

SURCOAT 915

Low Temperature, Detergent Iron Phosphate

- * ONE STEP CLEANS AND YIELDS UNIFORM COATING WEIGHTS
- * SPECIALLY FORMULATED FOR MIXED-METAL LOADS
- * CONTROLLED LOW FOAM

SURCOAT 915 is an acidic liquid concentrate, which provides one-step cleaning and phosphatizing at economical low temperatures in either immersion tanks or power spray washers. **SURCOAT 915** also provides pH stability, controlled low foam, and excellent detergency for a variety of common shop soils.

OPERATING CONDITIONS

	<u>Spray</u>	<u>Immersion</u>
Concentration:	2-4% by volume	6-10% by volume
Temperature:	90 ^o -120 ^o F	90 ^o -120 ^o F
Time:	30 - 60 seconds	2 - 4 minutes
Nozzle pressure:	15 - 25 psi	

TYPICAL PROCESS

1. Clean and phosphatize, using **SURCOAT 915**.
2. Warm water rinse.
3. Final post rinse.

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To the best of our knowledge the information in this bulletin is true and accurate. However, since application of the products described herein is beyond our control both the product and the information is offered without guarantee as to their use. We assume no liability for incidental, consequential, or direct damages of any kind, no matter the cause, including negligence. *Nothing contained within this operating bulletin shall be taken as a recommendation to use any product in violation of any patent rights.

EQUIPMENT

Processing tanks, piping, pumps, and heat transfer surfaces constructed of mild steel will provide satisfactory service life. We recommend that all spray nozzles be made of 300-series stainless steel.

INITIAL CHARGING PROCEDURES

1. Fill the tank to two-thirds the final volume with clean, cool water.
2. Add the required amount of the product slowly; agitate to mix thoroughly.
3. Add cool water to increase the volume to the operating level. The solution is then ready to be heated to operating temperature.

SOLUTION CONTROL

Materials required: 10 ml pipette
125 ml glass flask
Automatic burette assembly
Indicator #1 (Phenolphthalein)
Titrating Solution #8 (1/10N Alkali)

Titration Procedure for Total Acid:

1. Pipette a 10 ml sample of the bath into a 125 ml glass flask.
2. Add 4-5 drops of Indicator #1 (Phenolphthalein).
3. Titrate with Titrating Solution #8 (1/10N Alkali) until the sample turns from the original color to just noticeably pink.

Concentration: mls of Titrating Solution #8 required times the product factor, 0.4, equals the concentration in percent by volume of product in solution.

mls T.S. #8	% by volume
5.0	2
10.0	4
15.0	6
20.0	8

Titration Procedure for Free Acid:

After adjusting the Total Acid to the correct range, determine the Free Acid level of the bath.

1. Pipette a 10 ml sample of the bath into a 250 ml glass flask.
2. Add 20 mls distilled water.
3. Add 4-5 drops of Indicator #3 (Bromocresol Green).
4. Titrate with Titrating Solution #8 (1/10N Alkali) until the solution changes from yellow to green.

The mls of Titrating Solution #8 required indicates the Free Acid of the bath.

Maintenance: Maintain the Free Acid between 0.3 and 0.5 mls.

During normal operation of the process, the Free Acid will decrease and additions of *SURCOAT SCB* will be required to increase the Free Acid to the desired range.

To decrease the Free Acid, the addition of 200 mls of *PH PLUS* per 1000 gallons of solution will decrease the Free Acid by 0.1 ml.

REPLENISHING

A bath made up at 4% by volume will have a titration of about 10 mls. The titration, bath concentration, should be maintained between 9.0 and 11.0 mls.

The addition of 0.4 of a gallon of the product per 100 gallons of solution will increase the strength approximately 1.0 ml.

PRECAUTIONARY INFORMATION

The following suggestions for handling have been prepared in accordance with a pattern established by the American National Standards Institute, Publication ANSI Z 129.1 (1994).

WARNING! **CONTAINS AN ACID SALT
CAUSES EYE IRRITATION
AVOID CONTACT WITH EYES, SKIN, AND CLOTHING
WEAR FACE SHIELD, GLOVES AND APRON WHEN HANDLING
THIS MATERIAL
WASH THOROUGHLY AFTER HANDLING**

First Aid: **In case of contact, immediately flush eyes with plenty of water for at least fifteen minutes; ensure water flushing of entire surface of eye and lid. Obtain medical attention. Flush skin with plenty of water for fifteen minutes, then wash with soap and water. Remove contaminated clothing promptly; launder before re-use.**

WASTE DISPOSAL

When it becomes necessary to discard the processing solution, neutralization of the acidity, precipitation of the dissolved metals and phosphates, and further treatment may be required to meet local, state, and federal waste control regulations. Your Coral consultant will assist you in selecting the proper Coral waste treatment products to efficiently fulfill these regulations.

STORAGE

To meet pollution control regulations now being enforced by several states, we recommend that **all chemical products** be stored and used in areas which will not permit direct access to sanitary or surface drains. These areas should be constructed in such a manner that any chemical lost can be either salvaged or suitably treated to prevent pollution of natural waters.

PHYSICAL PROPERTIES

Liquid, clear
Water-white
Density: 10.0 lbs/gal