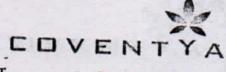
Coventya S.A.S.



TECHNICAL DATA SHEET

TDS00140UK

# FINIGARD 200 A

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### **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

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 31	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	

## **FINIGARD 200 A**

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### 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)  * Yellow  * Olive  * Yellow	5% 5% 5% 20%	1' à 15" 20" à 30" 20" à 30" 2'30" à 3'
	The second second	until decoloration

### 5 - TESTING & CONTROL

#### 5.1 Concentration

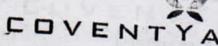
Accurately weigh a dry crucible. Call the weight Po. Pipette a 10ml sample of the working solution into the pre-weighed crucible and dry at 120°C for 1 hour. Allow the crucible to cool in a dessicator. Accurately re weigh. Call this weigh P1.

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.

## FINIGARD 200 A



### 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 colls

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		

<sup>\*</sup> 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