

TECHNICAL DATA SHEET

Paintbond 330

Cleaner and Iron Phosphate

Description	A combination cleaner and Iron Phosphate coating for steel, zinc (Mazak, Zintec, Galvanised) and aluminium surfaces. Provides a phosphate coating of 0.4 – 1.0 g/m ² .	
Features	<ul style="list-style-type: none">• Can be used by dip or spray (tunnel or washing machine) processes.• Degreases normally oily surfaces.• Improves paint and powder adhesion.• Operates at low temperatures - reduced energy.• Forms very little sludge – low maintenance costs.• Concentrated product for economy.	
Product Code	MP0237	
SG	1.24 ± 0.1 kg/l at 20°C.	
Coverage	Consumption will depend greatly on bath losses through drag-out and overspray. As a guide the following range has proved reliable: 100 – 250 m ² /kilo of Paintbond 330.	
Equipment	Parts of the plant that are in contact with chemicals or water (e.g. tanks, pumps, impellers, spray equipment etc.) should ideally be made from stainless steel, or from polypropylene or rigid PVC.	
Initial Fill	Fill the bath with mains water - for every 1000 litres of bath: <ul style="list-style-type: none">• Add 100 litres of Paintbond 330.• Warm the bath and circulate through the spray jets for 5 min. <p>Detergency: To improve cleaning, if the work is significantly oily, PB Detergent Additive A (MP0240) may be added to increase detergency, normally up 1 litre of PB Detergent Additive A per 1000 litre tank.</p>	
Application	The process sequence is: <ol style="list-style-type: none">1. Phosphate by Dip or Spray2. Rinse - normally 2 stages (see Rinsing below).3. Dry-off (see Drying below). <p>Pre-Cleaning: if the work is oily and/or corroded, prior cleaning may be required by e.g.<ul style="list-style-type: none">• T Cleaner 70 (MP0035) for dip removal of oils and grease• T Deruster 9 (MP0203) for dip derusting• T Deruster 25 (MP0006) for brush application derusting.</p> <p>A range of Trimite cleaning wipes are also available – please ask for details.</p>	
Control Points	Concentration	10 - 30%
	Acidity (pH)	4.0 - 4.5
	Temperature	35° - 55°C
	Time	2 - 4 min
	Spray Pressure	0.8 – 1.5 bar

TECHNICAL DATA SHEET**Paintbond 330****Cleaner and Iron Phosphate****Analytic Control****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 3.4 = % of Paintbond 330.

A Test Kit (**MP0604**) containing all the necessary items and replacement chemicals is available from Trimite.

Acidity:

Measure pH using an accurate and reliable meter or narrow range (4 to 7) pH paper. Normally, the pH will be restored to the correct level when Paintbond 330 is added.

- PB Acid Adjuster 2 (**MP0226**) may be needed to compensate for alkaline build-up from poor mains water or emulsified oils.
- PB Alkaline Adjuster 1 (**MP0225**) is also available should the pH be too low.

Rinsing

Dip: The work should be rinsed thoroughly with water in tanks fitted with weirs and continuously overflowed with mains water.

Spray: Similar holding tanks are suitable, but the clean water is better introduced over the work through the last spray risers. The overflowed water can be used to overflow to any rinses prior to the Paintbond 330 stage. Improved results can be gained by using demineralised water and PB Seal F (**MP0232**) (which is chromium-free), in a warmed final rinse; in this case the rinse is not normally overflowed, but should be changed regularly.

Drying

For most reliable results, the work should be dried in an indirect-fired oven at 70° - 125°C.

Tank Maintenance

Paintbond 330 forms a small amount of sludge in normal use, that will need periodic removal. The tank should be allowed to settle, the clear liquid transferred to an adjacent rinse tank, and the tank and heating surfaces cleaned. The clear liquid can then be returned to the cleaned tank, and replenished with water and Paintbond 330.

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.

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