



1000 Western Drive  
Brunswick, OH 44212  
PHONE: 330/225-3200  
FAX: 330/225-1499  
www.columbiachemical.com

## COLDIP TRI-V 120

### TECHNICAL DATA

02-29-19

## COLDIP TRI-V 120

### A HIGH CORROSION RESISTANT "TRIVALENT BLUE-BRIGHT" CONVERSION COATING FOR ZINC

COLDIP TRI-V 120	is a unique all "trivalent" conversion coating for electroplated zinc.
COLDIP TRI-V 120	will impart an aesthetically pleasing blue-bright conversion coating which when applied properly will produce a finish that exceeds 120 hours of neutral salt spray to white corrosion products.
COLDIP TRI-V 120	is a cost-effective alternative to high corrosion finishes in an all "trivalent" containing products.
COLDIP TRI-V 120	is an easy to use one-part system that is applied by conventional immersion techniques.
COLDIP TRI-V 120	is approved by General Motors Worldwide under the GMW 3044 specification.
COLDIP TRI-V 120	is approved by Delphi Corporation under Delphi DX 551200 specification.
COLDIP TRI-V 120	when top coated with Zinc-Chro-SHIELD or Zinc-Chro-PELLENT™ will provide 350+ hours to white corrosion products.

## OPERATING PARAMETERS

	<u>GENERAL APPLICATION</u>	<u>GMW 3044 APPLICATION</u>
Concentration:	3% to 8% by volume	6% to 8% (Optimum 7%)
Dip time:	30 to 90 seconds	50 to 70 seconds (Optimum 60 seconds)
Temperature:	80° to 100° F (26° - 38° C)	80° to 100° F
pH:	1.5 to 3.0	1.8 to 2.4 (Optimum 2.0)
Zinc deposit thickness:	Minimum 0.3 Mil (8 Microns)	8 to 16 Microns

NOTE: Dip times can vary depending upon the concentration and the age of the chromate.

## MAINTENANCE ADDITIONS

Periodic titrations should be made to ensure correct concentration. If the analysis shows the proper amount of COLDIP TRI-V 120 and the pH is high, small additions of 50% by volume of nitric acid can be made to adjust the pH.

## ANALYTICAL PROCEDURE

1. Pipette a 10 ml chromate sample into a 100 ml volumetric flask. Dilute to 100 ml with distilled water and mix well.
2. Pipette 10 ml of the above diluted solution into a 250 ml Erlenmeyer flask and dilute to 100 ml with distilled water.
3. Add 5 ml 20% Sodium Hydroxide and 1 ml 35% Hydrogen Peroxide.
4. Boil solution approximately 5 minutes.
5. Slowly add 1 ml 10% Nickel Chloride Solution and continue boiling for an additional 2 minutes.
6. Cool solution to room temperature.
7. With mixing, add 10 ml Concentrated Hydrochloric Acid, 1 g Ammonium Bifluoride, 10 ml 10% Potassium Iodide and 2 ml Starch Indicator Solution.
8. Titrate with Standard 0.010 N Sodium Thiosulfate from a blue to clear-green endpoint.

FACTOR: ml 0.010 N Sodium Thiosulfate x 0.382 = % COLDIP TRI-V 120

## TYPICAL CYCLE

1. PLATE
2. RINSE
3. ACID PRE-DIP (0.25% TO 0.5% NITRIC ACID)
4. RINSE
5. COLDIP TRI-V 120
6. COLD WATER RINSE
7. HOT WATER RINSE
8. DRY

## HELPFUL HINTS

1. A Nitric Acid pre-dip is recommended to increase the life of the COLDIP TRI-V 120 solution, particularly when an alkaline zinc electrolyte is utilized.
2. Removing fallen parts from the COLDIP TRI-V 120 tank and the Nitric Acid pre-dip tank is recommended to reduce the build-up and drag-in of iron contamination. In cases where the iron has exceeded the maximum concentration, the use of COLDIP IRON CONTROL can be used to help extend the life of the chromate.

3. Although the pH for a new solution make-up may be below the recommended operating range of 1.5 to 3.0, parts can be processed since the pH will climb after only a few hours.
4. Zinc-Chro-SHIELD or Zinc-Chro-PELLENT™ can be used in the final hot water rinse to help improve corrosion protection.
5. With trivalent chromate-based conversion coatings, care should be taken to avoid excess abrasion of the parts after processing. Trivalent coatings when fractured do not “heal” as in the case of traditional hexavalent products.
6. A cold COLDIP TRI-V 120 solution will affect the corrosion resistance of the chromate film. Maintaining the working temperature at 90° to 100°F, 32° to 38°C, will help improve corrosion protection.
7. Simply by increasing the COLDIP TRI-V 120 working concentration, temperature and dwell time can improve overall consistency of color and corrosion protection.

## **HANDLING & STORAGE**

Columbia Chemical recommends referring to the specific product Safety Data Sheets for safety, handling, and storage precautions.

## **NON-WARRANTY**

The data contained in this bulletin is believed by Columbia Chemical Corp. to be accurate, true, and complete. Since, however, final methods of use of this product are in the hands of the customer and beyond our control, we cannot guarantee that the customer will obtain the results described in this bulletin, nor can we assume responsibility of the use of this product by the customer in any process which may infringe the patents of third parties.