

# HP Acidsalt FLWET

**HP Acidsalt FLWET** is a dry powder acid-salt that replaces mineral acids in plating lines.

**HP Acidsalt FLWET** contains a special combination of surface activators to produce smut-free surfaces on Steel, Brass, Copper, Aluminum and Zinc die-castings.

**HP Acidsalt FLWET** assists in scale removal and oxides to promote better adhesion and active surfaces, with or without current.

**HP Acidsalt FLWET** is especially helpful when processing Zinc die-castings but may also be used to strip Chromium while activating Nickel surface.

## OPERATING PARAMETERS:

Concentration	2 – 48 oz/gal (15 – 360 g/l)
Temperature	60 – 180 °F (16 – 82 °C)
Immersion Time	15 seconds – 5 Minutes

## OPERATING CONDITIONS FOR SPECIFIC METALS:

Cold-rolled Steel Prior to Nickel plate	16 oz/gal / Ambient / 15 sec. – 2 min.
Hot-rolled, Welded, or Heat-treated Steel	32 oz/gal / 130 °F / 30 sec. – 5 min.
Zinc Die-Castings	4 oz/gal / Ambient / 30 sec.
Copper Plate or Brass	8 oz/gal / Ambient / 10 sec – 1 min.
Nickel Activation	16 oz/gal / 120 °F / 1 min.
Chrome Stripping	16 oz/gal / 180 °F / 1 – 3 min.

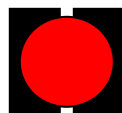
## ACTIVATION / SCALE REMOVAL USING CURRENT:

Polarity	Work-piece is cathodic
Anode:Cathode	2:1
Voltage	1.5 – 6 Volts
Current Density	45 – 100 ASF (4.5 – 10.0 ASD)
Anodes	Graphite (AGR)

## ANALYSIS PROCEDURE:

1. Pipette 10 ml sample into 250 ml Erlenmeyer flask.
2. Add 50 ml of DI water.
3. Add 2 - 3 drops of Bromcresol Green indicator solution.
4. Titrate with 1.0 N NaOH to a blue- green endpoint.

Calculation: Mls 1.0 N NaOH x 2.19 = **HP Acidsalt FLWET** (oz/gal)  
Mls 1.0 N NaOH x 16.4 = **HP Acidsalt FLWET** (g/l)



**EQUIPMENT:**

Tanks	Koroseal lined, satisfactory to 150 °F (66 °C). High temp. rubber is recommended for temps. over 150 °F (66 °C). At room temperature, rubber, Polyethylene, PVC or Polypropylene are satisfactory.
Heating Coils	Karbate, Graphite or Chemical Lead.
Ventilation	Positive ventilation is required when the solution is heated or when current is used. Ducts and blowers must be made of chemically resistant material.

**NON-WARRANTY:**

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