



COLDYE YELLOW 100

TECHNICAL DATA
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COLDYE YELLOW 100 CONCENTRATED DYE FOR ZINC PLATED PARTS

COLDYE YELLOW 100	can be added directly to any trivalent chromating solutions for zinc plated parts.
COLDYE YELLOW 100	reacts with the trivalent clear chromate coating to provide a uniform yellow-gold color.
COLDYE YELLOW 100	works equally well on chromated zinc plated parts from alkaline cyanide-free, acid chloride, and cyanide zinc plating baths.

OPERATING PARAMETERS

Add COLDYE YELLOW 100 directly to the chromate tank:

	<u>RANGE</u>	<u>OPTIMUM</u>
Concentration	1 - 3% by volume	2% by volume
pH	1.7 - 2.2	2.0
Temperature	75 - 85° F (24 - 28° C)	80° F (26° C)
Dip time	45 - 80 seconds	60 seconds

MAINTENANCE ADDITIONS

Additions of COLDYE YELLOW 100 are made by visual inspection of the parts. Simply increase the concentration of COLDYE YELLOW 100 when a greater degree of yellow-gold appearance is desired.

TYPICAL CYCLE

1. ZINC PLATE
2. COLD WATER RINSES
3. NITRIC ACID DIP (0.25 - 0.5%)

4. COLD WATER RINSE (OPTIONAL)
5. TRIVALENT PASSIVATE / COLDYE YELLOW 100
6. COLD WATER RINSE
7. HOT WATER RINSE
8. DRY

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.