

riag Pass 405

Trivalent transparent or thick chromate passivation on zink-nickel layers

The **riag Pass 405** is a new trivalent chromate process that produces a transparent finish on zinc-nickel plated surfaces. The coating has high stability while tempered at 200 °C in terms of loss of colour and brightness. The coating so obtained provides high corrosion resistance **without the presence of hexavalent chrome**.

The **riag Pass 405** is supplied as an easy to use liquid concentrate.

Make up

transparent chromate passivation

riag Pass 405 Additive (density = 1.23 g/mL)

pH

Temperature

Range
100 – 200 mL/L
2.6 – 3.2
38 – 42 °C

Optimum
125 mL/L
3.0
40 °C

thick chromate passivation

riag Pass 405 Additive (density = 1.23 g/mL)

pH

Temperature

Range
100 – 200 mL/L
2.2 – 2.8
38 – 42 °C

Optimum
150 mL/L
2.5
40 °C

The quantity of **riag Pass 405 Additive** depends on the zinc-nickel process used and the equipment.

Procedure for a make up of 100 litres

Put 80 L water in the process tank, add the required quantity of **riag Pass 405 Additive** and mix well. Adjust the pH with diluted sulphuric acid (or increase with a 10 % solution of sodium hydroxide) and top the volume up to 100 litres. Heat the passivation to the working temperature. Now the bath is ready for operation.

Operating conditions

Temperature:	38 – 42 °C (optimum 40 °C)
Time:	30 – 60 sec.
pH-Value:	Transparent: 2.6 – 3.2 (optimum 3.0). Frequent control is recommended. Thick: 2.2 – 2.8 (optimum 2.5) Adjust the pH with diluted sulphuric acid or sodium hydroxide
Agitation:	Air or parts movement
Fume extraction:	Recommended
Equipment:	Mild steel tank with polypropylene lining
Heating:	Glass or teflon tube heaters
Pre dip activation:	This will decrease the corrosion resistance and therefore is not recommended.
Post treatment	We recommend our riag post treatment for enhanced corrosion protection

Process sequence

1. Zinc-nickel plating
2. Water rinse
3. Water rinse
4. **riag Pass 405**
5. Drag Out
6. DI water rinse
7. **riag Seal *** * different options possible
8. Dry

Replenishment

riag Pass 405 is added on the basis of analysis.

Effluent control

The **riag Pass 405** chromate conversion coating solution is acidic and contains trivalent chromium salts. Spent solution has to be treated and discharged according to local wastewater laws.

Safety considerations

Protective gear such as face shields and gloves should be worn during bath make up and operation. Chemicals shall not be stored below 10 °C.

Liability

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Analysis

Sample preparation

Take the sample at a homogeneously mixed position and let it cool down to room temperature. If turbid, allow to settle and decant or filter.

Chromium (III)

Reagents	10 % Sodium hydroxide 30 % Hydrogen peroxide (H ₂ O ₂) Hydrochloric acid conc. Potassium iodide 0.1 mol/L sodium thiosulphate 1 % starch solution (freshly prepared)
Process	<p>Pipette</p> <p>10 mL passivation bath into a</p> <p>250 mL Erlenmeyer flask, add</p> <p>50 mL DI water and sodium hydroxide to a pH-value of about 10 (colour change), then add</p> <p>10 mL Hydrogen peroxide and boil the solution for 30 – 40 min. It is very important to evaporate excessive H₂O₂ (boil and reduce until shortly before crystallisation)</p> <p>100 mL Cool the solution, add DI water up to and acidify with hydrochloric acid (colour change from yellow to orange), add</p> <p>1 g potassium iodide, titrate with 0.1 mol/L sodium thiosulphate until the solution is only slightly yellowish, then add</p> <p>Some mL starch solution and titrate until the blue colour disappears.</p>
Calculation	mL/L riag Pass 405 Additive = Consumption in mL x 6.9