Bond Guard 1347-MX

Lo-Foam Detergent & Iron Phosphate

#1347-S is a detergent, 3-5 stage process iron phosphate conversion coating for all metals of steel, aluminum and zinc-galvanize. recognized as a hybrid conversion coating product.

#1347-S provides superior bonding and corrosion resistance. offering coating weights up to 175 mg/ft2. excellent detergency and free of metals such as molybdenum.

#1347-s is a premium product which is internally accelerated with a highly stabilized acid balance to provide maximum quality. Also used as a lubricant base for extrusions and bonding of adhesives.

Note: For added wetting agent detergency see Surfcon 100, for both detergency and defoaming see Surfcon 61.

Features & Benefits

- High solids liquid which provides ease of feeding.
- Balanced acid system for greater process control.
- Superior quality over competitive 3 stage processes.
- Extended coating weight range over standard 3 stage systems or detergent type products. Excellent salt spray, humidity and water immersion resistance.
- Significantly improves corrosion resistance and bonding performance.
- Satisfies requirements of “Tide” test as defined by appliance industry.
- Resistant to hard water. Meets military spec TT-C-490, Type II.

Physical Data

pH	2.0
Product Type	Liquid
Spec. Gravity	1.14
lbs./gal.	9.51
Foam, 0 = Low, 9 = High	0
Shelf-Life Years	10 years
Freeze Information	Not damaged by freezing.

Typical Processing

1. #1347-S Detergent Iron Phosphate, 140 F., 90 seconds, 1.5-4%. pH @ 4.5-5.5 (use meter).
2. Rinse.
3. Treated rinse, non-chrome toner sealer NCS-3, .2%, 125 F. 30 sec.
4. Optional D > I > water rinse.
5. Air blow off (Dry ovens should not exceed 250 F. for iron phosphates) to coating line

Note: #1347 Can be used in 5 stage systems also. Simply Use #1347-S in Stages #1 & #3

Packaging

Container Type	Poly
Net Units	523
Tare Wt.	25 lb.
Gross Wt.	595
DOT_Name	UN 1805, Phosphoric Acid Solution, 8, PG III
DOT Hazard	Corrosive
Tarriff ID	2835.22.00

Use Parameters

Concentration Range	2-4%
Temperature Range	100 – 150 F.
Time Range	30-120 seconds
Agitation	As available.

Waste Disposal

Neutralize.

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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Our People. Your Problem Solvers.

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

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