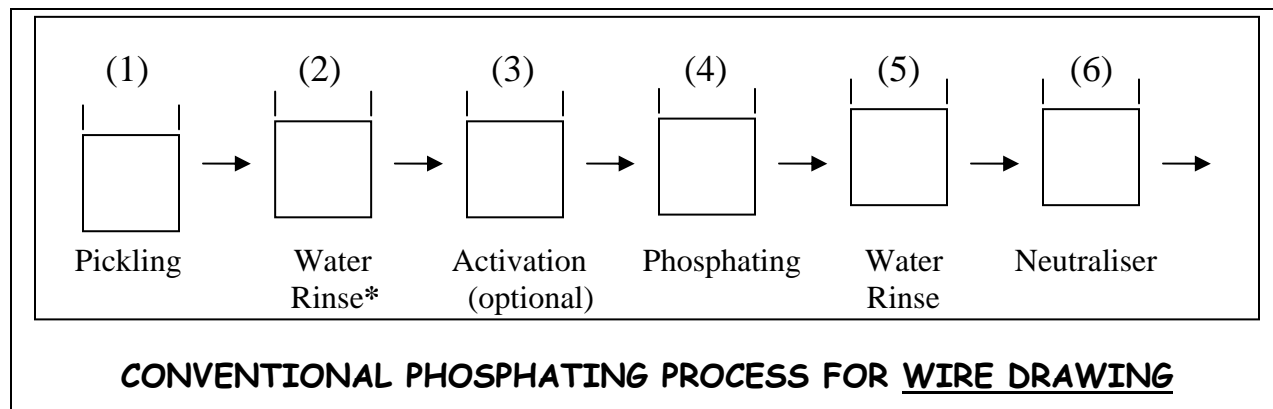


# PHOSPHATE TREATMENT FOR WIRE



\* - More than one water rinse tanks / jet water spray are suggested to avoid carry over of acid in the phosphate bath.

**PICKLING** :- Removal of rust and scale from ferrous surface.

PRODUCT	NATURE	CONC.	TIME	TEMP.
<b>HYDROCHLORIC ACID</b>	Acidic Descaling	33-50% v/v	10-15 min	RT

**ACTIVATION** :- Gives compact & uniform coating of zinc phosphate.

PRODUCT	NATURE	CONC.	TIME	TEMP.
<b>MOD</b>	Surface activation	0.5 % w/v	1 min	RT

**PHOSPHATING** :- Medium to Heavy weight Zinc Phosphate Coating For Cold Drawing :

PRODUCT	NATURE	CONC.	TIME	TEMP.
<b>PHOSCOAT CDZ</b>	Accelerated Medium weight Zinc Phosphate Coating.	5% v/v	10-20 min	RT-65 <sup>o</sup> C
<b>ACC</b>	Accelerator	0.07% w/v		

REMARKS - Phosphate tank can be operated even at room temp giving compact and uniform – medium weight zinc phosphate coating with minimum sludge formation.

**NEUTRALIZER** :- Neutralizes acidic zinc phosphate chemical residing on the surface and leaves a coating of carrier for lubricant in the die box.

PRODUCT	NATURE	CONC.	TIME	TEMP.
<b>NEUTRALIZER</b>	Neutralises the acidic water left and provides the base for dry soap powder.	8 - 10 %	1 min	RT to 80 <sup>o</sup> C

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