ADVANCE Chemicals
5-8 Malton Court, Altona Victoria, 3018
P.O. Box 164, Altona Victoria, 3018
Telephone: (03) 9398 4444
Web: www.advancechemicals.com.au
Email: info@advancechemicals.com.au

PHOSCOAT A LA1061

Gives a medium to heavy coating of iron phosphate on iron

PHOSCOAT A LA1061 is a one component alkali-phosphating chemical. It will clean and phosphate ferrous metals in the one operation.

PHOSCOAT A LA1061 is used for both bath make up and bath replenishment. This coating improves the adhesion of paint and reduces corrosion. It is used by spraying or immersion.

PHOSCOAT A LA1061 is recommended for:

- Light cleaning and heavy phosphate coatings on iron and steel in the one operation.
- It gives a suitable coating for a subsequent chromate seal.

PHOSCOAT A LA1061 has been **designed:**

1. To impart medium corrosion and humidity resistance to iron and steel. Performance is further improved by using a chromate seal in the final rinse.
2. To impart excellent paint adhesion to the metal in subsequent painting operations.
3. To maintain its high performance characteristics with only low maintenance to the phosphating bath.

CHEMICAL AND PHYSICAL PROPERTIES

Appearance:	Clear, thin liquid
Flash Point:	Non-flammable
Specific gravity:	1.1
pH (1% solution):	4 - 5.5
Odour:	Low odour

DIRECTIONS FOR USE:

For best cleaning **PHOSCOAT A LA1061** should be used by a spray process. It will clean light soil and phosphate in one operation. It may also be used in an immersion bath.

Spray Application:

Three (3) Stage Line

1. The metal must be moderately clean prior to phosphating. Remove heavy rust manually. Remove heavy soil by solvent cleaning or by hot tank degreasing followed by thorough rinsing.
2. Cleaning and Phosphating: Use 20 - 50 lt of **PHOSCOAT A LA1061** per 1000 litres of bath solution. Heat the bath to 35 - 60^{o}C. Circulate for at least 10 minutes to ensure good mixing. Spray for 1 - 3 minutes or immerse for 2 - 5 minutes. Agitation of an immersion bath assists cleaning. The pH should be 4 - 5.5. Contaminants like oil and grease will accumulate on the bath surface over time and should be removed by flooding to the tank overflow.
3. Rinse thoroughly with cold water, using an overflowing rinse. Spray for 30 - 60 seconds at room temperature.

Four (4) Stage Line

As above with a precleaning spray of 10 - 30 lt of **PHOSCOAT A LA106** 1 per 1000 lt of water.

Spray for 1 - 3 minutes at a pH of 4 - 6.

Operating Details

Make Up	**Pre-clean Spray**	**Clean and Phosphate**
Concentration	1 - 3% by volume	2 - 5% by volume
pH	4 - 5.5	4 - 5.5
Temperature	35 - 60^{o}C	35 - 60^{o}C
Time	1 - 3 minutes	1 - 5 minutes
Pressure	100 – 170kPa (15 – 25 psi)	100 – 170 kPa (15 – 25 psi)

Immersion Process:

1. The metal must be fairly clean prior to phosphating. Clean with an alkaline detergent.
2. Rinse thoroughly with cold water using an overflowing rinse.
3. Phosphating: A one stage phosphating treatment is normally used.
4. Rinse thoroughly with cold water using an overflowing rinse.
5. Optionally a chromate sealing rinse may be used. This may be used hot to assist in drying.
6. Dry and paint.

Operating Details

Concentration	3 - 5% by volume
pH	4 - 5.5
Temperature	45 - 60^{o}C
Time	2 - 5 minutes

Control Procedure.

Titrate a 10 ml sample with 0.1N Sodium Hydroxide to the phenolphthalein end point.

Bath concentration = Ml of 0.1N Sodium Hydroxide * 0.43 = % **PHOSCOAT A**