SOL-KOAT 690
In-Process Water Soluble Corrosion Preventative

SOL-KOAT 690 is water dilutable soluble oil based emulsion intended for use as an in-process rust preventative that can be applied to dry or wet parts by immersion, spray, or flood. This product is designed for use on all metals and leaves a very light and almost imperceptible film. SOL-KOAT 690 is designed as an in-process corrosion preventive for indoor storage protection.

Typical Characteristics
- Appearance of Concentrate: Clear, amber liquid
- Appearance of Emulsion: White
- Density: 7.59 lbs./gal
- Film Type: Thin oily
- pH (5%DI): 9.6-10.0
- Specific Gravity: 0.899-0.919
- Barium, Diethanolamine, Nitrites, Phenols: None

Recommended Dilutions
Emulsion products such as SOL-KOAT 690 work best if they can be mixed at room temperature and by adding the concentrate to the water; NEVER THE REVERSE. The use of DI water or softened water for make-up will improve bath life. Using premixed material as makeup will improve performance and help to maintain bath life. The recommended operating concentration is 5-10% depending on the length of protection needed. The product is designed to give 12 months indoor storage protection if used at 10%. SOL-KOAT 690 can be heated to facilitate drying.

Concentration Control
The chart below was prepared using a Atago Master M refractometer and dilutions of SOL-KOAT 690 in distilled water. Refractometer readings can vary with the type of water and refractometer used. Atago M refractometers are available from QualiChem, Inc.

<table>
<thead>
<tr>
<th>CONCENTRATION %:</th>
<th>3</th>
<th>4</th>
<th>5</th>
<th>7</th>
<th>10</th>
<th>12</th>
<th>15</th>
</tr>
</thead>
<tbody>
<tr>
<td>REFRACTOMETER READING:</td>
<td>3.2</td>
<td>4.3</td>
<td>5.3</td>
<td>7.4</td>
<td>10.6</td>
<td>12.8</td>
<td>15.9</td>
</tr>
</tbody>
</table>

Packaging
SOL-KOAT 690 is packaged in 310-gallon, one-way tote tanks and 55-gallon, non-returnable steel drums. Bulk and 5-gallon pails are also available.