

TECHNICAL DATA SHEET

i-FIN AL CHROMATING

i-Fin Al Chromating is an acidic liquid product for yellow conversion chromating process. It is used on aluminium and its alloys for producing a wide range of iridescent finish on the surface. This coating is primarily used for pretreatment of aluminium painting process. This also serves as a final finishing for resistant against corrosion and decorative purposes.

OPERATING CONDITIONS

	Unit	Range	Optimum
i-Fin Al Chromating A	ml/ltr	10-20	15
Temperature	°C	25-60	35
Time	minutes	3-10	5
Chromic Acid Points		7.0 – 12.0	10

BATH MAKE UP

- Fill the tank with deionized water up to $\frac{3}{4}$ of its volume.
- Add the required i-Fin Al Chromating A, distributing it over the whole tank surface and mix well again.
- Stir well and add deionized water up to the final volume.
- The bath is ready for operation after all the ingredients have been thoroughly mixed.

ANALYSIS PORCEDURE

A) Chromic Acid points

1. Pipette out 10 ml of the bath solution and add 25 ml of deionized water.
2. Add 20 drops of sulphuric acid (50%) and 0.5 gm of potassium iodide.
3. Titrate against 0.1N sodium thiosulphate till colour changes reddish brown to yellow.
4. Add few drops of starch indicator and colour changes to blue-black.
5. Titrate further against 0.1N sodium thiosulphate until colorless.
6. Note down burette reading which is equivalent to chromic acid points.

Note: To adjust the chromic acid points add i-Fin Al Alchromating B

B) Total Acid points

1. Pipet out 2 ml of the bath solution and add 25ml of deionized water.
2. Add 5 drops of phenolphthalein.
3. Titrate against 0.1N sodium Hydroxide until colour changes rose red
4. Note down burette reading which is equivalent to total acid points.

Note: If the total acidic points increases above 12, a fresh solution has to be prepared.

EQUIPMENT

Tank : The tanks must be lined with a material that may be resistant to acids (e.g. PVC, polypropylene, fibreglass, polyester, etc.)