

## TECHNICAL DATA

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THIS CHEMICAL IS  
FORMULATED FOR  
**WARNING** 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.

# DUOPHOS

## PRODUCT DESCRIPTION

DUOPHOS is a dual acting cleaner and iron phosphate which can be used in 2 stage machines without rust blushing problems. DUOPHOS simultaneously cleans and phosphates steel, zinc and aluminium surfaces. It can be applied by spray or immersion.

DUOPHOS provides the following advantages:

- Phosphates steel, zinc and aluminium
- Liquid product, suitable for autodosing
- Low temperature operation
- Excellent base for paint
- 200-400 mg/sq metre blue phosphate formed

## BATH MAKE-UP AND CONTROL POINTS

Spray:	30-50 litres of DUOPHOS per 1000 litre bath
Immersion:	50-80 litres of DUOPHOS per 1000 litre bath
Time:	1-5 minutes
Spray Pressure:	100-200 kpa (15-30psi)
Titration:	Spray 3-8
(Bath Pointage)	Immersion 6-15
pH	4.8-5.8
Temperature	45° - 55° Celcius

## BATH TITRATION:

- Place a 10ml sample of bath into a conical flask, add 100 ml of D.I. water
- Add a few drops of phenolphthalein indication
- Titrate with 0.1N SODIUM HYDROXIDE SOLUTION until a permanent pink colour is achieved.
- The number of mls of 0.1N SODIUM HYDROXIDE used is the bath pointage.
- Add 4 litres of DUOPHOS for each millilitre below recommended pointage - per 1000 litre tank volume

## RINSING

After DUOPHOS treatment work should be rinsed with fresh water. For optimum corrosion protection a PASSIVATOR should be used in the final rinse.

## DRYING

Work should be dried as quickly as possible at a temperature not exceeding 150°C.

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