

SAGAR SPRINGS PVT. LTD.	Format	Fmt. No.	F/PC/02
	Pre-Treatment Daily Report	Amd. No.	02
		Date	26.06.2021

Date :

Sr No	Stages	Parameters	Specifications	Checking Frequency	Observation Time		
					Time am	Reading after addition	Time pm
1	Degreasing	Pressure	1.0 - 2.0 Kg/cm <sup>2</sup>	Twice / Shift			
		Temperature	40-45 °C				
		Free Alkali	9- 12 ml	Twice / Shift			
		Oil content	< 4.0 gm/litre	Once / 6 month			
	Chemical Addition	Bonderite 1523R	For 1 Pointage	8 ltr			
		Bonderite 1523S	For 1 Pointage	0.8 ltr			
2	Water Rinse-I	Pressure	1.0 - 2.0 Kg/cm <sup>2</sup>	Twice / Shift			
		Total Alkali	< 5 ml	Twice / Shift			
		pH	6.00 - 8.00	Once / Shift			
3	Water Rinse-II	Pressure	1.0 - 2.0 Kg/cm <sup>2</sup>	Twice / Shift			
		Total Alkali	< 2 ml	Twice / Shift			
		pH	6.00 - 8.00	Once / Shift			
4	DM Water Rinse - 1	Pressure	1.0 - 2.0 Kg/cm <sup>2</sup>	Twice / Shift			
		pH	6.0 - 7.5	Once / Shift			
		Conductivity	< 300 µ/cm	Twice / Shift			
5	Phosphate	Pressure	3.0-4.0 Kg/cm <sup>2</sup>	Twice / Shift			
		pH	4.5-5.5	Twice / Shift			
		Zr point	18 - 22ml.	Twice / Shift			
	Chemical Addition	Bonderite M-NT2011		0.83 KG/1000 LTR/1 point			
		Bonderite M-AD 700	INCREASE PH	100ML/1000 LTR			
		Bonderite C-IC 2520	DECREASE PH	100ML/1000 LTR			
6	DM Water Rinse -2	Pressure	1.0 - 2.0 Kg/cm <sup>2</sup>	Twice / Shift			
		pH	6.0 - 7.5	Once / Shift			
		Total Acid	< 5 ml	Twice / Shift			
7	DM Water Rinse -3	Pressure	1.0 - 2.0 Kg/cm <sup>2</sup>	Twice / Shift			
		pH	6.0 - 7.5	Once / Shift			
		Conductivity	<100 µ/cm	Twice / Shift			
9	Water Dry off	Temperature	115°C - 125 °C	Twice / Shift			

SIGNATURE OF SUPERVISOR