

Passivation

Standard Operating Procedure

- 1. Hot Water Rinse (160° - 175°) for 3-5 minutes**
- 2. Mix 1oz:3gal | Liquid Non-Chlorinated Caustic**
 - a. Cycle for 30min.
- 3. Cold Water Rinse**
 - a. Cycle for 5min.
- 4. (Optional) If there are rust spots, 2% Citric Acid for 30min.**
 - a. Water at 120-130°
 - b. Rinse Until pH is Neutral.
- 5. Mix 2oz:1gal Nitric Acid NP50 with (120° - 130°) Water (do not exceed 140°)**
 - a. Cycle for 30min.
- 6. Drain**
 - a. DO NOT RINSE in Between These Cycles!
- 7. Mix 2oz:1gal 1320 UBC with (120° - 140°) Water**
 - a. Cycle for 30min.
 - b. IMMEDIATELY RINSE After Drain - Do Not Let This Dry.
- 8. Rinse well until neutral.**

ALWAYS WEAR PPE EYE-WEAR & GLOVES