



Chemical Methods, Inc.

20338 Progress Drive
Cleveland, Ohio 44149
216/476-8400
FAX: 216-476-1231
www.chemicalmethods.com

TECHNICAL DATA SHEET

CM-6004 NON-PHOSPHATE CONVERSION COATER

PRODUCT DESCRIPTION

CM-6004 is a mildly acidic phosphate-free conversion coating that imparts adhesion promoting and corrosion resistant coatings to most ferrous and non-ferrous alloys. **CM-6004** is specifically recommended for use in tunnel washers immediately following the rinses after alkaline cleaning stage(s). It is non-foaming and is a “green” alternative to traditional iron phosphating operations.

BENEFITS

- Room Temperature Application
- Under Paint Corrosion Protection
- Paint Adhesion Promotion
- No Glycol Ethers
- Phosphate-Free

PHYSICAL AND CHEMICAL PROPERTIES

Appearance, Concentrate	Clear Liquid
Appearance, 5% Dilution	Clear Liquid
Specific Gravity	1.005
Pounds per Gallon	8.39
pH	2.1 +/- 0.4

USE DIRECTIONS - For tunnel washer operations:

Parameter	Range
Concentration	0.5% to 3%
Temperature	70° to 120°F
Time	30 to 60 seconds
pH, at use	4 to 5

A clean water rinse should follow after the coating process immediately followed by a final RO or DI water rinse, if possible. CM-15 (sodium hydroxide) should be used to adjust the pH of tank at charge-up.

Note: Exact operating conditions will be dictated by the parts encountered. Operating at higher concentrations and temperatures can increase the speed and volume of the coating generated by the process.

SAFETY AND HANDLING

Refer to material safety data sheet for additional information about this product.