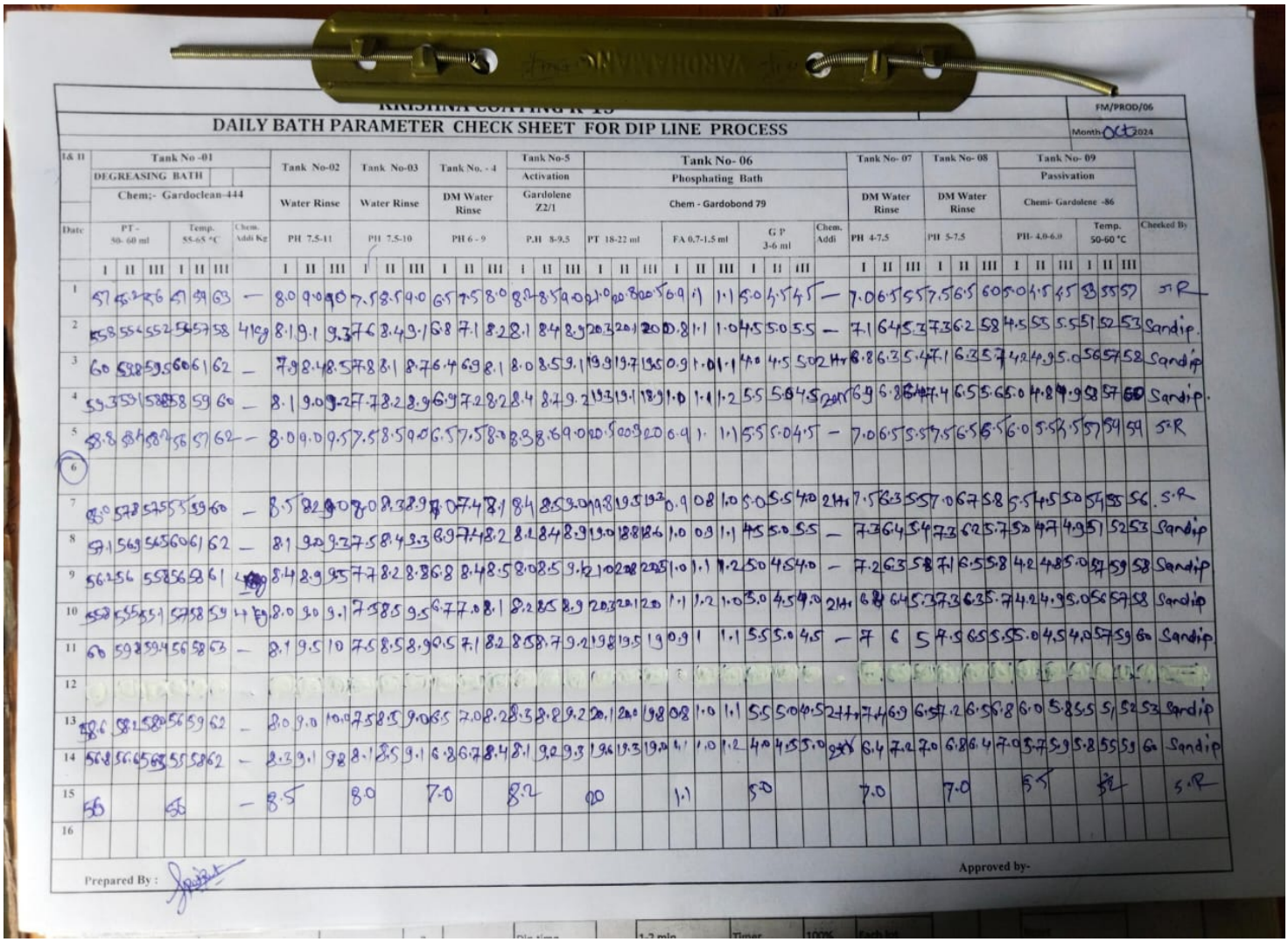

KRISHNA COATING K-15

FM/PROD/06

DAILY BATH PARAMETER CHECK SHEET FOR DIP LINE PROCESS

Month Oct 2024

I & II	Tank No -01			Tank No-02	Tank No-03	Tank No. - 4	Tank No-5	Tank No- 06			Tank No- 07	Tank No- 08	Tank No- 09		
	DEGREASING BATH			Water Rinse	Water Rinse	DM Water Rinse	Activation	Phosphating Bath			DM Water Rinse	DM Water Rinse	Passivation		
	Chem;- Gardoclean-444						Gardolene Z2/1	Chem - Gardobond 79					Chemi- Gardolene -86		
Date	PT - 50- 60 ml	Temp. 55-65 °C	Chem. Addi Kg	PH 7.5-11	PH 7.5-10	PH 6 - 9	P.H 8-9.5	PT 18-22 ml	FA 0.7-1.5 ml	G P 3-6 ml	PH 4-7.5	PH 5-7.5	PH- 4.0-6.0	Temp. 50-60 °C	Cheeked By
	I II III	I II III		I II III	I II III	I II III	I II III	I II III	I II III	I II III	I II III	I II III	I II III	I II III	
1	57 45 46	57 59 63	—	8.0 9.0 9.0	7.5 8.5 9.0	6.5 7.5 8.0	8.2 8.5 9.0	21.0 20.8 20.5	0.9 1.1	1.1 5.0 4.5	4.5	—	7.0 6.5 5.5	7.5 6.5 6.0	5.0 4.5 4.5	5.5 5.5	S.R
2	55 55 55	55 57 58	41kg	8.1 9.1 9.3	7.6 8.4 9.1	6.8 7.1 8.2	8.1 8.4 8.9	20.3 20.1 20.0	0.8 1.1	1.0 4.5 5.0	5.5	—	7.1 6.4 5.3	7.3 6.2 5.8	4.5 5.5 5.5	5.1 5.2 5.3	Sandip.
3	60 58 59	60 61 62	—	7.9 8.4 8.5	7.8 8.1 8.7	6.4 6.9 8.1	8.0 8.5 9.1	19.9 19.7 19.5	0.9 1.0 1.1	4.0 4.5 5.0	2.4	—	8.8 6.3 5.4	7.1 6.2 5.7	4.2 4.9 5.0	5.6 5.7 5.8	Sandip
4	59 59 58	58 59 60	—	8.1 9.0 9.2	7.7 8.2 8.9	6.9 7.2 8.2	8.4 8.7 9.2	19.3 19.1 18.9	1.0 1.1 1.2	5.5 5.8 6.0	2.8	—	6.9 6.8 6.4	7.4 6.5 5.6	5.0 4.8 4.9	5.8 5.7 6.0	Sandip.
5	58 58 58	56 57 62	—	8.0 9.0 9.5	7.5 8.5 9.0	6.5 7.5 8.0	8.3 8.6 9.0	20.5 20.0 20.0	0.9 1.0 1.1	5.5 5.0 4.5		—	7.0 6.5 5.5	7.5 6.5 6.0	6.0 5.5 5.5	5.4 5.4	S.R
6																	
7	58 57 57	55 59 60	—	8.5 8.2 9.0	8.0 8.3 8.9	7.0 7.4 8.1	8.4 8.5 9.0	19.8 19.5 19.2	0.9 1.0 1.0	5.0 5.5 4.0	2.4	—	7.5 6.3 5.5	7.0 6.7 5.8	5.5 4.5 5.0	5.4 5.5 5.6	S.R
8	57 56	56 60 61	62	—	8.1 9.0 9.3	7.5 8.4 9.3	8.9 7.4 8.2	8.1 8.4 8.9	19.0 18.8 18.6	1.0 0.9 1.1	4.5 5.0 5.5	—	7.3 6.4 5.4	7.3 6.2 5.7	5.0 4.7 4.9	5.1 5.2 5.3	Sandip
9	56	56	58	61	4.5kg	8.4 8.9 9.5	7.7 8.2 8.8	6.8 8.4 8.5	8.0 8.5 9.1	21.0 20.8 20.5	1.0 1.1 1.2	5.0 4.5 4.0	—	7.2 6.3 5.8	7.1 6.5 5.8	4.2 4.8 5.0	5.7 5.9 5.8	Sandip
10	55	55	57	58	59	14.5kg	8.0 9.0 9.1	7.5 8.5 9.5	6.7 7.0 8.1	8.2 8.5 8.9	20.3 20.1 20.0	1.1 1.2 1.0	5.0 4.5 4.0	2.4	6.8 6.4 5.3	7.3 6.3 5.7	4.2 4.9 5.0	5.6 5.7 5.8	Sandip
11	60	59	59	56	58	63	—	8.1 9.5 10	7.5 8.5 8.9	0.5 7.1 8.2	8.5 8.7 9.2	19.8 19.5 19.0	0.9 1.0 1.1	5.5 5.0 4.5	—	7 6 5	7.5 6.5 5.5	5.0 4.5 4.0	5.7 5.9 6.0	Sandip
12																	
13	58.6	58.2	58.0	56	59	62	—	8.0 9.0 10.0	7.5 8.5 9.0	6.5 7.0 8.2	8.3 8.8 9.2	20.1 20.0 19.8	0.8 1.0 1.1	5.5 5.0 4.5	2.4	7.4 6.9	6.5 7.2 6.5	6.8 6.0 5.8	5.5 5.1 5.2	5.3	Sandip
14	56.8	56.6	56.5	55	58	62	—	8.3 9.1 9.8	8.1 8.5 9.1	6.3 6.7 8.4	8.1 8.9 9.3	19.6 19.3 19.0	1.1 1.0 1.2	4.0 4.5 5.0	2.8	6.4 7.2 7.0	6.8 6.4 7.0	5.7 5.9 5.8	5.5 5.9 6.0		Sandip
15	56		56		—	8.5	8.0	7.0	8.2	20	1.1	5.0		7.0	7.0	5.5	5.2		S.R
16																	

Prepared By :

Approved by-