

SurTec® 520

Glide Wax

Properties

- liquid lubricant dispersion
- after drying it produces a homogeneous, colourless and stable layer
- decreases the friction coefficient to about 0.11-0.13, depending on the base material and the concentration of SurTec 520 being used
- improves the corrosion resistance of the layer system
- IMDS-number: 41368885

Application

SurTec 520 is applied as a topcoat after plating and passivating.

	<i>centrifuge</i>	<i>immersion</i>
make-up values:	25 %vol	12.5 %vol
make-up:	Steps for make-up: <ol style="list-style-type: none">1. Fill SurTec 520 into the clean tank.2. Fill up to the final volume with deionised water, stirring vigorously.	
temperature:	room temperature	(10-40°C)
pH-value:	8-10 in the current process adjust with ammonia solution or with SurTec 520 A, if necessary	
application time:	20 s; the parts should be wetted completely	
agitation:	not necessary	
tank material:	steel tank with plastic coating, stainless steel or plastic tank	
filtration:	not necessary	
heating/cooling:	not necessary	
exhaust:	not required	
hints:	After treatment the parts should be dried directly (at approx. 60°C). Protect SurTec 520 from freezing.	

Technical Specification

(at 20 °C)	Appearance	Density (g/ml)	pH-value (conc.)
SurTec 520	viscous, white-yellowish	1.000 (0.96-1.04)	8 (7-10)

Maintenance and Analysis

Analyse and adjust the concentration of SurTec 520 and the pH-value regularly.

Replenish missing volume with fresh solution, according to the make-up.

Sample Preparation

Take a sample at a homogeneously mixed position. If bigger particles are in the sample, decant the solution.

SurTec 520 – Analysis by Dry Residue (ISO 3251)

equipment: glass bowl, analytical balance, drying cupboard

procedure:

1. Weigh out a clean empty bowl.
2. Pipette 25 g sample into the bowl.
3. Dry the sample at 120 °C for 2 h in an drying cupboard.
4. Let it cool down to room temperature.
5. Weigh the bowl again.

calculation: $\text{dry residue in g} \cdot 11.4 = \% \text{vol SurTec 520}$

Ingredients

- dispersion of polyethylene

Consumption and Stock Keeping

The consumption depends heavily on the drag-out. To determine the exact amounts of drag-out, see [SurTec Technical Letter 11](#).

In order to prevent delays in the production process, per 1,000 l bath, the following amount should be kept in stock:

SurTec 520 200 kg

Product Safety and Ecology

The safety instructions and the instructions for environmental protection have to be followed in order to avoid hazards for people and environment. The Material Safety Data Sheets (according to European legislation) contain explicit details for this.

The following hazard designations and classifications into water hazard classes (WHC) have to be taken into account:

<u>product</u>	<u>hazard designation</u>	<u>water hazard class</u>
SurTec 520	-	WHC 1

Warranty

We are responsible for our products in the context of the valid legal regulations. The warranty exclusively accesses for the delivered state of a product. Warranties and claims for damages after the subsequent treatment of our products do not exist. For details please consider our [general terms and conditions](#).

Further Information and Contact

In our forum, you can discuss topics of the surface technology:
<http://forum.SurTec.com/>

If you have any questions concerning the process, please contact your local technical department: <http://SurTec.com/International.html>