

SurTec 650 Touch-up Pens

Trivalent Chromium Repair Pen

Description	A Trivalent Chromium (Hexavalent Chromium-free) ready to use solution, in a felt tip pen dispenser, for the spot repair of damage to treated aluminium.
Features	<ul style="list-style-type: none">• Rapid and simple, designed for the repair of surface scratches, abrasions etc., which have already been treated with SurTec 650.• Ready to use, and applied at room temperature.• Especially suited to small jobs or hard to reach areas on assembled and finished equipment.• Produces excellent corrosion resistance, which is comparable to the original hexavalent chrome conversion processes.• The restored conversion coating layer is an effective pretreatment for the optimum adhesion of subsequent paint, powder coating and adhesive applications.• Economical, as there is no waste of solution.
Complies With	SurTec 650 is approved to U.S. MIL-DTL-81706 and MIL-DTL-5541.
Product Code	MP0235.
SG	1.00 ± 0.1 kg/l at 20°C.
Application	Applied manually to the repair area using the pen.

Before application, the repair surface must be cleaned of dirt or oxides by sanding, solvent wiping or other suitable methods, depending on the degree of contamination and practicality.

Cleaning

Before using the Touch-up Pen, degrease using Trimite T Cleaner 8 (**MP0207**) and deoxidise with Trimite Deoxidiser C-IC 624 (**MP0003**), and then rinse thoroughly.

Application using the Touch-up Pen

Avoid touching the cleaned surfaces – the use of latex gloves is recommended.

The pen nib can be shaped, using a sharp trimming knife.

- Shake the pen well, then hold the pen with the tip down, and press against a firm surface to allow the liquid to wet the tip. This should take about 30 to 45 seconds. The pen is now ready for use.
- Apply the SurTec 650 liquid in smooth, even strokes, making sure to cover any edges. For best results, apply an initial coating in one direction only and using a 50% overlap between passes. Allow this coat to dry, then apply a second coat at right angles to the first, again using a 50% overlap on each pass.
- Do not allow pools of liquid to accumulate.
- Pre-warmed surfaces will result in smoother coatings being achieved. Avoid application in cold conditions.
- Replace the pen cap firmly after use.

TECHNICAL DATA SHEET

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Rinsing	After the conversion process, the parts can be rinsed or just wiped dry. For best corrosion resistance and best paint adhesion, rinsing with deionised water is recommended (conductivity <math><30 \mu\text{S}/\text{cm}</math>).
Drying	The drying temperature should not exceed 65°C at the part's surface.
Overcoating	Treated surfaces can be coated immediately after drying. They can alternatively be stored, as long as they are fully protected from contamination and temperature extremes. For best results, parts should be overcoated within 7 days maximum.
Shelf Life	18 months from date of manufacture. For best before date, see label.
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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