

DATA SHEET

DEVECO RS-528

Deveco RS-528 is a yellow, iridescent, bright chromate conversion coating for electroplated zinc and electroplated cadmium. It produces an exceptionally bright and adherent, iridescent coating on zinc chloride plated work.

MAKE-UP AND CONTROL:

Make-up	1% by volume Deveco RS-528
Immersion time	15 to 40 seconds
Temperature	60 to 90°F
pH range	1.3 to 2.2

On zinc die casting, an acid dip is usually required.

The solution may be maintained at any concentration by either pH control or hexavalent chromium analysis. However, appearance of the work will serve as a guide in making additions to the solution. Maintain the desired color with additions of 0.2 to 0.6% Deveco RS-528, or 20% of the initial make-up additions.

ANALYSIS:

1. Pipet 4.0 mLs of the bath sample into a 250 mL Erlenmeyer flask.
2. Add about 50 mLs of DI water.
3. Add about 2 grams of ammonium bifluoride (NH₄FHF).
4. Add about 30 mLs of 50% hydrochloric acid (HCl).
5. Add about 10 mLs of 10% potassium iodide solution (KI).
6. Titrate with 0.1N sodium thiosulfate to the first sign of clearing in the sample.
7. Add about 5 mLs of starch solution.
8. Continue titrating to a clear endpoint.

Calculation: % Deveco RS-528 = mLs titrant x .25

CAUTION:

This product contains chromates and is acid in nature. Contact of salts or solution with skin or eyes should be avoided. In case of contact, flush contaminated area with a large amount of water. When handling this product, protective clothing, i.e. rubber apron, gloves, boots, and goggles should be worn.

EQUIPMENT:

Deveco RS-528 solutions require polyethylene, stainless steel, or koroseal lined tanks.

Read Material Safety Sheet before using this product.

DISCLAIMER:

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