

TECHNICAL DATA SHEET

i-FIN AL COLD SEAL 35

i-Fin Al Cold seal 35 is a process based on chemical impregnation of the aluminium oxide film with reactive substances. It seals the coat and produces a productive coating having low reactivity to weathering. It shows quality standard higher than those of the anodized aluminium in drop test, wet loss and salt pray test.

It has a catalytic effect in sealing the anodic coating wherein the pores does not react with air moisture. i-Fin Al Cold seal 35 is basically a non organic liquid with special aging effect.

OPERATING CONDITIONS

	Unit	Range	Optimum
i-Fin Al Cold seal 35	ml/ltr	25 – 35	30
pH	–	5.5 - 6.0	5.8
Temperature	°C	20-30	25
Time	minutes	10-15	12

Note: Ammonia is used to raise the pH and Acetic acid is used to lower the pH.

BATH MAKE UP

- Fill the tank with deionized water up to $\frac{3}{4}$ of its volume.
- Add the required i-Fin Al Cold Seal 35, 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

1. Pipette out 50 ml of the bath solution and add 100ml of deionized water.
2. Add 15 ml of ammonia solution and 5 ml of Triethonolamine.
3. Add 0.1gl of Murexide indicator and mix well.
4. Titrate against 0.1M EDTA until purple violet colour is obtained.
5. Note down burette reading

Calculation : ml of 0.1 EDTA x 2.66 = ml/l of i-Fin Al Cold Seal 35.

EQUIPMENT

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

Filtration : It is advisable to circulate the bath by agitator and/or filtration.

*Issued on 04.01.2008
Supersedes all earlier*