

Instruction Sheet Chromating Salt

Green-475G (Olive drab)

Zinc Passivating salt Green-475G provide low cost chemical bright dip for bright zinc coated components and produce an dull dark green (olive drab), iridescent free, passivated film of high corrosion resistance.

Solution Composition:

For 100 liter of Olive drab Passivation solution.

Passivating Salt 475G	=	10 Liters
Water	=	to 100 Liters

Preparation of Solution:

Fill the tank with $\frac{3}{4}$ of working volume with clean cold water (preferably de-ionized water) and add 475G in the given concentration. Make-up the solution to the working volume.

Equipment:

The tank should be of molded PE or PP, or made of steel with glass-reinforced fiber lining, or PVC lining.

Operating Conditions:

Working temperature: Ambient. However under extreme cold conditions Less than 10°C) the temperature should be maintained above 10°C by titanium immersion heaters.

PH: 3.2 to 3.5

Immersion Time: 20 to 45 seconds.

Solution Maintenance:

The solution can be utilized for longer periods by frequent checking the pH and keeping the pH between the given range. If the correct pH do not give the desired result, discard the solution and prepare new solution.