

P.T. SINAR CEMARAMAS ABADI

- VERCOPPER (ACID/CYANIDECOPPER)
 - 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 25

Yellow Chromating

1. DESCRIPTION

ISOCHROME 25 is a highly concentrated liquid chromate to produce yellow chromate coating on surfaces deposited from cyanidic, alkaline, and acid electrolytes.

A ready to use solution is made – up simply diluting isochrome 25 with normal water of 25 – 30 oC.

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.

2. BATH MAKE – UP FOR 100 LITRES

ISOCHROME 25 1 - 2 litres

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3. WORKING CONDITIONS

Bath temperature : 20 – 35 o C

Immersion Time : 5 - 30 seconds

pH value : 0.8 – 1.5

Agitation : air blowing – in is recommendable

Decoration : is very recommendable, since it extends the service life. We recommend a decoloration in 0.3 vol. % of nitric acid. Even better is a blue chromating before directly dipping in the yellow chromating.

Drying : with warm air, not over 60 oC.

4. MAINTENANCE

The higher the concentration and the temperature of the chromating solution are, the more intense and stronger is getting the chromate coating. The produced chromating coatings are in wide scopes scratch-free, resistant against moisture, do not crack or flake bending and are very stable against salt water.

If the time intervals between the necessary additions decrease, it is more economical to make up a new bath solution.

A newly make – up solution will require a certain break – in time, a fact which can be explained by lack of trivalent chrome in the solution, which is necessary for the formation of a good film.

For each new bath make – up it is therefore advisable to retain at least 10 % of the spent chromating solution in the tan and to add 90 % of the new bath make – up volume.

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5. SAFETY PRECAUTIONS

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

6. WASTE WATER

ISOCHROME 25 Yellow Chromating contains hexavalent chromium compounds.

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

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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