

TURCOAT[®] LIQUID ALUMIGOLD CONCENTRATE

ALUMINUM CONVERSION COATING

DESCRIPTION:

TURCOAT LIQUID ALUMIGOLD CONCENTRATE is a clear, yellow solution developed to produce a golden iridescent chemical film or conversion coating on aluminum surfaces to improve corrosion resistance and paint adhesion.

FEATURES:

TURCOAT LIQUID ALUMIGOLD CONCENTRATE offers these features:

1. Approved by **Lockheed**, EPS #G31.2592
2. When used as directed meets MIL-C-81706 - Amend 5, Class 1A, Form III
3. (MIL-C-5541B - Specifies the use of materials qualified under MIL-C-81706)
4. Easy to control solution by titration
5. Product can be used in immersion or spray systems
6. Contains no cyanide salts

USE INSTRUCTIONS:

Tanks: Immersion tanks, spray systems and associated equipment should be fabricated from 316 stainless steel or equivalent acid-proof materials.

PRECLEANING:

General: Aluminum surfaces must be free from greases, marking inks and other soils. The use of chlorinated solvents is not recommended for cleaning parts prior to TURCOAT LIQUID ALUMIGOLD CONCENTRATE processing unless articles subjected to chlorinated solvent cleaning are subsequently cleaned by alkaline cleaning and several water rinses.

For maximum corrosion protection, cleaning with TURCO 4215 NC-LT is recommended. It should be used @ 7.5-15 g/L of water, 55°-60°C for spray system; (30 to 45 g/L of water, 30°-60°C for immersion system with air agitation), followed by cold to warm water rinsing.

DEOXIDIZING: It is advisable to employ a deoxidizing treatment with certain alloys prior to conversion coating. TURCO ALDOX V has been found to be ideal for deoxidizing treatments, but traditional chromate deoxidizers may also be used. For maximum salt spray resistance, it may be advisable to avoid deoxidizing treatment on certain alloys.

PREPARATION OF BATH: Use at 15% by volume in distilled or de-ionized water for dip application or 25% by volume for spray application. Mix well. Adjust the pH to 1.5 to 1.9. The pH of a fresh bath may change after standing. Correct pH of the bath with small amounts of nitric acid if high or small amounts of ammonium hydroxide if low.

CONTROL: pH Control - Close pH control is important. The use of a reliable pH meter is recommended. If a pH meter is not available, use Paul Frank No. 1028 pH paper (any equivalent paper of pH range from 0 to 2.5 may be used). A laboratory test procedure is available upon request.

PROCESSING INSTRUCTIONS: Operate bath @ 20°-30°C with a contact time of 15 seconds to 5 minutes by spray or 15 seconds to 10 minutes by immersion. Rinse with clean tap water followed by de-ionized water. Dry off temperature should not exceed 55°C.

DISPOSAL INFORMATION:

Dispose of spent solution per local, state and regional regulations. Refer to TURCO MATERIAL SAFETY DATA SHEET for additional disposal information.

CAUTION!

TURCOAT LIQUID ALUMIGOLD CONCENTRATE contains chromic acid and zinc silico-fluoride. Avoid contact with eyes, skin and clothing. Use with adequate (equivalent to outdoor) ventilation.

Protective clothing, such as a chemical face shield or goggles and gloves, boots and apron made from acid resistant neoprene should be worn when handling and using this product. A respirator equipped with a mist filter, such as U.S. Bureau of Mines number 2175, Model 7100 or American Optical R2090 Red Devil or equivalent protection should be worn during misting condition.

Store containers in cool, dry, ventilated areas, away from acids, combustible organic and reducing agents. Keep containers tightly closed. Store away from eating areas. Do not store containers near heat, open flames or metals.

Before using this product refer to container label and TURCO MATERIAL SAFETY DATA SHEET for additional precautionary, handling and first aid information.

NOTICE:

The above information and recommendations concerning this product are based upon our laboratory tests and field use experience with this or similar products. However, since conditions of actual use are beyond our control, any recommendations or suggestions are made without warranty, express or implied. Manufacturer's and seller's sole obligation shall be to replace that portion of the product shown to be defective. Neither shall be liable for any loss, damage, or injury, direct or consequential, arising out of the use of this product.