

# 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**

## 562

### **OLIVE DRAB CHROMATE CONVERSION COATING FOR ZINC AND CADMIUM**

**ACCU-LABS 562 OLIVE DRAB** is a two component Olive Drab System used to produce a smooth, heavy olive drab chromate finish on both zinc and cadmium plated work. **ACCU-LABS 562 Olive Drab** coatings provide superior salt spray protection and abrasion resistance; and meets government specifications for olive drab finishing. **ACCU-LABS 562 OLIVE DRAB** is an excellent final finish or base for subsequent painting operations.

#### **SOLUTION MAKE-UP:**

|                        |               |
|------------------------|---------------|
| Water                  | 84% by volume |
| <b>ACCU-LABS 562-A</b> | 8% by volume  |
| <b>ACCU-LABS 562-B</b> | 8% by volume  |

Fresh **ACCU-LABS 562 OLIVE DRAB** solutions will operate slowly when the first parts are processed. To quickly activate a fresh make up of **ACCU-LABS 562 OLIVE DRAB**, add and dissolve 1 gram of zinc dust per gallon of prepared solution. If an almost spent solution of **ACCU-LABS 562 OLIVE DRAB** is available use 3 - 5% by volume of it in the fresh make-up to activate the bath. This will eliminate the need for zinc dust.

**ACCU-LABS 562 OLIVE DRAB** concentrates should always be added separately to the tank solution and never mixed directly together.

**OPERATING GUIDELINES:**

|                      |                   |
|----------------------|-------------------|
| Immersion time:      | 10 - 60 seconds   |
| Bath pH:             | 2.0 - 3.0         |
| Bath Operating Temp: | 70 - 90°F         |
| Agitation:           | Mild air or mech. |

**TYPICAL PROCESS FLOW:**

1. Zinc or Cadmium Plate  
Min. thickness 0.0002 - 0.0003"
2. Warm or Cold Water Rinse
3. **ACCU-LABS 562 OLIVE DRAB** Dip
4. Cold Water Rinse
5. Hot Water Rinse (140°F Max.)
6. Dry - 140°F Max.

**MAINTENANCE:**

In most instances, it will become possible to control the **ACCU-LABS 562 Olive Drab** solution by visual observation of the work or by controlling the pH. Usually, additions are required every two to three hours of operation of 0.5 - 1% of both **562-A and 562-B**. Depletion of the bath is indicated when the required dip time becomes excessive or the olive drab color becomes lighter.

**ACCU-LABS 562 OLIVE DRAB** solutions can be maintained by monitoring the pH and making 1.0% additions of both **562-A and 562-B** to bring the pH down to the working range.

The color of the finish can be adjusted in a working **ACCU-LABS 562 OLIVE DRAB** bath. To produce a lighter green-yellow tone finish add 0.5% additions of **562-A**. To produce a darker brown tone color add 0.5% additions of **562-B**.

**EQUIPMENT:**

Tanks constructed of 316 stainless steel, PVC, Koroseal lined steel, polypropylene or polyethylene tanks are suitable for holding the **ACCU-LABS 562 OLIVE DRAB** solutions. Coils should be made of 316 stainless steel.

**SAFETY:**

**ACCU-LABS 562 OLIVE DRAB** solutions contain hexavalent chromium and are acidic solutions. In case of contact, flush the contaminated area with a large volume of water. Always wear eye and personal protective gear when handling or working with this product.

**NOTICE OF DISCLAIMER:**

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