

PMD (UK) LTD PROCESS DATA

505-05/02

ISSUE 6

PREV 5

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PMD CLEANER 505

INTRODUCTION

PMD Cleaner 505 is a non-etch cleaner ideal for all cleaning applications where no attack on the base metal can be tolerated. The carefully balanced formulation ensures complete removal of shop soils and light buffing compounds prior to further processing.

PMD Cleaner 505 is especially recommended for cleaning polished surfaces of aluminium prior to anodising and conversion coating. Other uses are cleaning non-ferrous metals, including gold, silver, brass and copper. It may also be used to clean steel for certain applications.

BENEFITS

Non-etch chemistry to protect sensitive metals.

High detergency helps soil removal and prevents re-contamination.

Free rinsing surfactants help prevent staining.

Dual purpose - soak and electrolytic enabling one tank to be used for simple cleaning cycles.

Economical - long life and effective cleaning

Versatile - can be used on aluminium, gold, silver, brass, copper, and ferrous metals.

SOLUTION MAKE-UP

PMD Cleaner 505

35 - 100 g/l

Optimum 50 g/l

OPERATING DATA

Temperature

50 - 90 °C

Time

30 seconds - 5 minutes

Agitation

Recommended on soak cleaning

Voltage

Cathodic

6-8 Volts

Anodic

4 Volts

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EQUIPMENT

Tanks	Mild steel, Polypropylene, unplasticised PVC
Heaters	PTFE, stainless steel or mild steel all with thermostatic control

INSTALLATION

Equipment to be used for PMD Cleaner 505 should be cleaned thoroughly before any product is added.

If in any doubt as to the cleaning procedure contact PMD (UK) Limited Technical Department.

1. Half fill the equipment with the appropriate amount of clean water.
2. Whilst stirring, add the correct amount of PMD Cleaner 505. Continue stirring until dissolved.
3. Make up to the operating level with clean water. Mix well
4. Heat to operating temperature.

PROCESS SEQUENCE

The operating parameters of PMD Cleaner 505 can be adapted to suit specific requirements. The following is given as a guide. If in any doubt as to the correct process sequence, contact PMD (UK) Limited Technical Department .

1. Degrease
2. Soak clean, PMD Cleaner 505, or, Electrolytic clean, PMD Cleaner 505
3. Rinse
4. Continue depending on application.

MAINTENANCE AND CONTROL

The solution should be regularly analysed and replenished as necessary.

Evaporation losses should be replaced using water.

Concentration losses should be replaced with PMD Cleaner 505.

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ANALYSIS METHOD

Reagents

1.0N Hydrochloric acid.
Methyl red indicator.

Method

1. Pipette 25.0 ml of working solution into a 250 ml conical flask.
2. Add approximately 50 ml deionised water and mix thoroughly.
3. Add 2-3 drops of Methyl red indicator.
4. Titrate with 1.0N Hydrochloric acid to an orange/ red end point.
5. Record titre = t mls.

Calculation

$t \times 3.22 = \text{g/l PMD Cleaner 505.}$

DISPOSAL

Dispose of in accordance with local authority requirements.

PRODUCT FAMILIES

The following products or product families are referred to in this data sheet.

<u>Product Name</u>	<u>Product Number</u>
PMD Cleaner 505	206001

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