PATEL CHEMICALS **TECHNICAL DATA SHEET**

UNISTAR HEXAPASS GREEN-45

UNISTAR HEXAPASS GREEN - 45 is a single dip immersion process to produce dark olive green passivation on chloride zinc electro deposits. The chromate coatings produced gives a very high corrosion resistance of over 150 hours in a salt spray test. UNISTAR HEXAPASS GREEN - 45 is supplied as a liquid concentrate and is to be diluted with known quantity of water to make the operating solution.

OPERATING CONDITIONS:

UNISTAR HEXAPASS GREEN-45 :	60 - 120 ml/ltr.
Temperature :	25° – 35°C
Time :	30 - 90 sec.
pH (Electrometric) :	0.8 - 1.2
Agitation :	Air or component movement.

BATH MAKE UP

Fill the tank with 2/3rd full of clean water and add required quantity of UNISTAR HEXAPASS GREEN- 45 and stir the solution. Make up the operating volume and stir well to ensure thorough mixing.

PROCESS CYCLE FOR CHROMATING IN UNISTAR HEXAPASS GREEN- 45

1. Zinc plate (Minimum thickness of 6 - 8 Microns)
2. Cold water rinse.
3. 0.4% by volume nitric dip.
4. Cold water rinse.
5. Olive chromating in UNISTAR HEXAPASS GREEN -45.
6. Cold water rinse.
7. Air dry.

Hot water should not be used for drying as it tends to dull the finish and reduce the corrosion resistance. The Olive chromate coatings formed are soft when wet and therefore care must be taken to minimise handling the work before it dries.

REPLENISHMENT

Regular additions of UNISTAR HEXAPASS GREEN-45 should be made based on visual observations and consumption patterns. When the bath is used continuously, the olive green colour changes and coaitng becomes iridescent and this can be corrected by adding regularly UNISTAR HEXAPASS GREEN- 45 Normally an addition of 800-1000ml. of UNISTAR HEXAPASS GREEN -45 is required to treat a work area of around 150 sq.ft.

NOTE

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