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CL COLORCHROME VG 3

Yellow trivalent passivation

Application

CL Colorchrome VG 3 is a liquid passivation consisting of two components which are absolutely free of hexavalent chromium and do not contain complexing agents. CL Colorchrome VG 3 is applied as a yellow passivation after the zinc plating process.

CL Colorchrome VG 3 can also be used for the passivation of aluminium

Make-up for a 100 ltr. bath

CL Colorchrome VG 3 Part 1	4 – 6 ltr.
CL Colorchrome VG 3 Part 2	6 – 8 ltr.
pH value	2.2 – 3.8. (to be adjusted with nitric-or sulfuric acid)
Temperature	R.T. (20 – 40°C)
Immersion time	60 seconds up to 2 min. according to the colour required.

Acid zinc plated parts should be passivated with a pH between 2,2-2.9 alkaline cyanide free-as well as cyanide zinc plated parts between pH 3-3.9.

The passivation is wipe resistant.

The corrosion protection without a post immersion lacquer (according to make-up quantity) is in accordance to DIN Norm 50021.

By a post immersion (in Top coats) for example in Avant Guard D and/or other watersoluble laquers for example Avant Guard L, a relative higher corrosion protection is achieved which fulfils the demands of the automotive industry.

The parts have to be dried before immersion in Avant Guard as otherwise a change of colour may appear.

It is of main importance that the parts have a good zinc coating and that they are not strongly damaged in the centrifuge.

The yellow colouring is depending on the pH value and from CL Colorchrome VG 3 Part 2. Pickling in nitric acid or hydrochloric acid , pH approx. 3, is recommended.

Bankverbindung : Stadt – Sparkasse Solingen, BLZ 342 500 00, Konto nr. 5353248
HRB 5025 Amtsgericht Solingen. Ust-ID-Nr. DE 813 359 241
Geschäftsführer : Uwe Lüdtke

Maintenance and replenishing

As replenisher are an equal part of CL Colorchrome VG 3 Part 1 and CL Colorchrome VG 3 Part 2 required. If the appearance is matt, add CL Colorchrome VG 3 Part 1- If the colour is not yellow enough add CL Colorchrome VG 3 Part 2 (approx. 0.3 ltr per 100 ltr make-up). The pH value has to be adjusted with nitric acid /sulfuric acid or sodium hydroxide.

The passivation can be monitored analytically and replenished accordingly.

As a general rule the following consumption values may be taken:

Rack plating: approx. 15 ml Part 1 and 2 per 1 m²/ltr.
Barrel plating: approx. 1.0 – 3.0 ltr of Part 1 and 2 per 1000 ltr bath and hour.

The above mentioned values are without obligation as the immersion times, drag out losses and type of material may vary strongly.

Check the pH value after every replenishing.

Disposal and handling

The CL Colorchrome VG 3 as well as the rinse water only require a neutralisation as a chrome reduction is not applicable.

Safety Indication

The necessary precautions measures should be adhered to in handling the chemicals.

Chemicals without a hazard indication should not been seen as harmless. Also when the handling of chemicals are not due to hazard identification, we recommend to handle with care and avoid for example skin contact.

Warranty

Seller makes not warranty, whether of merchantability, fitness or otherwise, expressed or implied, concerning the product other than it shall be of the specification stated herein.

Any recommendations made by Seller concerning the use of the product are believed to be reliable, but seller makes no warranty of the results obtained. Buyer agrees to inspect the product supplied hereunder immediately after delivery. Failure to give notice in writing as aforesaid within the specified time constitutes and unqualified acceptance of the product and a waiver of all claims with respect thereto.

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