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TECHNICAL DATA SHEET

CM-6003 CHROMATE PASSIVATION LIQUID

PRODUCT DESCRIPTION

CM-6003 is a liquid concentrate which, when diluted with water, will produce a clear blue bright chromate conversion coating on zinc plate. **CM-6003** will brighten and passivate zinc surfaces and protect it from finger staining, discoloring and corrosion. Typical applications of **CM-6003** are rack, barrel plated, bulk processed work requiring a high quality, low cost, blue bright, protective chromate coating. Although it has long life, the low cost of the material allows it to be discarded frequently, decreasing the need for precise control and preventing the build-up of contaminants that tend to produce variable results.

OPERATING INSTRUCTIONS

To process parts in **CM-6003**, simply immerse them in the solution for the recommended length of time or until the desired coating is produced. After processing, the parts are rinsed in cold water followed by a hot water rinse and dried.

In general, shorter dip times produce bluer coatings. For increased corrosion protection, the higher range of concentration is recommended. Where long transfer times occur, as in certain automatic rack and barrel installations, a concentration of 0.75% by volume is recommended.

SOLUTION MAKE-UP

Concentration:	0.75 – 2.0% by volume, 1.0% recommended
Time:	5 – 50 seconds
pH:	1.2 – 2.0
Temperature:	70 – 90°F (21 – 33°C)

EQUIPMENT & CONTROL

Chromating tanks should be constructed of stainless steel, Koroseal, PVC or rubber lined steel, or polyethylene. Ventilation equipment is not required. **CM-6003** may be controlled simply by observing the work. As the desired appearance falls off, an addition of **CM-6003** should be made.

Thorough rinsing is essential both before and after the **CM-6003** treatment. Plating solution carry over neutralizes the dip, consequently shortening the life of the bath. Failure to rinse well after chromating can cause streaking of the finished surface. When replacing an old solution, it is frequently advisable to retain approximately 25% of the solution.

SAFETY AND HANDLING

Solutions of **CM-6003** are strongly oxidizing and acidic. Do not allow to come in contact with combustible matter. Refer to material safety data sheet for additional information about product.

The information contained herein is based on data developed through laboratory and productions experience and is believed to be correct. However, Chemical Methods, Inc. makes no warranty, expressed or implied regarding the accuracy of the data or the results to be obtained from the use thereof. Northern Chemical Blending Corp. assumes no responsibility for injury from the use of the product described herein.