

CYCLE IMPLEMENTED FOR THE PASSIVATION OF CODE 30004053-001 (13721109)

Data: 30.10.2021

Code Premek Hi Tech: 13721109

Material: 15-PH5 sec. AMS 5659

CYCLE:

PHASE	NAME	CHEMICAL		TEMPER.	STIR	TIME
		Produttore	denominazione	°C		min.
1	DEGREASING	HENKEL	PERMETA 66L + GALVACLEAN P21	55	US	CA. 20'
2	RINSE	HENKEL	SAME *	Room	Static **	extended
3	RINSE		H ₂ O *		Under flow	extended
4	PASSIVATION		HNO ₃ 60 % V.*	Room	Static	60'
5	RINSE		H ₂ O *		Under flow	extended
6	RINSE	C.I.D.A.	H ₂ O demineralised	Room	Static	10'
7	BLOWING		Compressed air *			
8	DRYING		Blotting paper *			
9	PACKING		Plastic bags *			

Note:

PHASE	NOTE
2	To prevent oxidation of steel and cast iron the product was much diluted. ** continually filtered through activated charcoal for removal of oils and grease.
3	* Installation stopped with a tray in the air and washing targeted individual details.
4	* dilution of pure product concentrated.
5	* telaio sospeso in aria manualmente
7	* air without oil (used for blasting) pieces taken hand-held individually with cotton gloves.
8	* manually dabbing, not rubbing.
9	* individually in bags with bubbles.