

# TECHNICAL DATA SHEET

## i-FIN HOT SEAL 37

i-Fin Hot seal 37 is a liquid additive designed for hot sealing of anodized aluminium parts. It offers high anti smutting additive without sacrificing the seal quality. There is no tonality loss on the colour-anodized parts. Reduces the sealing time as compared to conventional sealing additives. It is suitable for both colored and natural anodized parts. Reduces the cost by about 1/3 of normal sealing. It provides an active buffering action thereby it is easier to maintain the pH at optimum range.

### OPERATING CONDITIONS

	Unit	Range	Optimum
i-Fin Hot seal 37	ml/ltr	10-15	12
pH	-	5.0 -5.8	5.5
Temperature	°C	70-90	80
Time	minutes	5-20	10

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

### BATH MAKE UP

1. Fill the tank with deionized water up to  $\frac{3}{4}$  of its volume.
2. Add the required i-Fin Hot Seal 37, distributing it over the whole tank surface, and mix well again.
3. Stir well and add deionized water up to the final volume.
4. 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 cool it to room temperature. Add 100 ml of deionized water.
2. Add 10 ml of ammonia solution and 10 ml of Triethanolamine.
3. Add 0.1gm of murexide indicator and mix well.
4. Titrate it against 0.1M EDTA until violet colour is obtained.
5. Note down burette reading.

**Calculation :** ml of 0.1M EDTA x 0.28 = ml/l of i- Fin AH hot seal 37

### EQUIPMENT

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

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

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