


Product properties – Technical sheet

FE NT PHOSPHATING	Item no.: 00 10 29
Areas of application	<p>FE NT is used in washing and phosphatising units operating in low temperature to clean and phosphatise steel and cast iron parts.</p> <p>FE NT produces on iron, steel and cast iron tight, iridescent yellowish to greenish-blue iron phosphate layers.</p> <p>The resulting iron phosphate acts as a temporary rust protection and in particular as a pre-treatment for a better adhesion of aqueous paints, usual paints containing solvents and powder paints. Also for aluminium, zinc and brass parts cleaned with this method the adhesion of the paints applied is better.</p> <p>Special components reduce the formation of sludge and deposits on the parts cleaned when the machine is stopped.</p> <p>Dry residues can be rinsed off easily.</p>
Corrosion protection	<p>FE NT hasn't any components for corrosion protection to prevent sensitive material from corrosion.</p>
Method of application	<p>Washing liquor control: Metering depending on pH, pH between 4.0 and 5.2 depending on material.</p> <p>For freshly prepared washing liquors conductance should not be below 3.0 mS/cm and not above 16 mS/cm (change bath or thin down.)</p> <p>Concentration: 1.0 – 2.0 % Temperature: 30 – 50°C Time: 1 – 3 minutes Pressure: 0.5 – 2 bar</p> <p>Rinsing liquors: Rinse the phosphatised parts thoroughly with sufficient clear water to completely remove any phosphate in excess and water salts.</p> <p>To passivate the parts add Rinsing Agent FE – Art.-No. 000712 – to the rinsing liquor before last.</p> <p>A last rinsing with demineralised water to remove water salts improves the adhesion of paints.</p> <p>Allow the parts to dry by their natural heat or place them into a drying cabinet.</p>
Material compatibility	<p>PVDF, PTFE, PFA, PE, PP, PVC and glass.</p> <p>FE NT changes surfaces of steel, aluminium and cast iron. The product is not suitable for polished surfaces; because of the pickling reaction the surfaces become rough.</p> <p>In addition, further material incompatibilities cannot be excluded. Therefore, test the product on an unimportant spot before its definite use.</p>

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Analysis of concentration	according to the titration instructions		
Physical and chemical properties			
Aspect/colour	Clear	Light Green – Green	
Form	Liquid		
Odour	Odourless		
Foaming behaviour (see under conditions of application)	Not foaming		
Phosphates	Contained		
Density (20°C) g/cm³	1.150 – 1.170		
Concentration	1 % in H₂O dest.	3 % in H₂O dest.	5 % in H₂O dest.
pH value (1 %, 20°C)	2.6 – 3.2	n/a	n/a
Conductance (1 %, 20°C) mS/cm	1.6 – 1.8	3.65 – 4.05	5.6 – 6.2
Phenolphthalein alkalinity (ml)	9.5 ± 1.0 (1 % at 50 ml sample)		
m-Value (ml)	n/a		
Storage stability	+ 5°C to + 30°C		
Remarks regarding biocides	n/a		
Hazardous products	Orthophosphoric acid / Dioctyldimethylammonium chloride		
Risk symbols			
	WARNING		
Special remarks	<p>Always close the container with the original closure, and store the items in a cool area without solar radiation. Product which was taken out of the container must never be poured back into the container.</p> <p>Read in any case our safety data sheet before using the product!</p>		
Disposal	Disposal acc. to official regulations, in case of doubt contact the manufacturer.		

Please refer to our safety data sheets and our operating instructions with regard to precautionary measures, first aid measures and storage. The information given in the Sheet corresponds to the present state of our technical knowledge and experience. They do not constitute any guarantee; they are to be considered as basic information only. In particular they do not guarantee particular properties or the suitability for a concrete purpose. Because of the multitude of possible influences during the application of our products, the user has to make in any case the relevant tests and take the corresponding precautions. Any existing intellectual property rights are to be observed.