

CICLO di pretrattamento ALODINE - MG

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	Washing demineralized	30 sec	Ambient			
5	Nano-technologic Passivation Cr 6 free	1 min	Ambient	5 - 10	3,3 - 3,5	HENKEL ALODINE 5992
6	Washing	1 min	Ambient			
7	Washing demineralized	1 min	Ambient			
8	Washing demineralized	30 sec	Ambient			
9	Blowing	15 sec	Ambient			
10	Blowing forced air	15 sec	80 - 90°C **			
11	First Drying	16 min	100 - 110°C **			
12	Second Drying	30 min	140 - 150°C **			
13	Cooling		Ambient			
14	Descharge		Ambient			
15	Visual control		Ambient			
16	Packaging		Ambient			

[*] water temperature

[**] air temperature