

Technical data sheet and product guideline



TENARISPRO

Anti-tarnish chemical passivation for

Color coordinates



L
a
b
c

Product form

Format	Ready to use
Chemical type	Acidic

Operating data

	Range	Optimal
Voltage (V)	n/a	n/a
Working temperature (°C)	60-66	63
Exposure time (sec)	5-20	10
pH	4-10	7
Anode/cathode ratio	n/a	n/a

CONCENTRAZIONIMETALLO

Deposit data

metallo	metallointervallo	metalloottimale
----------------	-------------------	-----------------

Preparation

Fill your vessel with TENARISPRO under ventilation.

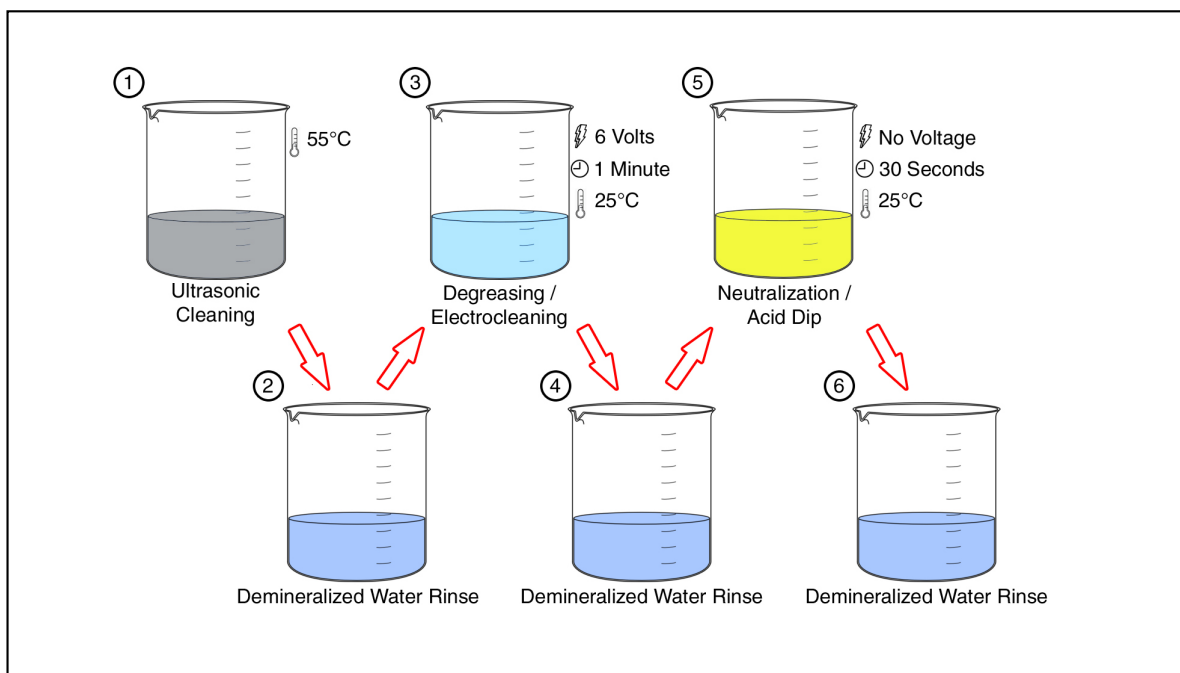
For optimum results the solution must be in a transparent state. Heat up to 62-63° C. The solution becomes transparent in the range 60-66° C. Higher or lower temperatures will make the solution turbid.

1. Electrolytic degreasing
2. Rinse
3. Acid neutralization
4. Rinse
5. Immersion in TENARISPRO for 10 minutes (with moderate agitation)
6. Rinse in hot water (70-75° C)(*)
7. Rinse with demineralized water
8. Dry with hot air (avoid drying systems that could remove the passivation)

(*) In case of items with complicated designs, liquid residuals can be removed more efficiently by rinsing in very hot water (85° C)

Equipment

For a correct use of this product you are advised to use PVC, polypropylene or PYREX glass tanks provided with thermostat-controlled heaters. Do not use stainless steel or iron tanks.



Product usage

1. Electrolytic degreasing
2. Rinse
3. Acid neutralization
4. Rinse
5. Immersion in TENARISPRO for 10 minutes (with moderate agitation)
6. Rinse in hot water (70-75° C)(*)
7. Rinse with demineralized water
8. Dry with hot air (avoid drying systems that could remove the passivation)

(*) In case of items with complicated designs, liquid residuals can be removed more efficiently by rinsing in very hot water (85° C)

Additional hints

EFFECTIVENESS OF THE SURFACE PROTECTION

The formation of the initial monolayer deposits within seconds or minutes. After the initial monolayer has formed, the layer still contains defects and is not fully ordered. Over time (hours to days), the layer comes to a more uniform and stable configuration.

PASSIVATION REMOVAL

To remove the passivation, simply degrease the pieces by means of alkaline cathode degreasing. Better results are obtained with the addition of a few grams of cyanide per liter.

REPLACING THE PASSIVATION SOLUTION

In case of reduction of the volume due to water evaporation, solution has to be replenished by demineralized water. TENARISPRO concentrate should be added to the solution if the effectiveness of the passivating solution becomes weaker. Effectiveness of the solution can be checked by submitting the pieces to a TAA test. Another important indicator can be represented by the level of the surface hydrophobicity. A properly working solution should give a surface with low water adherence, where water drops slip away easily.

STORAGE AND STABILITY

Store at temperatures below 30° C. Avoid direct sunlight. In the closed package the solution is stable for about 18 months. When open, it is recommended to use it within 6 months. A color change from white to yellow may be sometimes observed during the storage, even in a sealed new bottle. This change in color doesn't affect the properties of the product.

Packaging

