

# ACCU-LABS INC.

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**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, Plastisol 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.

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