

Hindustan Electro Plating
Process Control Sheet of Phosphating

Name of Vender:-All								
SHEET - PRE						Date:- 02-05-2022		
Sr. No.	Stage	Name of Chemical	Conc.	Specified Point age & pH Value	Actual Point age & pH	Specified Temp.	Actual Temp.	Amount of Chemical Addition Done & Remarks
1	Degreasing	Steelex K-20	60-90 %	60-90ml	68ml	10 min 70-80 C	73° C	
2	Water rinse	Plane Water	Plane water	Ph-10-12	11.2	Room Temp.	Room Temp.	
3	Water rinse	Plane Water	Plane Water	Ph-10-11	10.5			
3	Acid Pickling	Hydrochloric Acid	As it is	40-50%	45%	Time 1-3 min	Room Temp.	
4	Water rinse	Plane Water	Plane water	2-7.	2.5	Room Temp.	Room Temp.	
	Water rinse	Plane Water	Plane water	3-7.	3.8			
5	Phosphating	AK-ZC-24	3-5%	25-40ml	35	75-85 C For 5-10 min	76° C	Add 200ml
6	Water rinse	Plane Water	Plane water	4-7.	4.5	Room Temp.	Room Temp.	
7	De-Rusting Dip	AK-22	Plane water	3-8.	5.2	10 sec For Room Temp.	Room Temp.	
8	Drying				10min.	7 - 10 min 70-80 C		
9	Oiling	AK-RO-404/EMA	As it is	—	Room temp.	Room Temp.	
Remark:-								
							Sign 	