

WinKote 3380 NP

(Conversion Coating)

- ◆ Phosphate-Free ◆ Low Temperature ◆ Short Contact Time (15 – 30 seconds)
- ◆ Minimal Sludge ◆ Enhances Salt Spray Results

WinKote 3380 NP is a phosphate-free conversion coating with no regulated heavy metals. It is especially formulated for use in the treatment of steel, zinc and aluminum surfaces. It is designed to help reduce energy cost by providing a very effective conversion coating that can be applied successfully at temperatures ranging from 70 to 110°F. These lower temperatures will help lower increasing energy cost when compared to traditional iron phosphate products that run at temperatures ranging from 130 to 180°F. **WinKote 3380 NP** provides a microcrystalline surface in the nanometer (10^{-9} m) range and this in a very short contact time of 15 to 30 seconds. Conventional iron phosphate coatings are usually in the micrometer (10^{-6} m) range and it requires at least a 45 to 60 seconds contact time. The “nanocrystals” formed with **WinKote 3380 NP** increase the surface area of the substrate thus enhancing paint adhesion, corrosion protection and consequently salt-spray results. Since **WinKote 3380 NP** has no phosphate, sludge is reduced to the minimum while waste treatment costs and other effluent issues are greatly diminished. Typical coating weights vary depending on the substrate, application temperatures, and method of application. **WinKote 3380 NP** generally operates from 2 to 4% by volume, which is comparable to conventional iron phosphate products. **WinKote 3380 NP** should be preceded with a mild pH type cleaner or an alkaline cleaner followed by two rinse stages.

TYPICAL PROPERTIES

Appearance	Clear Colorless Liquid
Foaming Ability	None
pH of 2% Solution	2.4 – 3.0
Rinsing Ability	Superior
Solubility	Excellent
Specific Gravity	0.98 – 1.04

USING PROCEDURES

For most operations, dilute **WinKote 3380 NP** to 2 to 4 % and apply at 70 – 110°F. Increasing temperature will facilitate faster conversion coatings. Consult your Win Solutions representative for the optimum operating concentrations.

EQUIPMENT

All equipment, piping and pumps should be constructed of 304 or 316 stainless steel alloys. If mild steel is used in construction, it must be appropriately lined. Chemical feed pump parts made from elastomers can be Buna-N, EPDM, Hypalon, Viton or Teflon. Consult your Win Solutions representative.

MATERIAL SAFETY

WinKote 3380 NP is safe to be used as a phosphate-free conversion coating and paint-pretreatment for most metals.

WinKote 3380 NP should be stored in a cool dry area. Store away from incompatible substances; see an issued MSDS.

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