



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 POWDER BLUE CHROMATING

Description

Isochrome 10 Powder blue chromating produces deep blue uniform chromate coating on surfaces deposited of zinc. It is suitable for zinc deposits from cyanide.

Isochrome 10 Powder can be reinforced without any problems. Depending on the immersion time, make-up quantity and working temperature, the chromating produces a medium up to very strong chromate coatings with an optimum corrosion resistance.

Isochrome 10 Powder can be applied both in rack- and barrel operation.

Bath Make-Up For 100 Litres

0.8 - 1 kg **Isochrome 10 Powder**

1.5 – 2 L **Nitric acid conc.**

First fill-up the working tank to $\frac{3}{4}$ with clean water. Under stirring, add now the required quantity of **Isochrome 10 Powder** 0.8 - 1 kg and **Nitric acid** 1.5 – 2 L. After having filled-up to the final volume, the solution must thoroughly be mixed.

The **Isochrome 10 Powder** blue chromating is now ready for use.

Working Conditions

Bath temperature	20 – 35 °C
Immersion time	15 – 30 seconds
pH value	0.8 – 1.5
Agitation	air blowing is recommended
Tanks	plastic tanks or stainless steel tanks

Maintenance

Isochrome 10 Powder can often be reinforced. If an impeccable working solution is not given anymore, we recommend a new make-up. **Isochrome 10 Powder** can be monitored analytically and replenished accordingly. As replenisher is **Isochrome 10 Powder** required. If the pH value is increased too fast, adjustments can be made with nitric acid.

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.

Head Office :

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Waste Water

Isochrome 10 Powder blue chromating contains hexavalent chromium compounds. All waste water has to be treated as law requires before being admitted to the public canalization.

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

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

Determination

Reagents

Isochrome 10 Powder

Sulfuric acid 1:1

Potassium iodide

Sodium thiosulfate solution 0,1 mol/L

Starch solution 1%

Pipette:

Procedure

10 mL

Bath in a 100 mL beaker, add

30 mL

water, add approx.

10 mL

Sulfuric acid 1:1, add approx.

1 g

Potassium iodide, the colour gets red-brown, titrate with Sodium thiosulfate solution 0,1 mol/L to light yellow colour, add approx.

2 mL

Starch solution 1%, colour gets dark, titrate with Sodium thiosulfate solution 0,1 mol/L to colourless solution.

Calculation:

Isochrome 10 Powder (g/L) = V (Sodium thiosulfate solution 0,1 mol/L) x 0,23 x F

F = Factor Sodium thiosulfate solution 0,1 mol/L

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