Protection upgraded

SurTec® 650
chromitAL Retouche
Touch Up Pen

Properties

- this touch up pen is a special felt tip marker, similar to highlighter pens, designed for the repair of mechanically damaged aluminium surfaces by scratches, abrasions, etc.
- contains non-hazardous trivalent chrome solution
- especially suited for the repair of small and hard-to-reach areas on already assembled or finished equipment
- restores the conversion coating layer by simple application of the pen
- produces excellent corrosion resistance, comparable to hexavalent chrome processes
- the restored conversion coating layer is an effective pre-treatment for optimum adhesion of subsequent paint, powder coating and adhesive applications
- IMDS-number: 30429267

Application

With this touch up pen SurTec 650 can be applied manually.

Application time:	5 min	(2-10 min)	for critical aluminium alloys, e.g. 2xxx and 7xxx aluminium alloys, and/or for achieving Class 1A corrosion protection according to MIL-DTL-5541F
	4 min	(1-10 min)	for uncritical aluminium alloys, e.g. aluminium alloys except 2xxx and 7xxx, and/or for achieving Class 3 corrosion protection according to MIL-DTL-5541F
pH-value:	3.8	(solution in the pen)	

Application:

Prior to the application of SurTec 650 Retouche, the aluminium surface must be clean and free of oxides, e.g. by sanding and solvent wiping.

Working steps for applying SurTec 650 within a total time of 5 minutes:

1. Open the pen and push the felt tip into a piece of dry and clean cotton until the felt tip is totally soaked with liquid.
2. Wet the damaged aluminium surface area completely and quickly with firm pressure by the felt tip.
3. If there is too little liquid to wet the relevant surface area completely then press the felt tip once again until the liquid is evenly distributed. Let the solution takes its effect on the surface, and make sure that the surface is constantly wet.
4. Every 1 minute spread the solution with gentle pressure and apply fresh solution if necessary, to avoid a drying-out of the surface.
5. Repeat this procedure until a total treatment time of 5 minutes is accomplished.

During the entire treatment period, the surface needs to be permanently wet; in no case it is allowed to dry out. Hence, the spreading interval of the solution might be shorter than 1 minute, depending on the climatic conditions.

Hints:

After the conversion coating, the parts can be rinsed or just wiped dry.

For best corrosion resistance and best paint adhesion, a rinsing with deionised water is recommended (conductivity: < 30 µS/cm). The drying temperature should not exceed 65°C at the part's surface.

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

Product Safety and Ecology

Classification and designation are noted in the **Material Safety Data Sheets** (according to the European legislation). The safety instructions and the instructions for environmental protection have to be followed in order to avoid hazards for people and environment. Please pay attention to the explicit details in our Material Safety Data Sheets.

Warranty

We are responsible for our products in the context of the valid legal regulations. The warranty exclusively accesses for the delivered state of a product. Warranties and claims for damages after further processing of our products do not exist. For details, please find our country-specific **General Terms and Conditions** for downloading on our homepage or ask your regional SurTec representative.

Further Information and Contact

If you have any questions concerning the process, please contact your local technical department.

For further information and contact details, please visit our homepage:

http://www.SurTec.com

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