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Technical Process Bulletin

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ALODINE® 5700 Wipes

Pre-Saturated Wipes which create a Conversion Coating on Aluminum, Titanium and Magnesium Surfaces

Introduction:

ALODINE 5700 Wipes produce a chromium free conversion coating on aluminum, titanium and magnesium surfaces. This product is formulated as a ready-to-use material for pre-saturated wipe application. The conversion coating provides an excellent base for organic finishes, sealers and most adhesives. ALODINE 5700 Wipes produce a conversion coating which forms from a reaction with the metal surface to form true chemical bonds. This reaction greatly enhances adhesion and corrosion resistance of subsequently applied paints (including primers when multiple coat systems are used), sealers and adhesives. The ALODINE 5700 Wipes conversion coating process is a dry-in-place application and does not require water rinsing.

2. Operating Summary:

<u>Chemical:</u>	
ALODINE 5700 Wipes	Ready-to-use
<u>Operation and Control:</u>	
Concentration	Ready-to-use
Application	Wet the metal surface
pH	2.2 to 2.6
Application Temperature	70° to 100°F

3. The Process:

The complete process sequence normally consists of the following steps:

A. Thoroughly clean the metal surface using Parcosol 263 Wipes or a clean

Scotch Brite Pad followed by a Parcosol 263 Wipe to remove soils and metal fines. All metal to be treated with ALODINE 5700 Wipes must be dry and free from grease, oil and other foreign matter before treatment. Abrasive cleaning is also an acceptable method of surface preparation where scale or corrosion products exist. Remove all loose material from the surface by cleaning or re-cleaning with Parcosol 263 Wipes or equivalent.

- B. Wipe the clean surface with ALODINE 5700 Wipes. Use slightly overlapping vertical and horizontal, even pressured strokes. Make sure the entire bare metal surface is wetted with fluid. The surface can remain wet for less than one minute for the chemical reaction to be completed. Puddling of the fluid or prolonged wetting may create a dusty surface, which should be tacked off prior to painting, sealer application or adhesive bonding.
- C. Allow the wetted surface to dry at ambient temperature or speed drying with low velocity (do not disturb film) forced warm air, 100°F. to 200°F.
- D. If handling of the dried, treated work is necessary, operators should wear clean, low lint, cotton gloves so that the treated surface is not contaminated. If a treated surface becomes re-contaminated, go back to Step A, above.
- E. Apply paint, sealer or adhesive over the dry conversion coating and process as necessary to complete the painting, sealing or adhesive bonding operation.

4. Storage Requirements:

Always reseal the wipe package immediately after removing ALODINE 5700 Wipes. ALODINE 5700 Wipes should be protected from freezing. If the chemical is frozen, it will be irreversibly damaged and should not be used. ALODINE 5700 may precipitate if stored at temperatures below 40° or above 100°F. ALODINE 5700 Wipes must be stored between 40° and 100° F. Wipes that are accidentally allowed to dry out completely should not be re-moistened by adding water to the package. Dried out wipes should be discarded. To keep wipes moist, reseal any opened package of ALODINE 5700 Wipes using the zip lock closure feature on the package. Store wipes in a vertical position to maintain an equal level of saturation from wipe to wipe. If free fluid accumulates in the bottom of the wipe package, rotate the package 180° so the free fluid is re-absorbed by the less moist portion of the unused wipes.

5. Waste Disposal Information:

Applicable Local, State and Federal regulations covering disposal of chemicals should be consulted and followed. Disposal information for ALODINE 5700 Wipes is given on the Material Safety Data Sheet for the product.

6. Precautionary Information:

Before using ALODINE 5700 Wipes, the first aid and handling recommendations on the Material Safety Data Sheet should be read, understood and followed. The saturating fluid in ALODINE 5700 Wipes is acidic and may be irritating to skin and may cause burns to eyes. Avoid contact with skin and eyes. In case of contact follow the recommendations for contact given on the Material Safety Data Sheet for ALODINE 5700 Wipes.

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