Coventya S.A.S.

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TECHNICAL DATA SHEET TDS00140UK

FINIGARD 200 A

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1 de 4	09/94	V.PASQUIER	L.MOUI	JJ.DUPRAT	1	

FINIGARD 200 A

COVENTYA

1 - INTRODUCTION

FINIGARD 200 A is a process designed for application to zinc-plated and chromated pieces, to improve their corrosion resistance, especially with regard to the specifications of the automotive industry.

Over 500 hours salt-spray before the appearance of red rust (on>10 mm zinc coatings)
With chromium VI free blue finish TRIAZUR
With yellow or olive drab chromates
Including a thermal shock treatment at 120°C

The process will also give a colourless appearance by decolorisation of yellow chromates films.

After tempering at 120°C or 150°C the corrosion resistance is still retained more than 200h without white rust.

2 - MAKE-UP

Fill the holding tank approximately three quarters full with water and heat to 35 to 50°C. Add the appropriate quantity of FINIGARD 200 A solution (in the range 5 – 20% v/v) and thoroughly mix. Make-up the operating level and temperature and again re-mix.

3 - OPERATING CONDITIONS

Parameters	Range	Optimum
FINIGARD 200 A	5 à 20%	10%
pH	11,1 – 11,65	11,4
Temperature	30°C – 70°C	60°C
Time	10 secondes – 3 minutes	Dependent on colour
Density	1,010 – 1,040	1,025

4 - OPERATION

The properly prepared work* is immersed in the FINIGARD 200 A working solution at a suitable temperature in the range 30 to 70°C, preferably 60°C, for a suitable time, normally in the range 10 to 180 seconds, for a proper coating to be formed.

After the FINIGARD 200 A treatment, the work should be thoroughly dried.

* Normal post-plated treatment would be water rinse, followed by a chromate passivation, followed by a water rinse.

Chromate film	Concentration	Temps
* Yellow (bleached finish)	5%	1' à 15"
* Yellow	5%	20" à 30"
* Olive	5%	20" à 30"
* Yellow	20%	2'30" à 3'
		until decoloration

5 - TESTING & CONTROL

5.1 Concentration

Accurately weigh a dry crucible. Call the weight Po. Pipette a 10ml sample of the wotking solution into the pre-weighed crucible and dry at 120°C for 1 hour. Allow the crucible to cool in a dessicator. Accurately re weigh. Call this weigh P1.

FINIGARD 200 A Concentration (%v/v) = (P1 – P0) x 34,1

5.2 pH

Measure the pH of the working solution using a glass electrode and pH meter or close range pH paper. The pH should be maintened in the range 11.1 to 11.65, preferably at 11.4. Use FINIGARD 200 A to adjust the pH.

6 - EQUIPMENT

Tanks	:	Polypropylen, PVC, or mild steel
Heating	:	- Electrical heaters should be of steel, or Teflon, or ceramic-coated - Do not use mild steel steam coils
Extraction	:	Not obligaroty but is recommanded to remove team, etc.

7 - TROUBLE SHOOTING

Corrosion resistance to white rust insufficient	*- FINIGARD 200 A Conc too low* *- pH is too low* *- Temperature is too low* *- Immersion time is too short*
Corrosion resistance to red rust insufficient	*- Plating thickness is low* *- FINIGARD 200 A Conc too low* *- Immersion time too short* *- Inappropriate chromate* *- FINIGARD is contaminated (Re-make FINIGARD)*
Yellowish tinge to blue chromate	*- Temperature is too low* *- When decolorising yellow chromate : yellow chromate out of balance*

* If the solution becomes contaminated, it will probably go turbid.

8 - INFORMATION ON FINIGARD 200 A

Description	:	Slightly hazy, viscous liquid
SG	:	1.190 to 1.215
pH	:	11.5 – 12.5
Shelf life	:	2 years from date of manufacture