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PHOS-PREP®

Experts in non Chrome Preparations

TECHNICAL DATA SHEET

PHOS-PREP® PP938 ALUMINIUM NON ETCH CLEANER

APPLICATION

To produce a uniformly etched surface on aluminium for anodising or powder coating, it is necessary to effectively clean the work surface. The cleaning process is required to remove magnesium oxide films, cutting oils, finger marks, inks, etc; as by inhibiting the etch reaction they can produce patchy, masked and coarse surfaces.

PHOS-PREP® PP 938 powder cleaner is our strongest alkaline cleaner that consequently will etch the surface of aluminium when operated at high temperatures.

PLANT AND EQUIPMENT

The process tank and associated pipe work may be constructed from mild steel or stainless steel.

Bath heating equipment is required and air agitation of the bath is strongly recommended.

OPERATION

The PHOS-PREP® PP 938 cleaner bath has quite a wide range of operation of between 35^{0}C to 65^{0}C, with a concentration of 15 to 60 g/l and is dependent on the time of processing and the degree of cleaning required.
For most applications requiring an immersion time of about 5 minutes, a concentration of 25 g/l at a temperature of 50^{0}C has been found suitable. For heavier duty cleaning concentrations up to 60 g/l PHOS-PREP® PP 938, with immersion times up to 15 minutes and at temperatures of the order of 65^{0}C are used.

Air agitation of the bath should be used to improve cleaning efficiency, where the bath strength and/or temperature may be increased to compensate for poor agitation.

For this reason it is important that bath concentration control is maintained by periodically testing the process solution.

LABORATORY CONTROL

Take a 50-ml bath sample in a titration flask add about 50-ml of water and Bromophenol Blue indicator. Titrate with 1.0M Hydrochloric acid to a green end point, (the blue colour changing through blue/green to a pale green).

Titre x 3 = g/l PHOS-PREP® PP 938

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