

SurTec® 615 V

Activation for Manganese Phosphating

Properties

- slightly water soluble, weak acidic powder
- activates iron and steel prior to manganese phosphating
- assists the formation of thick, fine grained and dark phosphating layers with good adhesion

Application

SurTec 615 V is applied in immersion process.

make-up value: 5-10 g/l

make-up: Steps for make-up:

1. Fill the tank 2/3 with deionised water.
2. Add the calculated amount of SurTec 615 V while stirring vigorously.
3. Fill up to the final volume.

temperature: room temperature (20-60 °C)

pH-value: 4 (3-5)

application time: 2 min (1-5 min)

agitation: vigorous agitation

tank material: steel with acid resistant coating

filtration: not necessary

exhaust: required for worker's protection

hints: The activation should be made up freshly every week.

The pH-value should not exceed pH 7, to activate the surface properly.

Technical Specification

(at 20 °C)	Appearance	Bulk density (kg/l)	pH-value (at 10 g/l)
SurTec 615 V	powder, white-pink	1.040 (1.00-1.08)	3 (1.5-4)

Maintenance and Analysis

Control the pH-value regularly and keep it in the range of pH 3-5 by addition of SurTec 615 V.

Ingredients

- sulfates
- phosphates
- nonionic surfactants

Stock Keeping

In order to prevent delays in the production process, per 1,000 l bath, the following amount should be kept in stock:

SurTec 615 V Activation 10 kg

Product Safety and Ecology

The safety instructions and the instructions for environmental protection have to be followed in order to avoid hazards for people and environment. The Material Safety Data Sheets (according to European legislation) contain explicit details for this.

The following hazard designations and classifications into water hazard classes (WHC) have to be taken into account:

<u>product</u>	<u>hazard designation</u>	<u>water hazard class</u>
SurTec 615 V	Xi - Irritant	WHC 1

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 the subsequent treatment of our products do not exist. For details please consider our [general terms and conditions](#).

Further Information and Contact

In our forum, you can discuss topics of the surface technology:
<http://forum.SurTec.com/>

If you have any questions concerning the process, please contact your local technical department: <http://SurTec.com/International.html>

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