

## TECHNICAL DATA

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THIS CHEMICAL IS  
FORMULATED FOR  
INDUSTRIAL USE ONLY

#### WARNING

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.

# HIPHOS

## PRODUCT DESCRIPTION

HIPHOS is a versatile low temperature iron phosphate process which simultaneously cleans and phosphates steel, zinc and aluminium surfaces. It can be applied by spray or immersion.

HIPHOS provides the following advantages:

- Phosphates steel, zinc and aluminium
- Cleans and phosphates in single operation
- Liquid product, suitable for auto dosing
- Low temperature operation
- Excellent base for paint
- For use in 3 stage machines or higher

## BATH MAKE-UP AND CONTROL POINTS

Spray:	20-30 litres of HIPHOS
per 1000 litre bath	
Immersion:	40-60 litres of HIPHOS
per 1000 litre bath	
Time:	1-5 minutes
Spray Pressure:	100-200 kpa (15-30psi)
Titration:	Spray 4-6
(Bath Pointage)	Immersion 8-15
pH	4.2-5.5
Temperature	25° - 50° 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 5 litres of HIPHOS for each millilitre below recommended pointage - per 1000 litre tank volume
- pH - should be adjusted using ADDITIVE 35

## RINSING

After HIPHOS 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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