

Passivate 606

Passivate 606 is a citric acid based concentrated passivation formulation designed to clean surface of stainless steel from rust, free iron and other contaminants present in the surface of stainless steel itself and deposited by the working on it, drawing, machining, tooling etc. The purpose is to clear all the rust potential from the surface.

Been used for years to passivate medical instruments Passivate 606 is highly effective in passivation and removing rust from stainless steel parts 300 & 400 series. Especially surgical , Dental and other instruments of stainless steel. Besides being highly effective Passivate 606 has minimum or no effect on the base metal. does not etch the surface. Very important for workshop is that it gives great flexibility in batch schedules and timings.

Process:

Clean and degrease the instruments before passivation step. The cleaner the surface the better passivate surface is obtained.

Mix one part of passivate 606 with 5 parts of clean water (De-ionized or filtered with reverse osmosis) Warm upto 80 degrees C to activate the solution. Passivate 606 also works at room temperature , but to shorten the batch time and speed up the process , we recomend to warm up the solution as described.

The solution must be kept below boiling, high temperatures can reduce the efficiency of the liquid.

Non magnet preferably 316 grade stainless steel tanks should be used to fabricate passivation tanks.

Dip the instruments / parts 20-30 minutes. Dipping time is very important variable in this process and can be adjusted according to the nature of instruments. Usually instruments with less machining need lesser time and instruments with more machining, joints, welds, etc. need more dipping time. So variations in time and concentration are allowed depending on the application.

Experiments can determine best duration of time and compatibility/suitability of the chemical with your products.

Water Rinse thoroughly. A neutralizer solution may be used to neutralize any residues of passivation chemical . Again water Rinse and dry.

Any test recomend for the instruments/parts according to the material and process used , may be done and inspected. The passivation process may be repeated for any problem pcs.

Care: Although Passivate 606 is very safe to use, yet the process should be done in well ventilated area. Eye protection should be used by the workers. May cause slight skin irritation and should be water rinse immediately.

Storage: Passivate 606 should be stored in plastic containers at normal temperatures.

Packing : 10L , 20L, 50L, 200L.

