

CICLO di pretrattamento ECO-TRI

Step	TREATMENT	TIME	TEMPERATURE	%	pH	PRODUCT
1	Charge					
2	Alcalinic Degreasing	4 min	48 - 52°C *	2 - 5	9,0 - 9,5	HENKEL CLINSTONE L456
3	Washing	1 min	Ambient			
4	Washing	1 min	Ambient			
5	Washing demineralized	30 sec	Ambient			
6	Washing demineralized	1 min	Ambient			
7	Passivation	1 min	50 - 52°C *	11 - 13	1,8 - 2,0	ATOTECH ECO-TRI NO-CO
8	Washing	1 min	Ambient			
9	Washing demineralized	1 min	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