



TECH DATA SHEET

1. PRODUCT AND COMPANY IDENTIFICATION

POWDER 365 - CORAK SEAL

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Supplier Powder 365

82 Green Acres Circle

Lavonia GA 30553

For non-emergency information contact: 1-877-350-2343

CORAK SEAL

Reactive non-chrome final seal for use with iron and zinc phosphates. Can provide the performance of chrome seals without the use of chrome.

PRIMARY APPLICATION

CORAK SEAL is a non-chrome final seal for phosphate conversion coating processes. It is applicable on steel, aluminum, zinc and their alloys. CORAK SEAL reacts with the phosphated metal surfaces to enhance paint adhesion and corrosion resistance properties. It can impart some in-plant temporary rust protection. CORAK SEAL resists growth of biological contaminants.

APPLICATION PROCEDURE

All surfaces should be cleaned and treated with an appropriate conversion coating. Application must be preceded by a fresh water rinse stage, which should include a final fresh water riser, with the overflow directed toward the preceding rinse stage.

CORAK SEAL is used in the final rinse stage of an immersion or spray phosphating process under the following conditions:

- concentration..... 1.0 – 1.5 % by volume
- points..... 3.4 – 5.2 ml
- temperature..... 70 – 110°F (21 – 43°C)
- time..... 15 seconds minimum
- pressure 15 psi (0.7 – 1.0 bar)
- TDS (conductivity)..... 600 ppm TDS (900 ·S/cm) maximum

For best performance, do not use a final water rinse after Gardolene D 6871. Oven drying is recommended. Forced air is recommended to remove excess solution from pockets or cavities.

SOLUTION CONTROL

Gardolene D 6871 is controlled by the following procedure:

1. Place a 100 ml bath sample into a 250 ml Erlenmeyer flask.
2. Add 5 – 10 drops of Neutral Red Indicator. The color will be yellow.
3. Titrate with 0.1 N Acid until the solution turns from yellow, through pale orange to pale red.

4. Record the milliliters of 0.1 N Acid used. This is the points.

If desired, the points can be converted to percent by volume by multiplying by 0.29.

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NOTES ON USE - See Material Safety Data Sheet

A fresh CORAK SEAL solution should be changed when the TDS exceeds 600 ppm or the conductivity exceeds 900 \cdot S/cm.

A CORAK SEAL solution will normally have a pH of about 8 – 10. The pH will normally decrease somewhat as the solution ages. It is not necessary to monitor or adjust the solution pH.

For best performance, water for bath make-up should not exceed the following limits:

TDS375 ppm (550 \cdot S/cm)

Chloride plus Sulfate70 ppm

EQUIPMENT

Mild steel equipment and heating surfaces may be used.

SAFETY AND HANDLING

Prior to handling and use of any of the materials referenced in this document, the Material Safety Data Sheets should be read and understood by all personnel in contact with these materials.

KEEP OUT OF REACH OF CHILDREN

STORAGE

Dry indoor storage at temperatures between 40°F and 100°F is recommended, away from any incompatible materials referenced in the Material Safety Data Sheets. All containers should be tightly closed when not in use.

DISPOSAL

Any disposal of the materials referenced in this document should be in accordance with all applicable federal, state, and local regulations.

The process solution can contain components other than those present in the materials as supplied.

Analysis of process solutions may be required prior to disposal.