

Condorfos ZC 60

Nickel free, microcrystalline zinc phosphating process

Product information

Condorfos ZC 60 is used for the pretreatment of carbon steel tubes prior to cold forming.

Conversion coating features

The phosphate coating obtained with Condorfos ZC 60 has an acicular crystallinity and a phosphate weight of 10-15 g/m².

Products necessary for the preparation and maintenance of the working bath

- Condorfos ZC 60 F : Preparation product
- Condorfos ZC 60 A : Feeding product
- Accelerator : process accelerator

Bath preparation

The working bath is prepared with Condorfos ZC60 F. For the preparation of 1000 liters of working bath add 140 kg Condorfos ZC 60 F. The bath prepared as indicated has a total acidity of 52 ml. Prior to use the phosphating solution add accelerator following the instruction of the Condoroil Technical Service.

Working parameters

Condorfos ZC 60 is used in water solution by immersion as indicated above.

Treatment time (minutes)	:	from 6 to 12
Working temperature (°C)	:	from 65 to 75
Total acidity ml	:	from 48 to 62
Total acidity/Fisher acidity ratio	:	from 1,7 to 2,2
NO ₂ concentration in the working bath	:	from 0,2 to 0,25 g/l

The working parameters have to be maintained constant by feeding Condorfos ZC 60 A.

Il bagno di fosfatazione viene mantenuto in esercizio costante mediante aggiunte continue di Condorfos ZC 60 A.

The control parameter for the dosage of Condorfos ZC 60 A is the total acidity. To increase the acidity of one point add 1.5 kg of Condorfos KZ 60 A for every 1000 liters of working bath.

Preparation of the wire rod surface

Procedure:

- Alkaline cleaning to remove oils
- Rinsing with tap water
- Pickling and sandblasting to remove oxides
- Rinsing with tap water
- Rinsing with activating product if necessary
- Phosphating with Condorfos ZC 60
- Rinsing with tap water
- Neutralization
- Lubrification with soaps or polymers
- Drying

Equipment

All the equipment in contact with Condorfos ZC 60 has to be acid resistant; preferably AISI 316 L type.

Warning and safety

For transport, storing and usage of the product follow the current regulation.

For other informations see the MSDS of the product.

Waste treatment

For the waste treatment follow the current regulation.