

高精纯黑色膜处理

产品名称	高精纯黑色膜处理
公司名称	东莞市大朗景丰五金加工厂
价格	2.20/KG
规格参数	产品:高精纯黑色膜处理 工艺:表面锰系处理 类型:东莞非标零件加工、东莞非标零件加工、 东莞非标零件加工
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产品详情

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来源: 东莞市华宇五金膜层处理厂 作者: 盘先生

广州五金机械配件耐蚀性磷化产品详细

ph Phosphating of phosphating film in liquid iron ion concentration is too low, so the required ph. Instead, the iron ions content is higher, the less acid alkaline. Use high manganese series phosphating solution of free acid ph control is very simple, such as acid, alkali is 1 then free acid is 0.1. Explore acid alkaline reaction of manganese series phosphating solution, results showed that nitrate content of 0.5, when ph 5 said passivation reaction, passivation membrane. Acid alkali is 2, the film is a complex of phosphating film and passivation film, the nitrate content, the greater the phosphating film area is larger, when the acid alkali is 3, phosphating film formed, so the department of high manganese phosphating liquid acid alkaline 2.5 is best. The temperature Whether can for the production of the phosphating liquid and phosphating film, temperature is an important one of the reasons, and temperature on the efficiency of the phosphating film and phosphating effect is very obvious. Suitable temperature can not only make the iron in the melting of the anode region and iron phosphate reaction, shorten the time of the phosphating film formation. Can also activate a region of low ability, forming the activation center the crystal quantity increase quickly, and form the crystallization speed, at the time of reaction and generation, the center of the large crystal havent fully grown, and have new crystals begin to produce. Meticulous crystallization density, phosphating film closely, thickening of the thickness of the phosphating film, enhanced corrosion resistance, low temperature phosphating film formed of the phosphating liquid content of less than, cant complete phosphating film production. Temperature is too

large, which leads to the separation of components can be dissolved, separating out large amounts of zinc ion and phosphate ion, makes a lot of phosphate rapid separation, produce large amounts of sediment, losing the original dynamic equilibrium, liquid at room temperature is too high, not only affect the change of acid ratio, and reaction speed too fast, the phosphating film crystallization bulky, void ratio is too large, produce phosphating phosphating film residue super weight, corrosion resistance is low, influence the luster of the coating, and bath stability.

东莞市华宇表面磷化膜处理厂主营高难度表面锰系磷酸盐磷化处理、抗防锈机械灰黑磷化处理、抗蚀性金属铁系磷酸盐磷化、耐磨性零件浅黑色磷化处理。咨询热线：135 0902 5030

东莞市锌磷化处理厂

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地址：广东省东莞市塘厦镇林村工业区 Phosphating process of form a complete set of equipment calculation of phosphating tank volume According to the weight and area of the workpiece phosphating tank volume calculation, control and reasonable product area and the proportion of the phosphating liquid product, avoid because of phosphating work continuously produce large amounts of bivalent iron ion, lead to black phosphating liquid, according to the conventional phosphating tank of the solutions of load per unit volume is 3-15 square metre per cubic, can not be more than 258 square meters each cubic, or bath because the load is too large, important component in phosphating liquid consumption too fast, prompted the phosphating liquid is unstable, difficult to adjust. phosphating tank manufacturing Phosphating tank generally pided into two types: circular tank and the rectangular slot, in front of a suitable for mass production, the latter is suitable for the production and batch. Material must be used in the phosphating slot can withstand the corrosion of phosphating liquid and high temperature resistant, must have sufficient strength to withstand a load of phosphating liquid never deformation. Phosphating tank best with 4 to 8 mm thickness of steel plate, manganese phosphating liquid temperature is higher, generally around 95 degrees, solution acidity, selects the stainless steel, plastic tank, with 8 to 14 mm plastic board as well, some phosphating tank with the cement tank, inside put a plastic or glass fiber reinforced plastic anti-corrosion, the phosphating tank production costs low, can produce large phosphating slot. Ship form phosphating slot with cone bucket, facilitate collection phosphating residue. Cone bucket can discharge in the phosphating slot at the bottom, also can be in local place, should be designed at the bottom of the nozzle, the phosphate slag flow in accordance with the requirements to the cone bucket. Square phosphating tank bottom to the slag discharge mouth tilt, the slope gradient is 4 to 8, in the phosphating slot sloped drain pipe should be assigned to the lowest place. Phosphating tank volume of general solutions for 3 to 5 times the pump output.

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