

PMD (UK) LTD PROCESS DATA

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PMD CLEANER 606

INTRODUCTION

PMD Cleaner 606 is a highly effective, economical, soak/electrolytic cleaner which will rapidly remove soils from many types of surface without attack on the base metal. PMD Cleaner 606 will quickly remove soils such as oils, greases, heavy machine oils, light polishing compositions lanolin greases and swarf.

PMD Cleaner 606 is also extremely effective as an etch process for aluminium prior to chromate conversion.

BENEFITS

Will remove difficult soils.

High detergency, aids cleaning and prevents re-contamination

Free rinsing surfactants help prevent staining.

Dual purpose - soak and electrolytic capability enables a single tank to be used for both processes.

Versatile, effective on a wide range of materials

Economical, effective cleaning over a long life

SOLUTION MAKE-UP

PMD Cleaner 606

35-75g/L

Optimum 50g/L

OPERATING DATA

Temperature	20 - 60° C
Time	30 seconds - 5 minutes
Current Density	30 - 45 ASF (3.0 - 4.5 A/dm ²)
Voltage Cathodic	6 - 8 Volts
Anodic	4 Volts

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EQUIPMENT

Tanks	Stainless steel, Polypropylene, Polyethylene, Unplasticised PVC, Titanium
Heaters	Teflon coated, PTFE or Titanium with thermostatic control.

INSTALLATION

Equipment to be used for PMD 606 Cleaner 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 clean water.
2. Add, with constant stirring, the required amount of PMD Cleaner 606
3. Continue stirring until all solids have dissolved.
4. Make up to correct volume with clean water.
5. Mix well and heat to operating temperature.

Note: The temperature of the solution will rise as PMD Cleaner 606 dissolves.

PROCESS SEQUENCE

The following are typical process sequences which have been shown to give excellent results. If in any doubt as to the correct process sequence, contact PMD (UK) Limited Technical Department.

Mild Steel

1. Soak Clean, PMD Cleaner 606
2. Anodic Clean, PMD Cleaner 606
3. Rinse
4. 50% Hydrochloric Acid Dip
5. Rinse
6. Rinse
7. Anodic Clean, PMD Cleaner 606
8. 10% Sulphuric Acid Dip
9. Rinse
10. Electroplate

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Brass and Copper

1. Cathodic Clean, PMD Cleaner 606
2. Anodic Flash Clean, if required, in station 1.
3. Rinse
4. Rinse
5. PMD Econovate
6. Rinse
7. Electroplate

Leaded Brass

1. Soak Clean, PMD Cleaner 606
2. Cathodic Clean, PMD Cleaner 606
3. Anodic Flash Clean, if required, in station 2
4. Rinse
5. Rinse
6. PMD Econovate
7. Rinse
8. Electroplate

Aluminium

PMD Cleaner 606 is extremely effective as an etch for aluminium prior to chromate conversion using PMD Alchromate.

MAINTENANCE AND CONTROL

The solution should be regularly analysed and replenished as necessary.

Evaporation losses should be replaced by using water.
Concentration losses should be replaced with PMD Cleaner 606.

The solution should be discarded and a fresh one made up when the solution is so loaded with absorbed soils that replenishment does not regain performance.

ANALYSIS METHOD

Reagents

1.0N Sulphuric Acid
Methyl Orange Indicator.

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Method

1. Pipette a 10.0ml sample of the working solution into a 250ml conical flask.
2. Add approximately 50ml of deionised water and mix well.
3. Add 2-3 drops of Methyl Orange Indicator. Mix well.
4. Titrate with 1.0N Sulphuric Acid to an orange/red end point.
5. Record Titre = t mls.

Calculation

$t \times 5.43 = \text{g/L PMD Cleaner 606.}$

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 606	206003
PMD Econovate	223001
PMD Alchromate	237003

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