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A2LA Accredited ISO/IEC 17025:2005 Certificate # 2558.01

200 ACID SALTS

ACCU-LABS 200 Acid Salt is a powdered acid compound used prior to plating for activation of light and heavy scale removal. #200 Acid Salt can be used on a wide variety of metals to promote maximum adhesion and fast, uniform plating.

ACCU-LABS 200 Acid Salt is ideal for activating dips prior to plating zinc die castings, brass, and copper, steel, lead and tin-lead parts. ACCU-LABS 200 Acid Salt may be used cathodically for cleaning heavy scale off steel parts. It may also be used with electrolysis on stainless steel and high alloy nickel steel to promote the maximum degree of adhesion to subsequent electrodeposits.

MAKE-UP

Fill tank $\frac{3}{4}$ full with tap water. Slowly add required amount of #200 Acid Salt while agitating bath. Fill to final volume. Bring to desired temperature.

EQUIPMENT

#200 Acid Salt should be contained in a tank lined with PVC, polyethylene or koroseal. For electrolytic use, carbon electrodes should be used.

Please see application chart on next page for processing recommendations.

CHART OF RECOMMENDATIONS FOR APPLICATION

	CONC.	TEMP.	TIME
Acid dip for zinc die castings before plating	4 – 6 oz/gal	Room	20 – 30 secs
Acid dip for buffed brass or copper before bright nickel	½ - 1 lb./gal	Room	10 – 60 secs
Acid dip for copper plate prior to nickel plating	6 – 16 oz/gal	Room	20 – 40 secs
Solder Flux Removal	10 – 18 oz/gal	180 - 200°F	As required
Acid dipping brazed steel	9 – 16 oz/gal	Room	20 – 40 secs
Acid dip for cast iron prior to plating	1 ½ - 2 lb/gal	100 - 120°F	20 – 40 secs
Acid dip for steel prior to plating	12 – 20 oz/gal	Room	20 – 90 secs
Electrolytic treatment on steel for removal of light oxides and scale	12 – 20 oz/gal	Room	Cathodic 50 asf 20 – 60 secs
Electrolytic treatment on stainless, high nickel and high alloy steels prior to plating	1 – 2 lbs/gal	Room	1. Anodic 50 – 200 asf 30 – 60 secs 2. Clean in smut remover 3. Cathodic 50 asf 40 secs

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