

# DATA SHEET

## DEVECO 403

*A brilliant blue-bright chromate for zinc plating from the first part on.*

**Deveco 403** is uniquely formulated to produce a hexavalent blue-bright chromate conversion coating for zinc plate without the typical break-in period. This single dip chromate produces a brilliant blue-bright finish and provides excellent corrosion protection without leaching. It passivates and protects zinc plate from finger staining and discoloration.

Zinc plated fasteners finished with **Deveco 403** will retain their blue-bright appearance after the normal hydrogen relief bake cycle. This feature can result in important cost savings when post-bake dipping is eliminated.

Immersion and transfer times are not critical. One material can be used at slightly different concentrations to chromate on automatic machines, as well as, manually in baskets, barrels or on racks. Care should be taken to rinse the work off as quickly as possible after chromate dipping.

### MAKE-UP AND CONTROL:

For longer immersion and transfer times such as in automation:

<b>Deveco 403</b>	1.0% by volume
<b>Temperature</b>	70 to 80°F
<b>Time</b>	15 to 40 seconds
<b>pH</b>	1.6 to 2.1

For short immersion and transfer time such as manual rack and basket work:

<b>Deveco 403</b>	1.5 to 2.0% by volume
<b>Temperature</b>	70 to 80°F
<b>Time</b>	10 to 15 seconds
<b>pH</b>	1.4 to 1.8

To obtain maximum life of the chromate solution, it is important that the parts be thoroughly rinsed after plating. After chromating, the work is normally rinsed in cold water, then in warm water to dry the work and to impart a deeper blue finish.

The low cost of make-up and operation permits the solution to be discarded when it is spent and a fresh solution prepared. However, the bath may be maintained by adding sufficient **Deveco 403** to maintain the pH or the desired appearance to within the operating range.

**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 403** solutions require polyethylene, stainless steel, or koroseal lined tanks.

**Read Material Safety Sheet before using this product.**

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