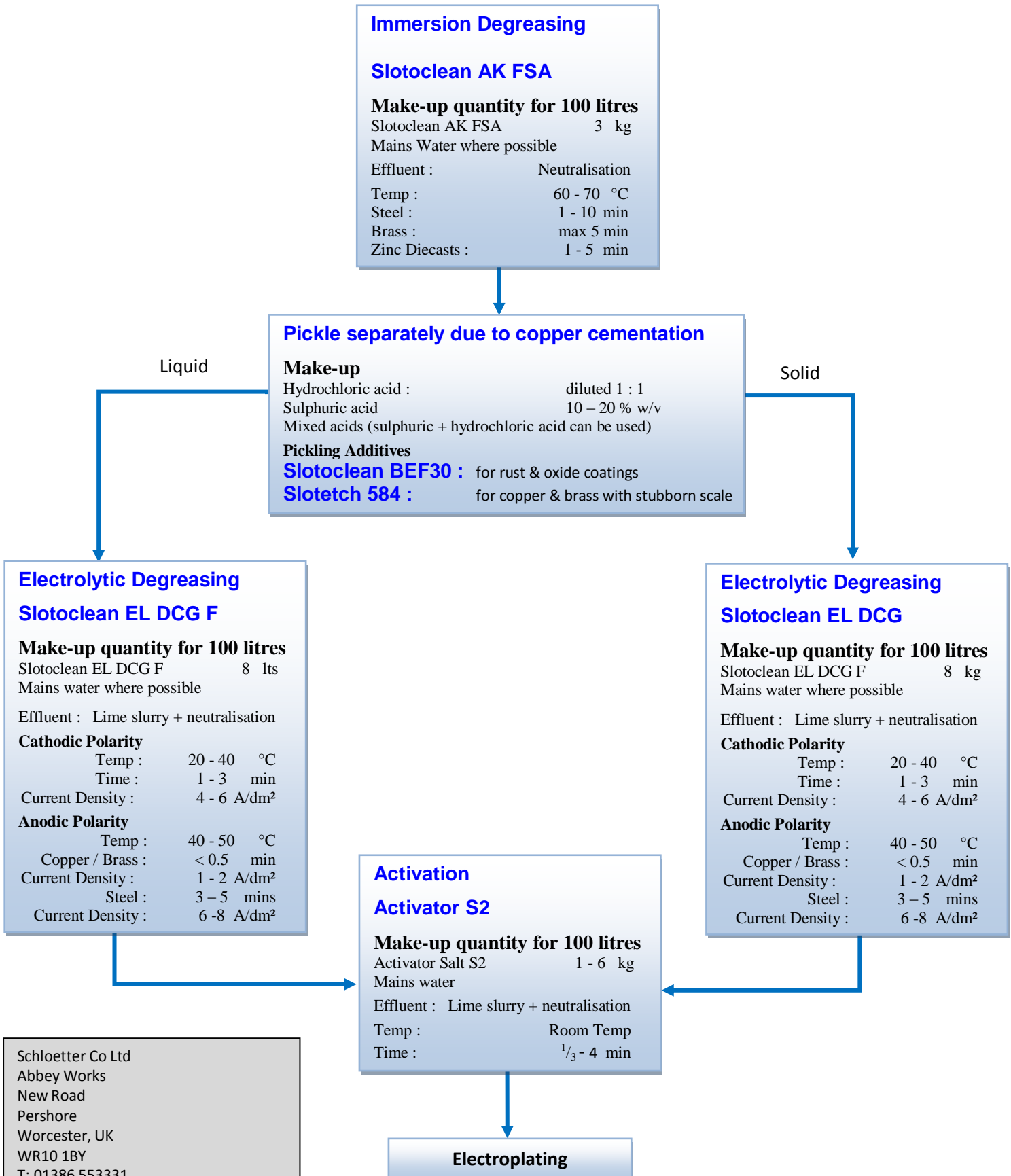


Product Guide: Pretreatment for Steel, Copper, Brass and Zinc Diecasts

Greased, Oiled



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Immersion Degreasing
Slotoclean AK FSA
Make-up quantity for 100 litres
 Slotoclean AK FSA 3 kg
 Mains Water where possible
 Effluent : Neutralisation
 Temp : 60 - 70 °C
 Steel : 1 - 10 min
 Brass : max 5 min
 Zinc Diecasts : 1 - 5 min

Pickle separately due to copper cementation
Make-up
 Hydrochloric acid : diluted 1 : 1
 Sulphuric acid 10 - 20 % w/v
 Mixed acids (sulphuric + hydrochloric acid can be used)
Pickling Additives
Slotoclean BEF30 : for rust & oxide coatings
Slotetch 584 : for copper & brass with stubborn scale

Electrolytic Degreasing
Slotoclean EL DCG F
Make-up quantity for 100 litres
 Slotoclean EL DCG F 8 lts
 Mains water where possible
 Effluent : Lime slurry + neutralisation
Cathodic Polarity
 Temp : 20 - 40 °C
 Time : 1 - 3 min
 Current Density : 4 - 6 A/dm²
Anodic Polarity
 Temp : 40 - 50 °C
 Copper / Brass : < 0.5 min
 Current Density : 1 - 2 A/dm²
 Steel : 3 - 5 mins
 Current Density : 6 - 8 A/dm²

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Activation
Activator S2
Make-up quantity for 100 litres
 Activator Salt S2 1 - 6 kg
 Mains water
 Effluent : Lime slurry + neutralisation
 Temp : Room Temp
 Time : 1/3 - 4 min

Electroplating