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|  | **ONKAR ENGINE & GENERATOR (P) LIMITED** | | **Doc No: OM/WI/08** |
| **WORK INSTRUCTION** | | **Rev No. /Date: 00/24.010.18** |
| **Department: Polymer Coating** | **Process Name: - PT Testing** | |

**Degreasing**

* Collect **10 ml** of solution sample from the tank using bellow-tube, Add **4-5** drops of **Phenopthalein** where the solution changes to pink color.
* Titrate with 0.1 N **Sulphuric acid** (H2SO4)\*,Note the acid consumption pointage) when the solution turn transparent. This Value should be **58 to 65 ml**.
* Less pointage implies less concentration and vice-versa, 900 g chemical add per 1 pointage less.

**Phosphating**

* Collect **10 ml** of solution sample from the tank using bellow-tube, Add **4-5** drops of **Phenopthalein** where the solution color less.
* Titrate with 0.1 N **Sodium hydroxide** (NaOH)Note the acid consumption pointage) when the solution turn pink color. This Value should be **30 to 35 ml**.
* Less pointage implies less concentration and vice-versa, 1.5 ltr chemical add per 1 pointage less.

**Prepared by: Issued by: Approved by:**