

CICLO di pretrattamento ALODINE - AL

Step	TREATMENT	TIME	TEMPERATURE	%	pH	PRODUCT
1	Charge					
2	Acid Degreasing	4 min	48 - 52°C *	2 - 5	4,8 - 5,2	HENKEL GRANODINE HMF 1080 IT
3	Washing	1 min	Ambient			
4	Acid Disossidation	1 min	Ambient	2 - 5	1,8 - 2,2	HENKEL DEOXIDINE 250 IT
5	Washing demineralized	30 sec	Ambient			
6	Nano-technologic Passivation Cr 6 free	1 min	Ambient	5 - 10	3,1 - 3,5	HENKEL ALODINE 5992
7	Washing	1 min	Ambient			
8	Washing demineralized	1 min	Ambient			
9	Washing demineralized	30 sec	Ambient			
10	Blowing	15 sec	Ambient			
11	Blowing forced air	15 sec	80 - 90°C **			
12	First Drying	16 min	100 - 110°C **			
13	Second Drying	30 min	140 - 150°C **			
14	Cooling		Ambient			
15	Descharge		Ambient			
16	Visual control		Ambient			
17	Packaging		Ambient			

[*] water temperature

[**] air temperature