



ONKAR ENGINE & GENERATOR (P) LIMITED

Doc No: OM/QA/08

Process Setup / Verification Report

Rev No. / Date:
01/ 26.09.20

Operation No: 02 - 02 F		Operation Name: Pre Treatment	Product: Polymer Coating M S Tank		Frequency: Every 4 Hrs / set up change/ after break down recovery/Shift change Applicable in all above cases				Date: Shift:
Particular	Control Parameters	Specification	Before Production start (First Piece approval)		2nd		3rd		Remarks
			Before	After	Before	After	Before	After	
DEGREASING	Chemical	DELUBE-S55							
	Pointage	58-65 ml							
	Temperature	45 - 55							
	Spray cycle/Duration	12 nos /90-120 sec.							
Water Rinsing 1	PH	7 to 9							
	Temperature	RT							
	Deeping/Spray Duration	10 nos/30-90 sec							
Water Rinsing 2	PH	7 to 9							
	Temperature	RT							
	Deeping/Spray Duration	10 nos/30-90 sec							
Activation	Chemical	Krisfine-Z							
	Pointage	8 to 9.5 ml							
	Temperature	RT							
	Deeping/Spray Duration	10 nos/30-60 sec.							
Phosphating	Chemical	Krisbond S30							
	Pointage	30 to 35							
	Temperature	30 to 45							
	Deeping/Spray Duration	12 nos /90-120 sec.							
Water Rinsing 3	PH	6 to 7							
	Temperature	RT							
	Deeping/Spray Duration	10 nos/30-90 sec							
Passivation	Chemical	Krispass NC							
	PH	4.5 to 6							
	Temperature	40 to 55							
	Deeping/Spray Duration	10 nos/60-120 sec.							
			Checked By	Approved By	Checked By	Approved By	Checked By	Approved By	