

TCJ-48 MX

Medium Zinc Phosphate “Non-Nickel”

TCJ-48 MX is a "lo-temp" medium- heavy coating zinc phosphate compound used for applying corrosion inhibiting coatings to steel in immersion tanks. Operates at 150 F. Ultra-low sludging, up to 75% less.

TCJ-48 MX is an immersion type product which provides coatings of 900 (+ /-200) mg/ft². Coatings are applied over steel and subsequently coated with a corrosion inhibiting coating, oil, wax or lubricant. Ultra-low sludging. Approved by and meeting various military and automotive specifications.

TCJ-48 MX provides a dark coating which resists many hours of corrosion resistance in salt spray testing conditions. Premium quality performance. Does not contain EDTA type products. Meeting various industry specifications. **BOOSTER 100** CAN BE USED TO BOOST COATING WTS ON HIGH ALLOY METALS.

Features & Benefits

Lo-temperature Processing: (Note: Nickel Free..... !!!)

1. Providing significant energy heating costs savings.
2. Ultra-low sludging for lowest cost & downtime.
3. Extended bath life by 3-5 times lowering cost.
4. Resistance to iron related problems. Up to 20 points iron
5. Provides dark dense coatings.
6. Provides improved corrosion resistance and bonding.
7. Eliminates "excess" heat related sludge on coils.
8. Effectively coats resistant alloys.

Physical Data

pH	1.0
Product Type	Liquid
Spec. Gravity	1.44
lbs./gal.	12.01
Foam, 0 = Low, 9 = High	0
Shelf-Life Years	10 years
Freeze Information	Not damaged by freezing.

Typical Processing

1. Pre-clean, Alkaline #2800 Or 2444-I, 8% B.V, 8 Min., 170 Deg. F.
2. Rinse (or Alkaline Descaler #399 Lr) (as Needed Per Various Specs)
3. Acid Pickle, (hydrochloric Or Sulfuric) 8 Min Optional As Needed.
4. Rinse,
5. 5) Preferred Rinse (maintain Low Conductivity Levels In All Rinses.)
6. Tc/zinc, 135-160+ F., 8-20 Min, 32+ Points Acid (re:5%) Iron Up To 20.
7. Rinse,
8. Rinse (No Chrome Sealers Used In This Process)
9. Oil Option: 10-20% By Volume #240, 125 Deg. F, 30-60 Sec.)
10. Dry To Touch "pre-paint Option" #2010, 1-4%, 125 Deg F. 30-60 Sec.
11. Lubrication Option: Loc-lube #5, 8 Oz./gal., 175 Deg. F, 4-10 Min.

Packaging

Container Type	Poly
Net Units	660
Tare Wt.	25 lb.
Gross Wt.	685
DOT_Name	UN 3264, Corrosive Liquid, Acidic, Inorganic, N.O.S., (Phosphoric & Nitric Acids), 8, PG II
DOT Hazard	Corrosive
Tarriff ID	2835.29

Use Parameters

Concentration Range	5% 30-95 (see Tests for Total)
Temperature Range	135 – 185 deg. F.
Time Range	8-20 min.
Agitation	n/a

Waste Disposal

Treat.

Holding Tank Materials of Construction

Acid resistant, stainless, or poly.

Other Information

It is important that the OSHA DATA, "Material Safety Data Sheet" be carefully read and reviewed with the users of this product. OSHA data is required to be posted in the work area by law.

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Testing, Operating & Troubleshooting Data

New Tank Make-up:

Fill Tank with Water Leaving Enough Room For 5% By Volume of Tcj. (5 Gallons Per 100 Gal). Place A Barrel of Parts in Solution Prior To Heating the Tank, In Order To "seed" Iron into The Bath. Allow The Parts to Sit In Solution Until the Tank Reaches Operating Temperature and The Solution Tests Positive For Iron. Process May Begin When the Operating Temperature Has Been Reached and Iron Is Positive.

Total Acid:(range 35-95)

1. Take A 10 MI Sample
2. Add 5-10 Drops Total Acid Indicator (phenol Indicator).
3. Titrate With 0.1 N Naoh (caustic Soda) (Color Will Change From Clear To Pink) 4)
Number Of Mls Used = Total Acid

*to Raise Total Acid- 1% Add Of Tcj Will Raise The Ta Points By 7.5

Free Acid: (range Per Ratio)

- 1) Take A 10 MI Sample
- 2) Add 5-10 Drops Of Bromophenol Blue
- 3) Titrate With 0.1 N Naoh (caustic Soda) (color Will Change From Yellow To Blue)
- 4) Number Of Mls Used = Free Acid

Acid Ratio:(range 4.5-9)

Ta/fa = 4.5 New Bath – 9 Older Bath With Higher Iron

Iron Test: (range 1- 15)

- 1) Take A 10 MI Sample
- 2) Add 5-10 Mls Of 50% Sulfuric Acid
- 3) Titrate With 0.2 N Potassium Permanganate (obtain A Permanent Pink Endpoint)
- 4) Number Of Mls Used = Points Of Iron



Peroxide Use To Lower Iron Level In A Zinc Phosphate Bath

A 1 Gallon (5 Liters) Of 15% Hydrogen Peroxide To A 1000 Gallon Zinc Phosphate bath Will Decrease The Iron Points By 1.0.

Effective Total Acid: Target 35+ Points Of Eta

Eta= Total Acid – (iron X 3.5)

Target = 35-45 Pts Of Effective Total Acid

<u>Iron</u>	<u>Total Acid Target</u>
1.0	35-45
2.0	42-52
3.0	45.5-55.5
4.0	49-59
5.0	52.5-62.5
6.0	56-66
7.0	59.5-69.5
8.0	63-73
9.0	66.5-76.5
10.0	70-80
11	73.5-83.5
12	77-87
13	80.5-90.5

Our People. Your Problem Solvers.

For more information on this process,
please call us at 203.756.5521 or email: techservice@hubbardhall.com

Hubbard-Hall holds certifications for **ISO 9001:2015**, Responsible Distribution, as accredited by the **ACD** (Alliance for Chemical Distributors) and as a **Women-Owned Small Business**, as well as maintaining an association with **Omni-Chem**¹³⁶.