

ROLEC Gehäuse-Systeme GmbH

Technical data concerning chromium free preliminary treatment of aluminium enclosures and profiles

Chemical composition, properties and application of NABUTANE STI/310

Chemical composition	
Nabutane: Composition: ph-value (1 %): Density: Contained substances:	STI/310 colourless liquid approx. 2.7 approx. 1.05 g/ml Hexafluoride titanate acid, polymers

Properties	
Nabutane STI/310	Nabutane STI/310 is a chromium free no-rinse procedure for aluminium and aluminium alloys. Corrosion resistance of the metal and adherence of paint are enduringly improved.

Application	
Nabutane STI/310	Nabutane STI/310 can be used both in immersion or spraying systems. For this, preliminary first class rinsing quality must be assured. After treatment, no further rinsing will take place (no-rinse). The parts are dried at once.
Concentration of initial preparation:	1 – 2 % Nabutane STI/310 in VE water



Bath conditions

Temperature:
Time of treatment:
Number of points:
ph-value:

20 – 45 °C
approx. 60 – 120 sec. (immersion), approx. 60 sec. (spraying)
A 3 – 6, B max. 2
2.6 – 3.0

Supervising bath

Nabutane STI/310

The Nabutane STI/310 bath is controlled by means of:

- the control of the ph-value
- the determination of the number of points (A, B).

Titration rules

Number of points A

100 ml of bath solution are titrated with 0.1 ml of caustic soda, after adding 10 drops of bromophenol blue as an indicator, till colour changes from yellow to violet.

Number of used ml of 0.1 caustic soda = number of points A

Number of points B

10 ml of bath solution are titrated with 100 ml of VE water, after adding phenolphthalein as an indicator, till colour changes from colourless to slightly pink.

Number of used ml of 0.1 caustic soda = number of points B



Procedure for chromium free preliminary treatment

