HAUG CHEMIE
iChem solutions based on partnership

Iron phosphating

eska®phor W 665

Product characteristics and performance features

- Degreasing and iron phosphating agent
- creates dense bluish iridescent layers on steel
- Excellent adhesion primer for paintwork and powder coatings
- Temporary corrosion protection
- Foamfree at 50°C
- multi-metal capable
- sprayable

Application range

eska®phor W 665 is used in single or multi-chamber spraying systems for cleaning or phosphating light metal and iron materials as well as galvanized steel.
After cleaning or phosphating, the workpiece surface is rinsed with clear, cold water to remove adhering product residues from the surface. Depending on the requirements of the workpiece surface, rinse with fresh water or demineralized water. The surface is then dried with hot air (100 - 120 °C). If no drying is available, a further hot rinsing bath must be installed downstream so that the workpieces dry by their own heat after removal. Drying can be additionally supported by blowing off with air.

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Advantages and benefits

Advantage: produces a high-quality phosphate layer
Benefit: Good primer and temporary corrosion protection for temporary storage

Advantage: Use of pH-controlled dosing possible
Benefit: Reduced control effort and product consumption. Stable process

Advantage: Degreasing and phosphating in one work step
Benefit: Economical, as no additional cleaning is required

Technical data

Density (20°C):	approx. 1.33 g/cm³
pH value (1% solution):	approx. 4.5

Preparation and operating data

Concentration:	1.5 - 2.0 vol.%
Bath temperature:	40 - 55 °C
Treatment time:	1 - 3 min
Spray pressure:	1 - 2 bar
pH value:	5.0 – 5.8

Depending on the water hardness, the pH value is in the range of pH 3.0 - 5.0. To achieve the above-mentioned optimum working range, the pH toner eska®phor P 347 should be added to the bath solution in stages. The pH value should be monitored regularly using suitable equipment, e.g. an electric pH meter.

Bath monitoring:	10 ml bath solution Phenolphthalein indicator solution (colorless-pink; pH 8.5) 0.1 N sodium hydroxide solution Factor tap water 0.23

Concentration (vol. %) = Consumption of measured solution (ml) x Factor
(see also titration instructions eska® phor products for bath monitoring)

Supplementary documents

Slight variations in color and appearance between individual product batches have no influence on the quality and functionality of the product. The information is based on technical knowledge and experience. For information on the safe handling of our product, please refer to the corresponding safety data sheet.

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