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:

<table>
<thead>
<tr>
<th>Component</th>
<th>Volumetric Percentage</th>
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<tbody>
<tr>
<td>Water</td>
<td>84% by volume</td>
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<tr>
<td>ACCU-LABS 562-A</td>
<td>8% by volume</td>
</tr>
<tr>
<td>ACCU-LABS 562-B</td>
<td>8% by volume</td>
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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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