



PPC-49

Dip and Spray Zinc Phosphate for Iron and Steel

DESCRIPTION

Crest PPC-49 is used as a coating on the frictional surfaces of gears, bearings, crankshafts, valve lifters, tool joints, valve seats, etc. It will prevent galling, scuffing and scoring during break-in periods. A PPC-49 coating is particularly suitable for impregnation with oils, or other lubricants for increased corrosion and friction resistance. Surface preparation of the metal before phosphating is one of the most important factors in obtaining a quality coating.

Surfaces may be cleaned by abrasive blasting or chemicals. A rough metal surface often accelerates the coating formation, producing fine crystalline coatings. Very fine coatings are obtained on grit-blasted, sand-blasted, and vapor-blasted surfaces. Machined areas, on the other hand, may produce non-uniform, shiny coatings.

When chemical cleaning is the method desired, we recommend Crest PAC-52 at a concentration of 4 to 6 oz/gallon or Crest SC-818 at a concentration of 5% by volume, and a temperature of 80°-200°F. After cleaning, parts must be thoroughly rinsed in clean water before phosphating. Most phosphate systems, that are not getting good results, can trace all their problems to the rinse stage.

MILITARY SPECIFICATIONS

- Conforms to
A-A-59267 Type Z
TT-C-490F Type I Class A

METHODS OF USE

- **APPLICATION METHODS**
 - Immersion
 - Flood
- **MIXING INSTRUCTIONS**
 - The phosphating bath is made up by addition of 7.5-12.5 gallons of PPC-49 to each 100 gallons of clean water.
- **APPLICATION INSTRUCTIONS**
 - Immerse the clean part in the PPC-49 bath for 15-30 minutes at 165 – 190F.
 - Paint Base Coating – Immersion time should be restricted to 10-30 minutes. This will produce a 500-1500 mg/sq. ft.
 - Paint Base Coating – Needs to be a lighter coating of 300 to 500 mg/ sq. ft. This will take 3-5 minutes to produce, and will have a smooth tight coating. If the coating is not smooth and tight enough, contact your Crest representative, as a nitrite additive may be needed.
- **ADJUSTMENTS**
 - Water is to be replaced as it evaporates from the bath.
 - Sludge should be removed from the bath every four weeks.
- **EQUIPMENT**
 - Tanks should be constructed of 316 stainless steel. 304 stainless steel or mild steel can be used as well.
 - Heaters may be either steam heated plate coils constructed of stainless steel or gas fired burner tube types constructed of mild steel.

CAUTION

This product contains acidic ingredients. Avoid contact with skin, eyes, and clothing. Refer to product labels and Safety Data Sheets for precautionary and handling information.

Product should be stored at no lower than 50°F and no higher than 100°F.

WARRANTY AND LIABILITY DISCLAIMER

The above information and recommendations concerning this product are based upon our laboratory tests and field use experience; however, since conditions of actual use are beyond our control, any recommendations, or suggestions, are made without warranty, expressed or implied. Manufacturer's and seller's sole obligation shall be to replace that portion of the product shown to be defective. Neither shall be liable for any loss, damage or injury, direct or consequential, arising out of the use of this product.

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