

# *Passivation*

## *Standard Operating Procedure*

1. Hot Water Rinse (160° - 175°) for 3-5 minutes
2. Mix 1oz:3gal | Liquid Non-Chlorinated Caustic for 30min.
3. Cold Water Rinse for 5 min.
4. (Opt.) 2% Citric Acid if you see any rust spots for 30min.
  - a. Water at 120-130°
5. (Opt. if Using Citric Acid Cycle) Rinse Until pH is Neutral.
6. Mix 2oz:1gal Nitric Acid NP50 with (120° - 130°) Water (do not exceed 140°) for 30min.
7. Drain and do not Rinse in Between these cycles!
8. Mix 2oz:1gal 1320 UBC with (120° - 140°) Water for 30min.
9. Rinse well until neutral.

**ALWAYS WEAR PPE EYE-WEAR & GLOVES**