

ENGINEERING MATERIAL SPECIFICATION

Material Name	Specification Number
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PHOSPHATE SOLUTION, ZINC, ACTIVATING AGENT

ESK-M5B327-A

PHOSPHATE SOLUTION, ZINC, ACTIVATING AGENT, LIQUID

ESK-M5B327-A2

1. SCOPE

The materials defined by these specifications are activating agents.

2. APPLICATION

These specifications were released originally for materials used as activating agent to control the crystallisation of zinc phosphate. The material is added to the wash zone prior to spray or dip phosphating.

3. REQUIREMENTS

3.1 STANDARD REQUIREMENTS FOR PRODUCTION MATERIALS

Material suppliers and part producers must conform to the Company's Standard Requirements For Production Materials (WSS-M99P1111-A).

3.2 CHEMICAL COMPOSITION

	ESK-M5B327-A	ESK-M5B327-A2
Total Phosphate as P ₂ O ₅	30.0 +/- 4.0 %	10.8 +/- 0.8 %
Titanium as TiO ₂	4.7 +/- 1.5 %	0.06 +/- 0.03 %

3.3 TITRATION

6.0 +/- 1.5 ml

15 +/- 3 ml

Titrate 10 ml of a 1 % solution by volume with 0.1n sulfuric acid (H₂SO₄). Use bromocresol green indicator.

3.4 pH-VALUE

10.3 +/- 1.0

9.9 +/- 0.3

1 % solution by volume at 20 °C.

Date	Action	Revisions
2002 08 19	Revised	Updated and renumbered
1996 04 04	Revised	Complete Revise, -A2 added K. Wolters
1987 12 18	SM/EQ 1579 TP	Released C. Herriott

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4. GENERAL INFORMATION

The information given below is provided for clarification and assistance in meeting the requirements of this specification.

4.1 The phosphate system released by these specifications consists of the following materials:

4.1.1	Phosphate Solution, Zinc, Alkaline Cleaner	SKM-5B9599-A or ESK-M5B340-A
4.1.2	Phosphate Solution, Zinc, Start Up	ESK-M5B337-A
4.1.3	Phosphate Solution, Zinc, Make Up	ESK-M5B338-A
4.1.4	Phosphate Solution, Zinc, Accelerator	SM-5B4509-A
4.1.5	Phosphate Solution, Zinc, Passivating Solution	SKM-5B9574-A or ESK-M5B326-A
4.1.6	Phosphate Solution, Zinc, pH Correction Agent	SKM-5B9574-B