

### NuKoat Ultra Seal 4: Liquid non-chrome, Organometallic polymer final rinse for iron or zinc phosphated metal surfaces. Apply by spray or immersion.

#### Description:

NuKoat Ultra Seal 4 a liquid, Neutral pH, chrome-free, reactive final seal for iron or zinc phosphated conversion coatings. Applied by spray or immersion, NuKoat Ultra Seal 4 reacts with the iron phosphated surface to significantly improve powder/paint adhesion. Improves corrosion protection and salt spray test results. Concentrated this product is run at low operating concentrations.

#### Application:

NuKoat Ultra Seal 4 is applied by either spray or immersion in the final rinse of a Phosphating process. NuKoat Ultra Seal 4 should be run at 0.5 to 1% by volume with water at 70-110°F for 15-seconds to 1-minute depending on the application.

- Improves rust protection and paint adhesion after Iron or Zinc Phosphating.
- Significantly improves salt spray testing results.
- Improves humidity resistance.
- Reacts quickly and predictably.
- Non-foaming – allows for use in unheated spray washers .
- Is free of heavy metals.

#### Typical Usage Parameters:

	NuKoat Ultra Seal 4
Description	Iron & Zinc Phosphate Adhesion Promoter
Concentration Range	0.5 to 1.0% (5 to 10 gallons per 1,000)
Operating Temperatures	70 up to 110°F
Time (min)	As required 15-60 seconds
Spray Pressure	10-15 psi
Aluminum, zinc, galvanized steel	•

#### Physical Properties:

	NuKoat Ultra Seal 4
pH, concentrate	7.0
pH, @ 0.5% bv	6.8-7.5
Bulk density, #/gal	9.0
VOC	0 g/L
Flash point	None
Chelates	None
Solubility in water	Complete
Silicated	No

**Bath Make-up:** Fill the tank up (RO or good quality water). Begin to circulate and add 5-10 gallons of NuKoat Ultra Seal 4 per 1000 gallons of bath. Mix thoroughly and check the pH. pH will match make-up water.

**Bath Replenishment:** It is normally the easiest to maintain bath through “Estimating Drag-out.” Once the bath reaches 200 ppm higher than the “initial charge” dump bath and recharge or bleed bath down 50% of volume and replenish.

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

**Disposal:** Dispose of in accordance with local, state and federal regulations.

**Shipping:** Non-hazardous, non-regulated material.