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A2LA Accredited ISO/IEC 17025:2005 Certificate # 2558.01

503 TRI-DIP

TRIVALENT BLUE BRIGHT CHROMATE COATING FOR ZINC

DESCRIPTION: ACCU-LABS 503 TRI-DIP is a post plating single dip product which provides a clear blue bright chromate conversion coating on electroplating zinc. When properly controlled, ACCU-LABS 503 TRI-DIP is a liquid acidic product that is totally trivalent in nature.

FEATURES: ACCU-LABS 503 TRI-DIP provides a clear blue bright finish that is consistent and reproducible barrel after barrel or rack after rack. It is equally effective on all electroplated zinc ranging from alkaline non-cyanide to acid chloride processed in either barrel or rack operation. ACCU-LABS 503 TRI-DIP possesses high tolerance to impurities and yellowing which will lend it to fewer rejections. Fewer problems are encountered with zinc stripping from low current densities due to its low zinc removal properties.

ACCU-LABS 503 TRI-DIP is economical to use due to its effectiveness at low concentrations and long life. Addition requirements can easily be determined by visual inspection of the chromated parts. ACCU-LABS 503 TRI-DIP decreases the users waste treatment requirements due to its exclusively trivalent chrome characteristics.

SOLUTION MAKE UP:

ACCU-LABS 503 TRI-DIP:	0.75-1.5% (1% typical)
Temperature:	65 - 90 F
pH:	1.5 - 2.5
Dwell Time:	10 - 25 seconds

TEST PROCEDURE FOR ACCU-LABS 503 TRI-DIP

1. Pipette a 30 ml sample into a 250 ml flask. (Or, use a small graduated cylinder to measure 30 ml.)
2. Add 50-70 ml of DI water.
3. Add 25 mls of 1N sodium hydroxide solution. (Or, add 1 gram of dry sodium hydroxide and mix to dissolve.)
4. Add 1-2 mls of 30% Hydrogen Peroxide solution. (Solution turns yellow.)
5. Heat solution to boiling and boil for 30 minutes minimum. Avoid boiling down to dry crystals. Maintain 20-50 mls of solution by adding DI water as needed.
6. Cool to room temperature and add DI water to raise volume up to about 100 mls.
7. Add 20 mls of 50% Hydrochloric Acid solution.
8. Add 10 mls of 10% Potassium Iodide solution.
9. Add approximately 2 grams of Ammonium Bifluoride Crystals.
10. Add 1-2 mls Starch Indicator solution.
11. Titrate immediately with 0.1N Sodium Thiosulfate solution to a dark purple to clear end point. Record mls.

Mls x 0.23 = by volume, **Accu-Labs 503 TRI-DIP**

SAFETY

Protective gear including eye protection should be properly worn when working with or around this chemical product; reading the MSDS prior to use is highly recommended.

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