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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
ACCU-LABS 562-A	8% by volume
ACCU-LABS 562-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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