

Description

The present invention relates to a method for non-electrolytically forming a protective coating film on the surface of the elements of a slide fastener chain made of aluminum or aluminum-based alloy and fastened to a fabric-made fastener tape along a periphery thereof.

As is well known, shaped articles of metallic aluminum or an aluminum-based alloy (hereinafter referred to merely as aluminum) are rarely used as shaped but used after being provided with a surface film with objects not only to enhance the mechanical and chemical resistance but also to improve beautifulness. Such a protecting surface film on aluminum shaped articles is obtained either by an electrolytic method of anodization or by a non-electrolytic method of chemical conversion by use of certain chemicals. These methods have their own advantages and disadvantages. For example, an aluminum shaped article provided with a protective surface film by the anodization is very excellently resistant against corrosion so that surface treatment of most of aluminum-made building materials such as wall panels and window sashes is performed by this electrolytic method. A disadvantage of the anodization method is, on the other hand, the relatively poor fastness of color when the surface-anodized aluminum article is subjected to coloring to increase beautifulness in addition to the high costs required for the expensive electrolytic facilities.

The method of chemical conversion coating is preferred because, despite the outstanding simplicity and low costs of the treatment process owing to the absence of the complicated electrolytic treatment in the expensive facilities, the surface film obtained by the method is sufficiently corrosion-resistant and remarkably beautiful although the anti-abrasion resistance of the surface film formed by the method is somewhat inferior to that obtained by the anodization. When the aluminum article is finished by providing an overcoating with a coating composition, e.g. paints and varnishes, poor anti-abrasion resistance is less significant so that the chemical conversion method is widely practiced as a method of pre-treatment for the overcoating.

DE-AS-1 621 491 discloses a method for non-electrolytically forming a protective coating film on the surface of an article made of aluminum or an aluminum-based alloy which comprises the steps of:

(a) cleaning and degreasing the surface of the article with a cleaning solution,

(b) rinsing the thus cleaned and degreased article by use of rinse water to remove the cleaning solution and scums formed by the degreasing,

(c) bringing the article into contact with a treatment solution capable of forming a chemical conversion coating film on the surface of the article,

(d) spraying a rinse water under pressurization

onto the article to remove the treatment solution, said spraying being performed with water of 20 to 40°C for 5 to 20 sec. and repeated with water of 60 to 90°C for 5 to 20 sec.

This prior art method is not however applicable to slide fastener chains integrally having both of the aluminum-made coupling elements and the fabric-made fastener tape.

The invention therefore aims at improving this prior art method in a manner to be adapted to form a protective surface film on aluminum made fastener elements already fastened to a fabric made fastener tape.

A method satisfying this requirement is stated in the appended claim.

After the step of removing the treatment solution by rinsing with water the slide fastener chain must be dehydrated as completely as possible before being subjected to the next step of heat treatment. This removal of the wetting water is carried out with suction at the reverse side of the fastener tape to that at which the wash water has been sprayed so as to further increase completeness of removal of the treatment solution and the efficiency of the dehydration. This step is very essential since direct heating of the aluminum article as wetted with water on the surface of the protective surface film formed in the chemical conversion treatment may adversely affect the surface film still in a fragile condition with poor adhesion to the aluminum base along with boiling of the water drop on the surface resulting in local damage to the coating film to give an unsatisfactory product with unevenly protected surface.

The last step in the inventive method is the heat treatment of the slide fastener chain. This treatment is important in order to improve the adhesion of the chemical conversion coating film to the surface of the coupling elements as well as to enhance the stability of the coating film. The heat treatment is carried out at a temperature in the range from 90 to 150°C for a length of time from 3 to 9 minutes in a hot-air oven or under infrared lamps. When the temperature is lower than 90°C, no sufficient improvement is obtained in the adhesion of the coating film to the surface of the coupling elements resulting in eventual exfoliation of the coating film off the coupling elements, while the surface luster of the conversion coating film is greatly reduced by a heat treatment at a temperature higher than 150°C.

In accordance with the inventive method, the coupling elements can be provided with a very durable protective surface film on the surface in a very simple and convenient progress and unexpectedly satisfactory results are obtained in that the thus formed conversion coating film is bonded to the surface of the coupling elements with very strong adhesion and imparted with excellent light resistance by the combination of the above-described steps of removal of the extraneous treatment solution from the surface thereof and heat treatment.

Following is an example to illustrate the method of the present invention in further detail.

A slide fastener stringer having coupling elements shaped by extruding an A-5056W aluminum alloy fastened to a fabric-made fastener tape was dipped in a detergent solution and complete degreasing was carried out with the cooperative effect of ultrasonic waves generated by the ultrasonic generator installed in the vessel. The thus degreased slide fastener stringer was rinsed with water and dehydrated with suction.

The chemical conversion treatment of the thus cleaned coupling elements of the slide fastener stringer was performed by use of an aqueous solution containing 60 g/liter of Bonderite BT713M (a trade name by Nippon Parkerizing Co.) to give a treatment solution containing 0.1% by weight of hydrogen fluoride, 0.25% by weight of chromic anhydride, 0.25% by weight of bichromic acid and 0.25% by weight of nitric acid, in which the slide fastener stringer was dipped for 6 minutes at 50°C. The treatment solution was agitated throughout the treatment time by aeration.

After completion of the chemical conversion treatment, the slide fastener stringer was taken out of the solution, rinsed completely with water,

dehydrated with suction and heated in a hot-air oven at 120°C for 6 minutes.

The thus finished coupling elements had a conversion coating film of about 0.3 μ m thickness on the surface colored in beautiful golden yellow. This aluminum product was subjected to the tests of boiling in water, resistance against sea water and light resistance according to the procedures specified in Japanese Industrial Standard L 0842 to give the results shown in Table 1 below. Table 1 also includes the results obtained with the same aluminum coupling elements finished by use of a paint or by the anodization treatment. The numerical values in the table indicate the proportion in % of the areas with faded color to the total surface area of the coupling elements.

As is clear from the results shown in the table, the inventive method was as effective as the anodization treatment in respect of the boiling test and the sea-water test and much higher light resistance was obtained than in the paint coating and anodization.

Meanwhile, coloring may be controlled by the adjustment of the concentration of the treatment solution as well as the temperature and time of the treatment even by the use of the same type of the solution.

TABLE 1
Present
invention

Protective treatment		Coating with paint	Anodization
Boiling test	60 minutes	0	0
	120 minutes	5	0
Sea water test	3 days	0	0
	5 days	0	0
Light resistance	20 hours	50	40
	60 hours	80	100

For example, the golden yellow tone of coloring is best when the conversion treatment is performed with a solution containing 4 to 8% of Bonderite 713M at 40 to 60°C for 4 to 8 minutes.

When a plurality of slide fastener chains are subjected to the process of chemical conversion coating as described above, the treatment is preferably undertaken in two steps as is mentioned before with an intervening step of tension control therebetween. As is usually the case, the chemical conversion treatment of slide fastener chains is performed simultaneously in multiple lines for which more or less unbalanced tension is always unavoidable among the lines causing undesirable unevenness in the bias and lengths of the individual fastener chains. The step of tension control succeeding the first chemical conversion treatment can give a means for controlling the travelling velocity of each of the fastener chains so that uniformity in the quality of the finished products is ensured.

Claim

A method for non-electrolytically forming a protective coating film on the surface of the elements of a slide fastener chain made of aluminum or an aluminum-based alloy and fastened to a fabric-made fastener tape along a periphery thereof which comprises the steps of:

(a) cleaning and degreasing the surface of the elements of the slide fastener chain with a cleaning solution;

(b) rinsing the slide fastener chain with the thus cleaned and degreased elements by use of rinse water to remove the cleaning solution and scums formed by the degreasing;

(c) removing the rinse water from the slide fastener chain by suction;

(d) bringing the slide fastener chain into contact with a treatment solution capable of forming a chemical conversion coating film on the surface of the elements;

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(a) cleaning and degreasing the surface of the elements of the slide fastener chain with a cleaning solution;

(b) rinsing the slide fastener chain with the thus cleaned and degreased elements by use of rinse water to remove the cleaning solution and scums formed by the degreasing;

(c) removing the rinse water from the slide fastener chain by suction;

(d) bringing the slide fastener chain into contact with a treatment solution capable of forming a chemical conversion coating film on the surface of the elements;



(e) spraying a rinse water under pressurization at the slide fastener chain from a side thereof to rinse out the treatment solution adhering to the slide fastener chain;

(f) removing the rinse water adhering to the slide fastener chain by suction from the side reverse to the side at which the rinse water is sprayed; and

(g) heating the slide fastener at a temperature in the range from 90 to 150°C for 3 to 9 minutes.

Patentanspruch

Verfahren zur nichtelektrolytischen Erzeugung einer Schutzschicht auf der Oberfläche der Elemente einer Reißverschlußkette, die aus Aluminium oder einer Aluminiumlegierung hergestellt und am Rand eines Textil-Tragbandes befestigt sind, bestehend aus folgenden Arbeitsschritten:

a) Reinigen und Entfetten der Oberfläche der Elemente der Reißverschlußkette mit einer Reinigungslösung;

b) Spülen der Reißverschlußkette mit den auf diese Weise gereinigten und entfetteten Elementen mit Spülwasser, um die Reinigungslösung und den durch die Entfettung gebildeten Schaum zu entfernen;

c) Entfernen des Spülwassers von der Reißverschlußkette durch Absaugen;

d) in Berührung bringen der Reißverschlußkette mit einer Behandlungslösung, die auf der Oberfläche der Elemente eine Schutzschicht durch chemische Umwandlung erzeugen kann;

e) Aufsprühen von Spülwasser mit Druck auf die Reißverschlußkette von einer Seite derselben, um die an der Reißverschlußkette anhaftende Behandlungslösung abzuspielen;

f) Beseitigen des an der Reißverschlußkette anhaftenden Spülwassers durch Absaugen von derjenigen Seite, die der Seite gegenüberliegt, auf die das Spülwasser aufgesprüht wurde; und

g) Erhitzen der Reißverschlußkette bei einer Temperatur im Bereich von 90 bis 150°C für 3 bis 9 Minuten.

Revendication

Procédé pour former de façon non-électrolytique une pellicule de revêtement protectrice sur la surface des éléments d'une chaîne de fermeture à glissière en aluminium ou en alliage d'aluminium fixés à un ruban en tissu le long d'une périphérie de ce dernier, comprenant les phases consistant:

(a) à nettoyer et dégraisser la surface des éléments de la chaîne de fermeture à glissière avec une solution de nettoyage;

(b) à rincer la chaîne de fermeture à glissière avec les éléments ainsi nettoyés et dégraissés en utilisant une eau de rinçage pour éliminer la solution de nettoyage et l'écume formée par le dégraissage;

(c) à éliminer l'eau de rinçage de la chaîne de fermeture à glissière par aspiration;

(d) à mettre en contact la chaîne de fermeture à glissière avec une solution de traitement capable de former sur la surface des éléments une pellicule de revêtement par transformation chimique;

(e) à pulvériser une eau de rinçage sous pression sur une des faces de la chaîne de fermeture à glissière pour éliminer par rinçage la solution de traitement adhérent à la chaîne de fermeture à glissière;

(f) à éliminer l'eau de rinçage adhérent à la chaîne de fermeture à glissière en appliquant une aspiration sur la face se trouvant à l'opposé de la face sur laquelle l'eau de rinçage a été pulvérisée; et

(g) à chauffer la chaîne de fermeture à glissière à une température comprise entre 90 et 150°C pendant 3 à 9 minutes.

