

# ACCU-LABS INC.

4831 S. Whipple Avenue  
Chicago IL 60632  
Phone: 773.523.3100 Fax: 773.523.4008  
[www.accu-labs.com](http://www.accu-labs.com)

**A2LA Accredited ISO/IEC 17025:2005 Certificate # 2558.01**

## **982A GOLD FILM CONVERSION COATING ON ALUMINUM**

ACCU-LABS 982A is an acid salt that was developed to produce a gold iridescent film on aluminum. 982A will also give a clear chromate film on aluminum if used at a lower concentration and shorter time cycle. It gives excellent corrosion protection and provides a good adhesive bond for paint. ACCU-LABS 982A conversion coating meets current military specification Mil-5541B-Class 1A. This material is the same as the material listed on the QPL list and meets Specification ASTM D-1730 for Type B, Method 7.

### **OPERATING GUIDELINES:**

#### **Concentration & Dwell Time**

- |                            |   |
|----------------------------|---|
| 1. Clear Coating Process   | ¼ to ½ oz/gal. of 982A<br>15 to 30 seconds    |
| 2. Gold Iridescent Process | .75 to 1.25 oz/gal. of 982A<br>1 to 2 minutes |

<b>Temperature:</b>	<b>70 to 90°F</b>
pH Range	.2 - 2.3
Tanks	Polyethylene, Polypropylene, Koroseal, P.V.C. Stainless Steel
Racks & Baskets	Stainless steel, Platisol coated steel, P.V.C, or Polyethylene baskets

## RECOMMENDED CYCLE

1. Clean with non-etch soak cleaner ACCU-LABS 110NC (silicated) or 368-G (non-silicated).
2. Water rinse
3. Etch
4. Water rinse
5. Desmut with ACCU-LABS DX-14 **PARTS MUST BE SMUT-FREE!**
6. Water rinse
7. ACCU-LABS #982A CONVERSION COATING
8. Cold rinse
9. Warm rinse
10. Air dry

## ANALYTICAL CONTROL

- Pipette 10 ml sample of working solution into 250 ml e-flask
- Add 15 ml DI water
- Add 15 ml 25% sulfuric acid
- Add 15 ml 10% potassium iodide
- Add 1-2 ml starch indicator
- Titrate immediately with 0.1N sodium thiosulfate to a light blue/green endpoint.  
**Note: Endpoint is reached rapidly!**
- Record mls of sodium thiosulfate used.
- **CALCULATION:** mls of sodium thiosulfate used x 0.1100 = oz/gal 982A  
**EXAMPLE:** 9.00 mls of 0.1N sodium thiosulfate x 0.1100 = 1 oz/gal 982A

## SAFETY

Store in a DRY area. AVOID SKIN and EYE CONTACT. Wear PROTECTIVE CLOTHING and GOGGLES. FLUSH EXPOSED AREAS IMMEDIATELY with CLEAN COLD WATER. Contact a physician in case of injury. Read the Material Safety Data Sheet before using.

## DISCLAIMER

The information contained in this bulletin is true and accurate to the best of our knowledge. Because use and conditions are beyond our control, no guarantee is expressed or implied for the above suggestions or recommendations. ACCU-LABS, INC. will not incur any liability in connection with the use of these suggestions or technical data.