



EnviroServe Chemicals, Inc.

***Low Temperature / Phosphate-Free
Conversion Coating Products for the
Paint Pretreatment Industry***



Significantly Reduce Energy Costs
Eliminate Phosphate From Effluent Stream
Increase Corrosion Resistance
Shorter Contact Time
No Regulated Heavy Metals
Environmentally Friendly

We know what it takes:

Products, Service, Support, and Equipment

AMBIENT TEMPERATURE/PHOSPHATE-FREE Conversion Coating Products

EnviroKote 3380 NP and **EnviroKote 3381 NP** are inorganic conversion coating products for 4 to 7-stage spray washers prior to subsequent paint finishing processes. They are preceded by either a moderate pH cleaner followed by one rinse stage or an alkaline cleaner followed by two rinse stages. These products deposit a microcrystalline inorganic conversion coating. They operate at ~2 % concentration at ambient temperature. Both products perform best at pH ranges of 4.0 – 4.7 for steel / multi-metal substrates and 3.5 – 4.0 for aluminum substrates.



LOW TEMPERATURE/PHOSPHATE-FREE Cleaner/Conversion Coating Products

EnviroKote 3385 NP is a cleaner / conversion coating product for 3 to 5-stage spray washers prior to subsequent paint finishing processes. It is designed to be effective at ~2-4 % concentration at temperatures of ambient to 100 °F on light to moderate soil levels. It cleans multi-metal substrates while depositing a microcrystalline inorganic conversion coating.

EnviroKote 3386 NP is a cleaner / conversion coating product for 3 to 5-stage spray washers prior to subsequent paint finishing processes. It is designed to be effective at temperatures of 90 – 120°F on medium to heavy soil levels. It cleans multi-metal substrates while depositing a microcrystalline inorganic conversion coating.

These two products perform best at pH ranges of 4.0 – 4.7 for steel / multi-metal substrates and 3.5 – 4.0 for aluminum substrates.



LOW TEMPERATURE CLEANERS Designed especially to work with our inorganic conversion coating systems

Multi-Metal Phosphate-Free Alkaline Cleaner **EnviroClean 3416 LT**
Phosphate-Free Alkaline Cleaner **EnviroClean 3415 LT**

These cleaners are very effective in multi-stage spray washers at significantly lower temperatures than those typically found in most paint pretreatment washers. These cleaners operate efficiently at temperatures of 90 to 120°F depending on the soil type and level. Conventional alkaline cleaners in the market today operate at 140 to 160°F. These products are an excellent choice when two rinse stages are available prior to applying our inorganic conversion coating products, **EnviroKote 3380 NP** or **EnviroKote 3381 NP**.

Multi-Metal Low-Phosphate Mild Cleaner **EnviroClean 3410 LT**
Low-Phosphate Alkaline Cleaner **EnviroClean 3411 LT**

These products are highly effective on light to moderate soils and are recommended where only one rinse stage is available prior to the conversion coating. They are designed to operate at temperatures of 90 to 120°F depending on the soil type and level in comparison to conventional alkaline cleaners operating at 140 to 160°F.



ADVANTAGES OF INORGANIC CONVERSION COATINGS

Formulated to replace traditional iron phosphate products, these products require no or very little heat to deposit an inorganic conversion coating. Conventional iron phosphate products, on the other hand, can require temperatures of 130-160°F. Another benefit of this new technology is usage; a maximum of about 2% by volume, for the stand-alone coater, is needed in the bath compared to approximately 2-4% by volume with conventional iron phosphates.

These type of coatings provide a microcrystalline surface in the nanometer (10^{-9} m) range and require a short contact time of 15 to 30 seconds. Conventional iron phosphate coatings are usually in the micrometer (10^{-6} m) range and require at least 45 to 60 seconds contact time. The “nanocrystals” formed increase the surface area of the substrate thus enhancing paint adhesion, corrosion protection and consequently salt-spray results. These inorganic conversion coatings do not require a non-chrome post treatment seal to achieve high performance adhesion, under film corrosion and salt-spray resistance.

These new technology coatings also contain no regulated heavy metals and eliminate phosphate from the process bath. Sludge is also reduced to a minimum while waste treatment costs and other effluent issues are greatly diminished. Reduced sludge formation results in considerably lower maintenance costs since fewer bath dumps are needed and the incidence of plugged nozzles and other problems are reduced. Rinse water consumption is also reduced because of the lower amount of total dissolved solids present in these new coating baths. Lower total dissolved solids means less rinse water overflow is needed to maintain proper rinse integrity.

A truly environmentally friendly conversion coating.



Salt-Spray Performance

The corrosion resistance performance of these inorganic conversion coatings is compared below to conventional iron phosphate coatings (organic accelerator) with TGIC polyester and hybrid powder paint systems on cold-rolled steel and aluminum substrates.

Paint system	Substrate	Inorganic conversion coating 2% conc., 80 °F bath, 30 seconds contact time	Conventional iron phosphate conversion coating 4% conc., 140 °F bath, 60 seconds contact time	Hours of neutral salt- spray exposure (ASTM B-117)
TGIC Polyester	Cold Rolled Steel	0.5 mm creepage from scribe	1.8 mm creepage from scribe	504
TGIC Polyester	Aluminum	0.2 mm creepage from scribe	1.0 mm creepage from scribe	1008
Hybrid	Cold Rolled Steel	2.0 mm creepage from scribe	4.3 mm creepage from scribe	504
Hybrid	Aluminum	0.4 mm creepage from scribe	2.2 mm creepage from scribe	1008

Test panels were prepared and tested according to ASTM B-117 and evaluated according to ASTM D-1654 Method 2. Ratings were taken of the average creepage failure from the scribe mark after a predetermined number of hours of exposure.

As the table indicates, the inorganic conversion coatings outperformed conventional iron phosphate coatings in under film corrosion resistance.

AUXILIARY / COMPLIMENTARY PRODUCTS

pH adjuster up	EnviroAdjust 2375
pH adjuster up	EnviroAdjust 2378
pH adjuster down	EnviroAdjust 3245 NP
Cleaner booster additive	EnviroAdd 3354
Cleaner booster additive	EnviroAdd 3355
Cleaner booster additive	EnviroAdd 2252 B
Wetting agent additive	EnviroAdd 2244

For further information, recommendations and other regulatory information please refer to the individual Product Data and Material Safety Data Sheets and/or contact **EnviroServe Chemicals**.

EQUIPMENT

EnviroServe Chemicals can supply a wide range of manually and automatically controlled metering equipment to ensure effective control of your pretreatment operating parameters.

We recommend that all equipment, piping and pumps be constructed of 304 or 316 stainless steel alloys. If mild steel is used in construction, it should be appropriately lined. Chemical feed pump parts made from elastomers can be Buna-N, EPDM, Hypalon, Viton or Teflon. Consult your **EnviroServe Chemicals** representative for more details.

Find out how **EnviroServe Chemicals** can improve your pretreatment processes, reduce your energy costs and provide a better solution for your conversion coating needs:

- Call us at [910-892-1791](tel:910-892-1791)
 - Visit us at www.enviroservechemicals.com
 - E-mail us at <mailto:sales@enviroserveinc.com>
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**We Are Your Single Source Service-Oriented
Industrial Chemical Supplier for the Metal Industry.**

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