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COLDYE YELLOW 100

LIQUID DYE FOR ZINC PLATED PARTS
TECHNICAL DATA
12-21-10

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.

STARTUP AND OPERATING PARAMETERS

Add COLDYE YELLOW 100 directly to the chromate tank:

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

CONTROL AND MAINTENANCE

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% to 0.5%)
4. Cold water rinse (optional)
5. Trivalent Chromate / COLDYE YELLOW 100
6. Cold water rinse
7. Hot water rinse
8. Dry

HANDLING

COLDYE YELLOW 100 is not known to be hazardous, but should be handled with care - using normal precautions to avoid contact with eyes and skin. Wear chemical goggles, rubber gloves, and clothing suitable to prevent skin contact.

STORAGE

No special precautions.

NON-WARRANTY

The data 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 assure any responsibility of the use of this product by the customer in any process which may infringe the patents of third parties.