

SurTec® 481

Salt for Acid Dip

Properties

- effective activating of even difficult metal surfaces before electroplating
- excellent acid dipping to prevent parting layers after pretreatment with silicate solutions
- cyanide- and chromium(VI)-free

Application

	<i>for steel and brass</i>	<i>for zinc die cast</i>
make-up value:	6-8 %	3-5 %
temperature:	15-25°C	
pH-value:	< 3 control with pH indication paper or with fluoride resistant electrode; adjust with SurTec 481 (or with sulfuric acid)	
application time:	30-100 s, longer application is possible, if required	
tank material:	plastic tank resp. steel tank with rubber or plastic coating	

Technical Specification

<i>(at 20°C)</i>	Appearance	Bulk density (kg/l)	pH-value (at 10 g/l)
SurTec 481	powder, white to light yellowish	1.545 (1.51-1.58)	ca. 2.6

Maintenance

Check the pH-value regularly and adjust, if necessary. If the pH-value cannot be decreased with small additions of SurTec 481, a new make-up is necessary.

Ingredients

- sodium fluoride
- sodium bisulfate
- chlorides

Stock Keeping

In order to prevent delays in the production process, per 1,000 l bath the following amount should be kept in stock:

SurTec 481 75 kg

Product Safety and Ecology

The safety instructions and the instructions for environmental protection have to be followed in order to avoid hazards for people and environment. The Material Safety Data Sheets (according to European legislation) contain explicit details for this.

The following hazard designations and classifications into water hazard classes (WHC) have to be taken into account:

<u>product</u>	<u>hazard designation</u>	<u>water hazard class</u>
SurTec 481	Xn - Harmful	WHC 1

Warranty

We are responsible for our products in the context of the valid legal regulations. The warranty exclusively accesses for the delivered state of a product. Warranties and claims for damages after the subsequent treatment of our products do not exist. For details please consider our [general terms and conditions](#).

Further Information and Contact

In our forum, you can discuss topics of the surface technology:

<http://forum.SurTec.com/>

If you have any questions concerning the process, please contact your local technical department: <http://SurTec.com/International.html>

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