

* FORD MOTOR CO.LTD TOX NO. 159352*

PA25 is a mild immersion cleaner, specifically formulated for the preparation of Ferrous components prior to pre-treatment with a Manganese Phosphate conversion process, such as Perf. MN.

The use of **PA25** will not cause coarsening of the coating and will allow the formation of a tight, complete crystalline Manganese Phosphate.

PA25 may also be used as a general soak/immersion cleaner for the degreasing of ferrous and non-ferrous metals.

OPERATION

As a stage in the Manganese Phosphate process (refer to the Performance MN data sheet for full details of the sequence of operations required). **PA25** should be used at a concentration between 3 and 5% i.e. 30-50gms per litre. At a temperature of 55-70 degrees centigrade. These parameters will be dependant upon the degree of soiling on the components, although for general machining and workshop contamination the mid points for strength and temperature will be found to be satisfactory.

The cleaner may be operated in either a mild steel or stainless steel tank and, if possible, should be agitated either mechanically or by compressed air.

Immersion times will vary but normally 5-10 minutes will be sufficient, although naturally this will be adjusted to suit the other process stages and line speeds if part of an automatic process sequence.

RINSING

Following immersion in **PA25** components will need to be rinsed thoroughly, preferably with cold overflowing water rinse followed by a hot rinse (to aid drying or as preparation for a hot phosphate pre-treatment).

With a Manganese phosphate process the hot rinse may be beneficially substituted by a grain refining rinse in order to ensure the formation of a tight, small crystalline structure.

CONTROL

The cleaning solution should be regularly tested via a titration so that the strength remains within the required parameters.

TESTING

Take a 10ml sample and titrate with 0.1N sulphuric acid using either phenolphthalein or screened Methyl Orange indicator.

A 4% solution will titrate at 24ml, which is equivalent to 24 points.

General operating parameters would be: -

Temperature 55-70 degrees centigrade

Concentration 20-30 points or 3-5%

Optimum operating parameters for this solution are:-

Temperature 60 Degrees Centigrade

Concentration 24 points or 4%

HEALTH & SAFETY Please refer to MSDS sheet for this product.

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