

KEYKOTE 750

Nickel – Free, REACH and ELV
Compliant Heavy Zinc Phosphate



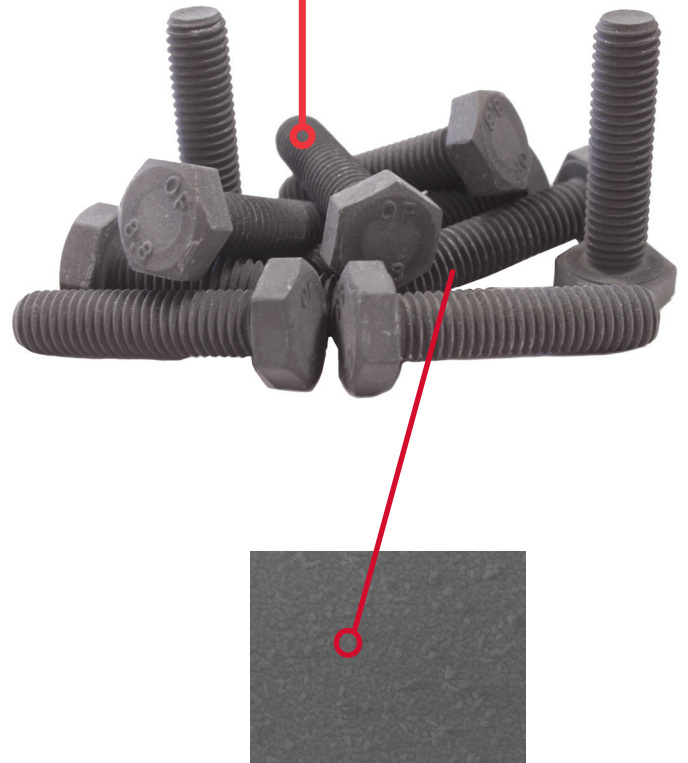
Rust Protective Coating

KeyKote 750 is a two component nickel-free heavy zinc phosphate coating process. It is proven to be superior to the existing processes for ease of application and increased coverage per liter. This results in an excellent coating performance and an economical operation.

KeyKote 750 produces a heavy, adherent, uniform zinc phosphate coating by immersion application. Coating thickness of 3 to 15 μm are easily obtained - meeting current zinc phosphate specifications for military and automotive hardware.

KeyKote 750 is chromium and nickel-free. This means that it is safer for applicators to work with, easier to effluent treat and is fully compliant with REACH and ELV directives.

As well as meeting automotive specifications from global OEMs 2010-Fe/Znph... such as BMW, Ford, GM, PSA and VW, it meets the requirements of ISO 9717:2010 Type ISO 9717:2010-Fe/Znph/... (previously EN 12476:2000 Type EN 12476-Fe/... /.



KEY FEATURES

- Coating retains oil to provide good corrosion resistance
- Exceptionally long bath life
- Stable bath process with reduced sludge formation
- Meets automotive, Oil & Gas and military requirements
- Nickel and chromium-free process

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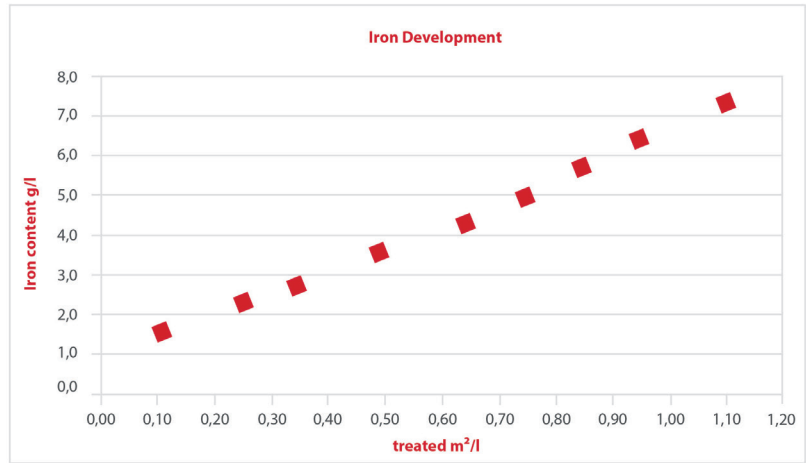
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KeyKote 750 delivers a consistent coating weight of 6 – 30g/m² and thickness of between 3 - 15 µm. These properties are ideal for oil retention.

KeyKote 750 coatings perform exceptionally well when required to absorb and retain oils. In particular it will give outstanding protection when used with rust-preventive oils. Die life is extended during cold forging and extrusion operations by protecting the work with a KeyKote 750 coating impregnated with a cold forming lubricant.

KeyKote 750 is an efficient, easy-to-use product. It is a two-component system – no supplementary accelerators or other additives are needed. The bath requires no special startup chemicals, is easy to control through simple analysis and has a high tolerance for iron, thus extending bath life and reducing maintenance downtime.



Process Sequence (Without Rinsing Stages)

| | |
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| Cleaning Stage | Prior to phosphating articles should be cleaned of oil, scale, rust, paint and general shop soils |
| Acid Pickling Stage Phosphoric Acid Based Pickles are Generally Preferred | Pickling methods have a great influence in controlling coating weight and crystal size, therefore they must be selected with care. |
| Conditioning (Optional) | KeyKote 604 |
| Phosphate Stage | KeyKote 750 for 5 - 10 minutes at 65-70°C |
| Hot Water Rinse | The hot rinse can be used as a neutralizing or passivating stage by adding KeyKote MBT or KeyKote 70MB |
| Post Phosphate Treatment Stage | KeyKote 168 oil emulsion |