

25.07.2014

MAGPASS-COAT®

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^(*)	10	60 – 80
3	Rinsing of parts	De-ionized Water	0.5 – 1	RT
4	Pickling of parts	Phosphoric acid 75 %	0.5	RT
5	Rinsing of parts after pickling	De-ionized Water	0.5 – 1	RT
6	Neutralization of the surface	Sodium hydroxide 10 %	0.5	RT
7	Rinsing before coating	De-ionized Water	0.5 – 1	RT
8	Coating	MAGPASS-COAT®^(*)	5	30
9	Rinsing of parts	De-ionized Water	> 2	RT
10	Drying of parts	Hot air	30	120
11	Unclamping of parts			

(*) Material safety data sheets are available on request