted to the public canalization.

The recommended protective clothes. Gloves and goggles are to wear while working the blue chromating.

These working instructions are based on laboratory values and practical experiences.

We have however no influence on the precise and conscientious use of our products.

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