

### NuKoat CMZ: Calcium-modified, immersion applied zinc phosphate coating for steel. This product develops a fine grain coating without the use of a separate accelerator.

#### Description:

NuKoat CMZ is a liquid, calcium-modified, zinc phosphate treatment for steel. This product develops a densely packed, uniformly smooth, fine grained conversion coating. CMZ produces coating weights from 150-500 mg per square foot. Phosphate coatings produced by the NuKoat CMZ process meet the Federal Specification TT-C-490, Type 1. The NuKoat CMZ creates an extra fine grained coating in approximately two to five minutes without adding a separate accelerator.

#### Application:

#### Initial Bath Make-up

Temperature	160-180°F
Time	2 to 5 minutes
Total Acid	30-40 mls
Free Acid	2.5 – 5.0
TA/FA Ratio	8 to 12
Calcium, Zinc	7 to 9 ml
Iron Titration	0 to 11 ml



**Note:** For every ml of iron titrated, increase total acid 0.6 ml over that in a fresh bath.

**Solution Control:** NuKoat CMZ is controlled by Total Acid, please see our Process Instructions.

#### Typical Usage Parameters:

	NuKoat CMZ
Description	Ferrous metal by Immersion
Concentration Range (initial bath make-up)	5% by volume
Operating temperatures	160-180°F
Time (min)	two-five minutes
Ferrous metals	•
Aluminum, zinc, galvanized steel	NA

#### Physical Properties:

	NuKoat CMZ
pH, concentrate	~1.0
pH, @ 5% bv	2.0
Bulk density, #/gal	12.4
VOC	0 g/L
Flash point	None
Chelates	None
Solubility in water	Complete
Biodegradable	No
Silicated	No

**Shipment:** Freight classification: "UN1760 Corrosive Liquid, n.o.s. (Nitric & phosphoric acid mixture), 8, PG III."

**Storage:** Keep from freezing. Store between 40-120°F

**Disposal:** Dispose of in accordance with local, state, and federal regulations. For assistance with disposal contact NuGeneration Technologies at 888-99-NuGen or email: [info@nugentec.com](mailto:info@nugentec.com).