

TECHNICAL DATA SHEET

Abphos 201M

Cleaner and Iron Phosphate

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| Description | A combination cleaner and Iron Phosphate coating for steel, zinc and aluminium surfaces. Provides a phosphate coating of 0.3 – 1.0 g/m ² . | | | | | | |
| Features | <ul style="list-style-type: none">• Designed to treat mild steel, but can also be used for zinc and aluminium, provided they are in mixed metal production along with mild steel.• Can be used by spray or immersion.• Produces lightweight coatings of amorphous iron phosphate conforming to the requirements of BS EN ISO 9717:2017 and DEF SAE AMS03-11.• Extremely low sludging. | | | | | | |
| Product Code | ABPH/201M | | | | | | |
| SG | 1.22 ± 0.1 kg/l at 15°C. | | | | | | |
| Equipment | Abphos 201M may be used satisfactorily in mild steel equipment. However, because of its acidic nature, stainless steel, polypropylene or rubber lining is preferable. | | | | | | |
| Initial Fill | Fill the bath with mains water - for every 1000 litres of bath: (i) Add 30 litres of Abphos 201M. (ii) Warm the bath and circulate through the spray jets for 5 minutes. Take care to <u>not</u> boil the Abphos 201M solution. | | | | | | |
| Control Points | Abphos 201M is generally operated by spray techniques at a concentration of 2 - 3% (v/v) and at a temperature of 55°C. However, depending upon specific conditions Abphos 201M may be satisfactorily used within the following ranges: <table><tr><td>Concentration</td><td>2 - 3% (5% for immersion method)</td></tr><tr><td>Temperature</td><td>35 - 65°C</td></tr><tr><td>Process Time</td><td>1 - 10 min.</td></tr></table> For immersion applications, operation at the higher end of the ranges is normally recommended. | Concentration | 2 - 3% (5% for immersion method) | Temperature | 35 - 65°C | Process Time | 1 - 10 min. |
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| Analytic Control | Concentration Titration: Measure 10 ml of the bath into a flask and add 4 – 6 drops of Phenolphthalein Indicator solution. Titrate with 0.1 M sodium hydroxide until the colour changes to a permanent pink. Titration (ml) x 0.31 = % (v/v) of Abphos 201M. | | | | | | |

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| Rinsing | Rinse the work thoroughly in a tank fitted with a weir and continuously overflowed with mains water. |
| Drying | For most reliable results, the work should be dried in an indirect-fired oven at 70° - 125°C. |
| Tank Maintenance | Whilst Abphos 201M produces small amounts of sludge, it is necessary to periodically remove it, along with debris accumulated off the work. This can build up particularly on heating coils, spray jets etc. where it may interfere with the performance of the system. Any floating oil or grease should likewise be skimmed off the surface. |
| Shelf Life | 2 years from date of manufacture when correctly stored in unopened containers. |
| Storage | The product should be stored in cool, dry, frost-free conditions, in sealed containers. |
| Health & Safety | Refer to the product's Safety Data Sheet and safety advice on the product label before use. |
| Technical Support | For technical support in using this product, please contact: e: birminghamtech@trimite.com , or t: 0121 554 7000. |
| Date of Issue | July 2021. |

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