PATEL CHEMICALS **TECHNICAL DATA SHEET**

UNISTAR HEXAPASS YELLOW-25

UNISTAR HEXAPASS YELLOW-25 is a yellow iridescent chromate conversion coating over chloride and cyanide zinc coatings. It provides a very good corrosion protection to zinc and cadmium plated components. The thick chromate layers are durably bright and provide strong bonding with zinc and cadmium coating. Good pH stability and high corrosion resistance help the process to meet the federal specifications. Different shades can be obtained by variation in solution concentration, immersion time and bleaching procedures.

OPERATING CONDITIONS

UNISTAR HEXAPASS YELLOW-25 :	15 - 20 ml/ltr
Nitric Acid (360 Be) :	2.0 - 4.0 ml/ltr
Time :	5 - 30 sec.
pH :	1.2 - 1.8
Temperature :	Room

BATH MAKE UP

Fill the tank 2/3 full of water and add the required amount of UNISTAR HEXAPASS YELLOW-25 and stir to mix. To this add calculated amount of 36º be Nitric acid and make up the level with water.

OPERATION

Zinc or cadmium plated components are rinsed thoroughly and immersed in the UNISTAR HEXAPASS YELLOW-25 bath and is agitated thoroughly to wet the entire surface .Immersion time can be adjusted as per the concentration and life of the solution. Passivated components are rinsed thoroughly in water and dried.

DRYING

A cold air centrifugal drying is recommended. Warm air or hot water drying of the coating will produce maximum hardness. But use of these drying methods will reduce the corrosion resistances of the coating.

EQUIPMENT

Stainless steel, plastic or plastic lined tanks are recommended.

NOTE

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