

KEMCOT L
ALUMINUM CONVERSION COATING
CONTAINING HEXAVALENT CHROMIUM

Description:

KEMCOT L is a special liquid product for providing aluminum with a golden iridescent chemical film or coating of the surface conversion type, for protection against corrosion and improvement of paint adhesion.

KEMCOT L meets the requirements of MIL-DTL-81706B Type I, Class 1A and 3 Form III (ready for use) and MIL-DTL-5541F Type I, Class 1A and 3.

Pre-Cleaning:

Before using **KEMCOT L** surfaces must be free from grease, soils and oxides. RADOL 22-22 (5% in the water at room temperature) is recommended for cleaning and deoxidizing. Parts must thoroughly be rinsed with clean water after cleaning. Rinse tanks should be kept pure and refilled daily.

Usage:

Brush Application:

Apply to a chemically cleaned surface using the solution undiluted, as received.

Immersion Application:

KEMCOT-L is used as received or diluted with water in a concentration of 33%. For each 100 parts of bath, mix 33 parts of **KEMCOT-L** and 67 parts of water. The clean aluminum parts are immersed in the **KEMCOT L** bath at room temperatures of about 30 seconds to 5 minutes depending on the aluminum alloy and the condition of the solution.

Ascertain the pH 1,5 – 2,1 by adding small amounts of ammonium hydroxide or nitric acid if necessary. The pH will normally be within the correct operating range without additions.

After treatment the parts should be thoroughly rinsed with water. First in water at ambient temperature and then with deionized water.

The final dry-off may be accomplished by conventional methods; however, temperature during drying should not exceed 50°C.

Product properties:

Appearance: Reddish-brown.

pH (neat): 1,5 – 2,1

Safety:

KEMCOT L is caustic. Avoid contact with skin and eyes. Rinse with plenty of water in case of contact. Wear protective clothing when handling.

Packaging:

KEMCOT L is available in 20 liter pails or 210 liter drums.