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**SPM 70-00-99 S1220 - CONSUMABLE MATERIALS - SULFURIC ACID ANODIZING AND THIN FILM
 SULFURIC ACID ANODIZING HEXAVALENT CHROMIUM FREE SEALING SOLUTION**

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HIGHLIGHTS

HIGHLIGHT REFERENCE DESCRIPTION OF CHANGE

- tk70-00-99-801-819 Technical Change: Changed procedure title.
- tk70-00-99-801-819 Technical Change: Added Solution Sheet 1220 for a sulphuric acid anodizing hexavalent chromium free sealing solution.

TASK 70-00-99-801-819

1. Commercial Products.

- A. Socosurf PACS is an alternative solution to hexavalent chromium containing sealant applied after anodizing.

2. Composition.

Subtask 70-00-99-350-017

Consumable Product	No.	Concentration (Initial Mix)
Socosurf PACS	C03-125	8-12% (v/v)
Hydrogen Peroxide (35% Technical Grade)	C04-309	5-7% (v/v)

NOTE: Other concentration raw materials can be used if the concentration given in table is obtained.

3. Preparation.

Subtask 70-00-99-350-018

WARNING: REFER TO THE PRODUCT LABEL AND THE MANUFACTURER'S (MATERIAL) SAFETY DATA SHEET (SDS) FOR INSTRUCTIONS ON THE HAZARDS, STORAGE, SAFE HANDLING AND PROPER USE OF CONSUMABLE PRODUCTS.

WARNING: OPERATOR SHOULD WEAR FACE SHIELD, GLOVES, PROTECTIVE CLOTHING, AND PROTECTIVE SHOES.

- A. Fill the bottom of the tank with demineralized water.
- B. Add the required quantity of Socosurf PACS C03-125 and hydrogen peroxide C04-309, top with demineralized water up to the optimal fill level and stir.
- C. Prepared solution pH should be between 4.2 and 5.3.
- D. If the pH is less than 4.2, use ammonia diluted to 5% to increase the pH, and if the pH is more

than 5.3, use nitric acid diluted to 5% to decrease the pH.

4. Check.

Subtask 70-00-99-350-019

A. Determine the concentration of bath parameters as follows:

Checks	Limits	Recommended Intervals
Socosurf PACS	8-12 % v/v	Weekly
Hydrogen Peroxide (35% Technical Grade)	5-7% (v/v)	Twice a week
pH	4.2-5.3	Weekly

B. Follow the manufacturer's control procedures to maintain the solution.

5. Regeneration.

Subtask 70-00-99-350-020

A. If required, follow the manufacturer's regeneration procedures to maintain the solution.

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