

WinKote 3390SW

(Zirconium Conversion Coating)

◆ Phosphate-Free ◆ Low Temperature ◆ Short Contact Time (20 – 45 seconds)

◆ Minimal Sludge ◆ Enhances Salt Spray Results

WinKote 3390SW is a phosphate-free zirconium conversion coating with no regulated heavy metals. It is especially formulated for use in the treatment of steel, zinc and aluminum surfaces. It is designed to help reduce energy cost by providing a very effective conversion coating that can be applied successfully at temperatures ranging from 70 to 110°F. These lower temperatures will help lower increasing energy cost when compared to traditional iron phosphate products that run at temperatures ranging from 120 to 180°F. **WinKote 3390SW** provides a microcrystalline surface in the nanometer (10^{-9} m) range and this in a very short contact time of 20 to 45 seconds. Conventional iron phosphate coatings are usually in the micrometer (10^{-6} m) range and it requires at least a 60 to 90 seconds contact time. The “nanocrystals” formed with **WinKote 3390SW** increase the surface area of the substrate thus enhancing paint adhesion, corrosion protection and consequently salt-spray results. Since **WinKote 3390SW** has no phosphate, sludge is reduced to the minimum while waste treatment costs and other effluent issues are greatly diminished. Typical coating weights vary depending on the substrate, application temperatures, and method of application. **WinKote 3390SW** generally operates from 1% to 3% by volume, which is comparable to conventional iron phosphate products. **WinKote 3390SW** should be preceded with a mild pH type cleaner or an alkaline cleaner followed by a thorough rinse.

TYPICAL PROPERTIES

Appearance	Clear Colorless Liquid
Foaming Ability	None
pH of 2% Solution	4.4 – 5.2
Rinsing Ability	Superior
Solubility	Excellent
Specific Gravity	1.04

USING PROCEDURES

For most operations, dilute **WinKote 3390SW** to 1% to 3% and apply at 70 – 110°F. Increasing temperature will facilitate faster conversion coatings. Can be used as a norinse product for steel at lower concentrations. If processing aluminum a rinse is highly recommended. Consult your Win Solutions representative for the optimum operating concentrations.

EQUIPMENT

All equipment, piping and pumps should be constructed of 304 or 316 stainless steel alloys. If mild steel is used in construction, it must be appropriately lined. Chemical feed pump parts made from elastomers can be Buna-N, EPDM, Hypalon, Viton or Teflon. Consult your Win Solutions representative.

MATERIAL SAFETY

WinKote 3390SW is safe to be used as a phosphate-free conversion coating and paint-pretreatment for most metals.

WinKote 3390SW should be stored in a cool dry area. Store away from incompatible substances; see an issued SDS.

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WinKote 3392SW

(Spray Wand Zirconium Conversion Coater)

◆ Works Well In Most Spray Wands

◆ No Foaming

◆ Will Produce Good Coating Weights

◆ Easy To Use Liquid

WinKote 3392SW is a premium formulated coater and paint pre-treatment for most metals. It will produce a tight bonded Zirconium conversion coating on most ferrous and non-ferrous metals. **WinKote 3392SW** will provide excellent coating weights and help increase paint adhesion. Typical dwell times will vary depending on the coating weights being sought. Typical temperatures during application range from ambient to 120 °F.

TYPICAL PROPERTIES

Appearance	Clear Liquid
Foaming Ability	Controlled (low)
Operating pH	3.5 – 5.0
Rinsing	Superior
Solubility	Excellent
Specific Gravity	1.15 (water = 1.0)

USING PROCEDURES

WinKote 3392SW is recommended for use at concentrations between 1% - 2% (b/v) on steel, aluminum and galvanize. If processing steel it can be used as a no rinse. If processing aluminum or galvanize a post rinse is highly recommended.

MATERIAL SAFETY

WinKote 3392SW is safe as a conversion coating and paint-pretreatment for most metals.

STORAGE

WinKote 3392SW is stored in a cool dry area. Store away from incompatible substances; see an issued MSDS.

SAFETY

Please refer to the label and Material Safety Data Sheets for all warnings, recommendations and other regulatory information. Copies of the Material Safety Data Sheets are available from the Win Solutions office or your local representative.

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WinKote 3395 LT

(Conversion Coating)

◆ Cleaner Coater ◆ Low Temperature ◆ Low Phosphate

◆ Enhances Salt Spray Results

WinKote 3395 LT was designed to help reduce energy cost by providing an effective cleaner and low phosphate conversion coating that can be applied successfully at temperatures ranging from 80 to 110 °F. These lower temperatures will help lower increasing energy cost when compared to traditional iron phosphate cleaner coater products that run at temperatures ranging from 130 to 180 °F. Lower phosphate levels will help reduce sludge levels, waste treatment cost and other effluent issues. This product greatly enhances paint adhesion, corrosion protection and salt spray results. **WinKote 3395 LT** is easy to operate and will reject oil very efficiently, allowing for continuous and removal with any oil removing system. **WinKote 3395 LT** is a highly effective cleaner and it prepares ferrous and non-ferrous substrates for painting by converting their surfaces into an amorphous conversion coating. Typical conversion coating weights vary depending on the substrate, application temperatures, and method of application. **WinKote 3395 LT** generally operates from 2 to 4% by volume, which is comparable to conventional iron phosphate products. There is usually no break in time needed with this product.

TYPICAL PROPERTIES

Appearance	Clear Colorless Liquid
Foaming Ability	None
pH of 2% Solution	3.0 – 3.1
Rinsing Ability	Superior
Solubility	Excellent
Specific Gravity	0.98 – 1.04

PROCEDURES FOR USE

For most operations, dilute **WinKote 3395 LT** to 2 to 4 % and apply at 80 – 110° F. Increasing temperature will facilitate faster conversion coatings. Consult your Win Solutions, Inc. representative for the optimum operating concentrations.

MATERIAL SAFETY

WinKote 3395 LT is safe to be used as a low phosphate conversion coating and paint-pretreatment for most metals.

WinKote 3395 LT should be stored in a cool dry area. Store away from incompatible substances; see an issued MSDS.

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WinKote 3398SI

(DIP Zirconium/Polymer Coater/Sealer)

◆ Works Well In Spray Washers & Wands

◆ No Phosphates

◆ Will Produce Good Coating Weights

◆ Easy To Use Liquid

WinKote 3398SI is a premium formulated Dry in Place zirconium/polymer paint and powder pre-treatment for most metals. **WinKote 3398SI** will provide excellent coating weights and help increase paint adhesion as well as corrosion resistance. Typical dwell times will vary depending on the coating weights being sought. Typical temperatures during application range from ambient to 120 °F.

TYPICAL PROPERTIES

Appearance	Clear Liquid
Foaming Ability	No Foam
Operating pH	4.5 – 5.5
Rinsing	Superior
Solubility	Excellent
Specific Gravity	1.03 (water = 1.0)

USING PROCEDURES

WinKote 3398SI is recommended for use at concentrations between 3.0% - 4% in spray washers and 1.5% - 3% in spray wands. 1% - 2% recommended on non-ferrous metals.

MATERIAL SAFETY

WinKote 3398SI is safe as a zirconium/polymer coating and paint-pretreatment for most metals.

STORAGE

WinKote 3398SI is stored in a cool dry area. Store away from incompatible substances; see an issued SDS.

SAFETY

Please refer to the label and Material Safety Data Sheets for all warnings, recommendations and other regulatory information. Copies of the Material Safety Data Sheets are available from the Win Solutions office or your local representative.

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WinKote 2272

CONCENTRATED LIQUID IRON PHOSPHATIZER

- ◆ Works Well in Spray or Immersion
- ◆ Provides higher coating weights
- ◆ Effective On Most Substrates
- ◆ Versatile Usage
- ◆ Easy to Use Liquid
- ◆ No Foam

WinKote 2272 is specifically formulated as a low temperature, iron phosphatizer and paint pre-treatment for most metals. It will produce a tight bonded iron phosphate conversion coating on steel and iron parts while slightly etching zinc, galvanized and aluminum parts. This product gives superior paint adhesion and corrosion protection. **WinKote 2272** is instantly soluble when used in an industrial spray washer or immersion system. Typical dwell times should be from 45 seconds to 90 seconds in spray washers and 3 to 5 minutes in immersion systems. Typical temperature ranges can be from 100°F to 125°F. The pH ranges should be maintained between 3.0 and 5.0 with a pH of 4.0 being optimum. **WinKote 2272** does not contain any cleaning properties. It is designed as an iron phosphatizer only.

MATERIAL SAFETY:

WinKote 2272 is safe as an iron phosphatizer and paint pre-treatment for most metals.

EMPLOYEE SAFETY:

Please read the MSDS before using. **WinKote 2272** should be used only as directed, and at the recommended concentration levels. **KEEP OUT OF THE REACH OF CHILDREN.**

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