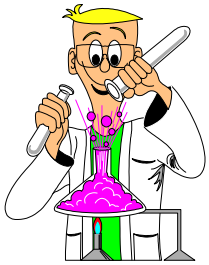
HSC

Howard Supply Company, Inc.



TECHNICAL BULLETIN
#834 Liquid Iron Phosphate

#834 Liquid Iron Phosphate was made for spray applications on metal surfaces. On steel, it converts the metal surface to non-metallic iron phosphate coatings, which inhibit corrosion and increase adhesion for better durability of paint finishes. This product cleans and phosphates in one operation and must be followed by an overflowing rinse in the second stage. If a third stage is available, a sealer may be used to avoid flash rusting. Parts are usually dried in a bake oven before painting.

PROCEDURE:

Concentration: Two to four ounces per gallon. In most cases, 15-20 gallons of #834 per 1,000 gallons of water.

Temperature: 110-160 degrees F., depending on the amount and type of soils on parts.

Immersion time: One-half minute minimum. Longer time provides better cleaning and heavier coatings.

Soda ash is used to raise the pH of the bath. The pH should run from 3.8 to 4.4. #834 should be added when pH reaches 4.4.

Spray nozzles should be kept clean and pump packing should be tight enough to avoid faulty patterns in the washer. Overflow weirs are advisable to continuously skim oil from top of tank. Tank life is extremely long if skimming is done regularly.

Steel Tanks are suitable, but stainless pumps and coils are recommended. Stainless steel nozzles are also better than other metals.