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WARNING:

**This chemical is formulated
for industrial use only**

Contact with skin or clothing or other improper handling or use of this product may result in bodily harm or other damage. Before using or mixing the contents with other substances, all labels applied to container, the applicable Technical Data Sheet and Material Safety Data Sheet should be read and specific instructions and precautions followed to assure correct use and personal safety.



PASSIVATOR 20

INTRODUCTION

PASSIVATOR 20 is an acidic, liquid passivating chemical used in either an immersion or spray final rinse to improve paint adhesion and minimise under-film corrosion and blistering, especially on iron phosphate conversion coatings.

PASSIVATOR 20 is adaptable to automatic bath control on multistage spray installations.

MAKE-UP AND OPERATION

Fresh baths are normally made up with 4.0 litres of PASSIVATOR 20 per 1000 litre of bath.

Temperatures from ambient to 80°C are suitable. Contact time is 5-30 seconds, and spray application requires a nozzle pressure of 70 - 100 kPa.

The working bath is controlled by two titrations and a pH check.

EQUIPMENT

Tanks, pipe work etc for PASSIVATOR 20 baths may be constructed of mild steel.

● *Bringing the Best Products to the Surface* ●

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TECHNICAL DETAILS

BATH MAKE-UP AND CONTROL

(a) Make-up of Fresh Bath

For each 1000 litres of water in the bath add with stirring:

PASSIVATOR 20 – 4.0 LITRES

(b) Control Points

Bath Concentration	:	4.0 litres / 1000 litres
pH	:	4.0 - 6.0
Temperature	:	Ambient - 80° C (180F)
Contact Time	:	5-30 seconds
Pressure	:	70-100 kPa (10-15psi)

OPERATIONAL RECOMMENDATIONS

(i) PASSIVATOR 20 baths may be operated at any temperature up to 80° C, though in general, the lowest temperature which will not impede subsequent drying of the work is recommended.

(ii) If the work has seams or pockets where PASSIVATOR 20 may be trapped, a supplementary rinse with deionised water is advisable.

(iii) Waters exceeding 200 ppm of alkalinity (expressed as CaCO₃), or 225 ppm of chlorides, sulphates and alkalinity are unsuitable for use in PASSIVATOR 20 baths, because the retention of soluble salts can lead to under paint blistering. Conductivity of the fresh water should not exceed 800 micro siemens at 55°C.

PLANT MAINTENANCE

Screens (to protect circulating pumps and nozzles) should be cleaned daily.

Nozzles should be checked for alignment and blockages, and a regular programme of removal and cleaning adhered to.