

CICLO di pretrattamento GRANODINE

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

[*] water temperature

[**] air temperature