PHOSPHATE SOLUTION, ZINC, PASSIVATING SOLUTIONS, ANTI FOAM AGENT **ESK-M5B391-A2**

PHOSPHATE SOLUTION, ZINC, PASSIVATING SOLUTIONS, PH CORRECTION AGENT **ESK-M5B391-A4**

1. SCOPE

The materials defined by these specifications are a chrome-free passivating system.

2. APPLICATION

These specifications were released originally for materials used as a passivating solution for dip or spray zinc phosphate operations.

3. REQUIREMENTS

3.0 STANDARD REQUIREMENTS FOR PRODUCTION MATERIALS

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

3.3 ESK-M5B391-A2

3.3.1	Chemical Composition	Anti foam agents in aqueous solution
3.3.2	pH Value of a 10 g/L H_2O Solution at 20 °C	8.0 +/- 0.5
3.3.3	Density at 20 °C	1.0 +/- 0.05 g/mL
3.3.4	Color	Light yellow

3.5 ESK-M5B391-A4

3.5.1	Chemical Composition	
	Phosphate as P205	54.3 +/- 1.0%
3.5.2	Density at 20 °C	1.57 +/- 0.05 g/mL

Date	Action	Revisions
2008 02 26	RE-ACTIVATED	Re-activated per Lucia Rama's request; The A1 version was taken off this spec and the A3 version is on a separate document; Inserted 3.1; Deleted 3.1, 3.2, 3.2.1, 3.2.2, 3.2.3, 3.2.4, 3.2.5, 3.4, 3.4.1, 3.4.2, 3.4.3, 3.4.5, 3.6 & 4 A. Sosa
2006 10 17	INACTIVATED	ESB-M5B391-A2 was inactivated, ESB-M5B391-A4 was inactivated 1996 10 14
1991 06 03	Released	EP00E01089485000

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3.5.3	Color	Colorless
3.5.4	Titration	15.3 +/- 1.0 mL
	Titrate 10 mL of a 1% by volume solution with 1N sodium hydroxide (NaOH).	
	Indicator	Phenolphthalein

5. GENERAL INFORMATION

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

The materials defined by these specifications must be used with the following phosphate systems.

5.1 DIP PHOSPHATE SYSTEM:

5.1.1	Phosphate Solution, Zinc, Activator	ESK-M5B373-A or SKM-5B9613-A
5.1.2	Phosphate Solution, Zinc, Precleaner	ESK-M5B374-A
5.1.3	Phosphate Solution, Zinc, Alkaline Cleaner	ESK-M5B375-A or ESK-M5B371-A
5.1.4	Phosphate Solution, Zinc, Activator	ESK-M5B370-A
5.1.5	Phosphate Solution, Zinc, Cleaner Additive	ESK-M5B358-A
5.1.6	Phosphate Solution, Zinc, Start-up	ESK-M5B368-A
5.1.7	Phosphate Solution, Zinc, Make-up	ESK-M5B369-A
5.1.8	Phosphate Solution, Zinc, Accelerator	S-M5B4514-A
5.1.9	Phosphate Solution, Zinc, Neutralizer	S-M5B4513-A
5.1.10	Phosphate Solution, Zinc, Sludge Conditioner	ESK-M5B335-A

5.2 SPRAY PHOSPHATE SYSTEM:

5.2.1	Phosphate Solution, Zinc, Alkaline Cleaner	ESK-M5B355-A
5.2.2	Phosphate Solution, Zinc, Start-up	ESK-M5B351-A
5.2.3	Phosphate Solution, Zinc, Make-up	ESK-M5B352-A
5.2.4	Phosphate Solution, Zinc, Accelerator Additive	ESK-M5B353-A
5.2.5	Phosphate Solution, Zinc, Accelerator	ESK-M5B354-A

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