

**TECHNICAL DATA SHEET****SurTec 650 Brush RTU****Trivalent Chromium Conversion Coating**

**Description** A Trivalent Chromium (Hexavalent Chromium-free) ready to use solution, for brush, spray or wipe application to aluminium.

- Features**
- Forms an iridescent blue to tan protective chromate coating.
  - Hexavalent Chromium free - meets all RoHS test criteria (IEC1 11/24/CD).
  - Excellent bare corrosion protection.
  - Suitable as pretreatment before lacquering, powder coating and gluing.
  - Can be used on magnesium.
  - The coating has low electrical resistance - under 0.8 milli-ohms/cm<sup>2</sup>.
  - For use with or without paint.
  - Heat resistant up to 100°C with minimal loss in corrosion resistance.

**Complies With** Approved to U.S. MIL-DTL-81706 and MIL-DTL-5541.

**Product Code** **MP0257.**

**SG** 1.00 ± 0.1 kg/l at 20°C.

**Application** Prior to the passivation with SurTec Brush 650 RTU, the aluminium surface must be cleaned and deoxidized thoroughly. The surface must be water-break free.

An example process is:

1. Clean with T Wipes 2 (**MP0302**) or T Cleaner 2 (**MP0113**).
2. Clean and deoxidise with Deoxidine 624 (**MP0003**).
3. Deionised (demineralised) water rinse.
4. Apply SurTec 650 Brush RTU
5. Deionised (demineralised) water rinse.
6. Air dry or force dry (no hotter than 60°C)

The addition of a nitric acid rinse before the SurTec 650 Brush RTU step can improve performance.

Treated surfaces can be coated immediately after drying, or stored if they are protected from contamination and temperature extremes. For optimum results, the parts should be coated within 7 days.

<b>Control Points</b>	Temperature	Room temperature
	Acidity (pH)	3.8
	Application Time	2 min average (between 1 and 10 min)
	Spray Pressure	1 bar average (between 0.5 and 1.5 bar)

**Rinsing** After the passivation SurTec 650 Brush RTU, the parts must be rinsed. For best corrosion resistance, a rinsing with deionised water is recommended. For successive lacquering, the last rinse must have a conductivity of less than 30 µS/cm. The drying temperature should not exceed 65°C at the part's surface.

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### **SurTec 650 Brush RTU** **Trivalent Chromium Conversion Coating**

<b>Shelf Life</b>	For best before date, see label.
<b>Storage</b>	The product should be stored in cool, dry, frost-free conditions, in sealed containers. During storage, a slight precipitation may occur which does not impair the quality or the function of the product.
<b>Health &amp; Safety</b>	<b>Refer to the product's Safety Data Sheet and safety advice on the product label before use.</b>
<b>Technical Support</b>	For technical support in using this product, please contact: e: <a href="mailto:birminghamtech@trimite.com">birminghamtech@trimite.com</a> , or t: 0121 554 7000.
<b>Date of Issue</b>	June 2021.

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