

# Accu-LABS INC.

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**A2LA Accredited ISO/IEC 17025:2005 Certificate # 2558.01**

## **622-Y**

## **TRIVALENT YELLOW CHROMATE FOR ZINC**

The following make-up and process guidelines are for using Accu-Labs products **622-M** Trivalent Chromate and **622-Y** to produce an easy to use and maintain single dip trivalent yellow chromate for zinc plated parts.

**SALT SPRAY HOURS TO WHITE CORROSION PER METHOD ASTM B-117:**  
**-WITHOUT ACCU-LABS KSN SEALER UP TO 120 HOURS**  
**-WITH ACCU-LABS KSN SEALER UP TO 250 HOURS**

### **MAKE UP OF SINGLE DIP TRIVALENT YELLOW:**

#### **% BY VOLUME WITH HIGH QUALITY WATER**

**Accu-Labs 622-M:** 2.0%-10.0% (4.0% typical)

**Accu-Labs 622-Y:** 0.10% - 1.00% (0.5% typical; consult w/Accu-Labs)

### **TRIVALENT YELLOW PROCESS GUIDELINE:**

Zinc Plate:	0.0002" minimum
Water rinse (dual)	
Bright dip (optional)	0.25% by volume nitric acid
Water rinse	
<b>Trivalent Yellow:</b>	60 - 90 seconds, 70 - 90°F; pH 2.5 - 2.9
Water Rinse	
Sealer (optional):	<b>Accu-Labs KSN</b> 2-4% 5 - 30 seconds 65 - 90°F
Hot air dry ( <b>OPTIMAL</b> )	

## **MAINTENANCE GUIDELINE OF TRIVALENT YELLOW:**

Control the **Trivalent Yellow Solution** by pH. For each 1 gallon (3.8 liters) addition of **622-M** added to maintain (lower) the solution pH add 2 - 8 ounces (60 - 240 mls) of **622-Y**. **Note:** Dwell time and the **622-Y** concentration can be manipulated for desired color effect, the aforementioned guideline is for typical processing; your application may vary depending on conditions of usage. Best corrosion protection is attained by maintaining pH of working solution at 2.70 while processing parts at the higher end of the dwell time and temperature ranges; pH should be lowered by incremental additions of **622-M** to maintain desired pH range plus a corresponding addition of **622-Y** to maintain desired color.

## **SAFETY:**

Always wear proper personal protective gear including eye protection when working with or around this or any chemical; read MSDS prior to use.

## **DISCLAIMER:**

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