



4831 South Whipple Street

Chicago, IL 60632

www.accu-labs.com

Ph. 773-523-3100

F. 773-523-4008

ACCU-LABS 891

High Corrosion Resistant Top Sealer

Accu-Labs 891 is a concentrated liquid sealer product formulated to produce superior top coatings on passivated zinc plated parts. Accu-Labs 891 adds corrosion resistance and scratch resistance. The thin film top coating has excellent protective properties which can withstand repeated baking or heating cycles.

Features:

- Easy to use single dip coating
- Excellent added corrosion resistance
- Heat resistant organo-mineral coating
- Superior adhesion, ductility and scratch resistance
- RoHS compliant

Operating conditions:

Concentration	5-30% by volume Accu-Labs 891 *
pH	8-9 use aqua ammonia to raise if required
Immersion Time	15-45 seconds
Temperature	70-100°F
Agitation	Mechanical (do not use air)
Filtration	Recommended, 50 micron
Ventilation	Recommended

*Deionized water is recommended for makeup and maintenance of the sealer solution

Typical Cycle:

1. Zinc plate (0.0003 inch minimum)
2. Rinse
3. Rinse
4. Dilute acid activate (0.15-0.25% by vol. nitric acid, room temperature)
5. Rinse
6. Trivalent passivate (Accu-Labs 607-HC or 546 Yellow Trivalent Passivate)
7. Rinse



**4831 South Whipple Street
Chicago, IL 60632**

www.accu-labs.com

Ph. 773-523-3100

F. 773-523-4008

8. Rinse (Maintain pH of final rinse above 4, preferred 5-8. Use dilute caustic soda to adjust if needed)
9. Seal, Accu-Labs 891
10. Hot air Dry **

** Preferred, use a speed "step-up" hot air spin dryer. Maximum speed for 10" basket 400 RPM, 20" basket 200 RPM, 30" basket 130 RPM.

Equipment:

Tank	PVC or Koroseal lined steel, or plastic, propylene
Heater	Derated Teflon, titanium or quartz
Agitation	Mechanical, pump, prop or work. Do not use air agitation.
Filtration	50 micron, polypro

Solution Control:

Accu-Labs 891 sealer solutions can be controlled by concentration testing. Use refractometer or hydrometer testing methods. Consult your Accu-Labs representative for recommendations (Use of a Leica IFT 10 hp refractometer or 1.000-1.050, 260 mm hydrometer is recommended).

Safety:

Wear protective gear to avoid any contact with chemicals: goggles, face shield, rubber or plastic glove and apron. Read and review the Safety Data Sheets (SDS's) for information on health hazards, safe handling and first aid before using.

Storage:

Store in tightly closed original container with temperature above 45°F. Product freezing during shipment or storage can damage product.

Notice of Disclaimer: *The recommendations contained within this technical data are made in good faith and are based on our technical background and experience. However, since the conditions of use are beyond our control, this knowledge is given on the express terms and agreement that Accu-Labs, Inc. will not be held liable to any person in contract, tort (including negligence), strict liability, or otherwise any claims, damages, or losses whatsoever. Nothing herein shall be deemed a testimonial to use any product or process in infringement of any existing patent rights and no guarantees, expressed or implied, are made regarding information, product, processes, recommendations, description and safety notations contained herein.*