



KEMPHOS DG

Ferrous metals phosphodegreasing

CHARACTERISTICS

KEMPHOS DG is a phosphodegreaser, specially developed to allow the degreasing and phosphating operations to be carried out at one time. The use of the product allows to coat the metal surface with a light layer of mixed phosphate iron and zinc with the characteristic bluish color. The treatment gives the surface the best characteristics for the anchoring of paints subsequently applied and improves corrosion resistance.

In particular, it is possible to temporarily protect the ferrous materials in the interoperational phases provided that the instructions relating to the conduct of the process and the subsequent storage of the parts are carefully observed.

CHEMICAL-PHYSICAL DATA

Physical state:	liquid
Colour:	yellow - green
Theoretic yield :	5 g/m ² ca.
Density (20°C) :	1,02 ± 0.05 Kg/dm ³
Solubility in water:	completes
pH _(t,q) :	1 ÷ 2

APPLICATIONS

Product solutions can be used for immersion and spraying especially as pre-paint treatment. It isn't necessary to degrease the surfaces of the articles beforehand KEMPHOS DG thanks to a surfactant package that effectively removes oil, lubricating and dirt residues. For the indispensable removal of thermal oxides, preliminary pickling specific treatments (METALDEC line)

USE AND DOSAGE

⇒ Immersion

It is recommended to use between 3% and 5%, the exact concentration should be defined according to the workmanship. The operating temperature should be between 40 ° C and 70 ° C and the contact time between 1 and 3 min.

Preparation of the bath

Fill for $\frac{3}{4}$ approx. the tank, then add the required amount of KEMPHOS DG and then the remaining quarter of water

Process management

1. perform phospho-degreasing
2. Rinse with clean water
3. Dry (if possible with hot air)

⇒ Spray (Pressure Nozzle)

The product concentration at the outlet from the nozzles (or the heater) must be about 3% and the temperature around 65 ° C.

Below 50 ° C the product develops foam.

Process management is similar to the previous case.

BATH MANAGEMENT

The bath should be checked with the appropriate KEMPHOS KIT to verify its concentration and with specific indicator charts for the pH check which must be maintained within the 3.5 ÷ 4.0 range. The bath is exhausted when it has a large amount of sludge and the phosphate conversion process is uneven

