



POWDER 365 -ONE STEP NO RINSE IP TECH DATA SHEET

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Supplier Powder 365

82 Green Acres Circle

Lavonia GA 30553

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

One Step Detergent Iron Phosphate for Manual High Pressure Spray or Steam Application, Molybdate free

PRIMARY APPLICATION

Oakite Gardobond A 4961 is a liquid one step manual phosphating product formulated to simultaneously clean and prepare large parts for painting. It is designed for use in manual applications utilizing a high-pressure spray or steam unit. What makes Oakite Gardobond A 4961 unique is that it can be used without a subsequent rinse.

The coating developed by Oakite Gardobond A 4961 provides increased paint adhesion under today's modern finishes.

Oakite Gardobond A 4961 has excellent cleaning capabilities. The surfactant package was chosen to remove typical soils used in the manufacture of large parts. It was proven to have superior cleaning properties compared to the manually applied detergent iron phosphates available today. What's more, Gardobond A 4961 is biodegradable.

It has been formulated to overcome the effects of hard water and reduce streaky coatings, both chronic problems in treating large parts.

Consult your Oakite Technical Sales Specialist for information on Oakite application equipment - steam generators (portable & stationary), hot/high pressure units, spray wands and associated equipment.

CHEMICAL CHARACTERISTICS

- chemical composition ..... phosphates, activators, wetting agents, surfactants
- physical form ..... pale yellow liquid
- odor ..... slight amine
- specific gravity ..... 1.140 @ 20°C (68°F) ASTM 1298
- bulk density..... 9.5 lb./gal @ 20°C (68°F)
- biodegradable surfactants ..... yes

color - concentrated ..... pale yellow  
- as used ..... clear  
behavior in hard water ..... good  
pH - concentrated..... 3.3-3.7  
- as used..... 3.5-4.5 @ 1% by volume  
maximum solubility ..... complete

#### APPLICATION PROCEDURE

Oakite Gardobond A 4961 may be applied by a manual high-pressure spray or a steam unit under the following

process parameters:

Concentration .....0.5 to 2.0% at the nozzle

pH.....3.5 to 4.5

Time .....as required

Temperature.....dependent on application equipment. Sump solutions max. 140°F

Solution Control: Oakite Gardobond A 4961 is controlled using Gardotest Procedure 154.

Sample Size: 25.0 mls Factor: 0.13

ISO 9001:2000

FM 93653

#### EQUIPMENT

The Chemetall Oakite Electro-Steam Generators, Hot Hi-Pressure Washers, or Pressure Island systems can be

used to steam/hot water clean or phosphatize larger parts using this product. Please contact the Chemetall

Oakite Process Equipment and Engineering Department for specific recommendations.

#### NOTES ON USE (See Material Safety Data Sheet)

Stainless steel tanks and equipment are recommended, preferably types 316 or 321. Mild steel can be used,

but the life of the equipment will be reduced due to the corrosive nature of acidic phosphate products.

#### Heating

coils and equipment should be constructed of stainless steel.

Avoid contact with or mixing with chlorine-releasing materials.

#### SAFETY AND HANDLING

Prior to handling and use of Gardobond A 4961, the Material Safety Data Sheet should be read and understood

by all personnel in contact with the product.

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 Material Safety Data Sheets. All containers should be kept 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. Process solutions can contain components other than those present in the materials

as supplied. Analysis of process solutions may be required prior to disposal.

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use by buyers having necessary industrial skill and knowledge. Buyers should undertake sufficient verification and testing to determine the suitability of the Oakite materials for their own particular purpose.

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