

DNM-4 Process steps

Step No	Process	Product	Treatment Time (min)	Solution Temperature (°C)
1	Clamping the parts in place			
2	Degreasing of parts	RIAG Clean 601	4 – 6	45 – 55
3	Rinsing of parts	De-ionized Water	0.5 – 1	RT
4	Activating of parts	Fluoride type	0.3 – 2	RT
5	Rinsing of parts after activating	De-ionized Water	0.5 – 1	RT
6	Magnesium pickling	Special formula	4 – 6	38 – 42
7	Rinsing of parts	De-ionized Water	0.5 – 1	RT
8	Activating of parts	Fluoride type	0.3 – 2	RT
9	Rinsing of parts after activating	De-ionized Water	0.5 – 1	RT
10	Magnesium pickling	Special formula	1.5 – 2	38 – 42
11	Rinsing of parts	De-ionized Water	0.5 – 1	RT
12	Electroless Nickel coating	DNM-4	4 – 140	86 – 94
13	Rinsing of parts	De-ionized Water	> 2	RT
14	Drying of parts	Hot air	30	120
15	Unclamping of parts			

(*) Material safety data sheets are available on request