

# PMD (UK) LTD PROCESS DATA

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**FERRAVEL-06/02**

**ISSUE 5**

**PREV 4**

# PMD FERRAVEL

## INTRODUCTION

PMD Ferravel is an extremely effective immersion process for removing small burrs left on mild steel parts after pressing or machining, and for brightening the metal surface before subsequent electroplating.

## SOLUTION MAKE-UP

PMD Ferravel A	50g/l
PMD Ferravel B	200ml/L

## OPERATING DATA

Temperature	20 - 40 deg C
Time	2 - 5 minutes
Extraction	Recommended

## EQUIPMENT

Tanks	Polypropylene, Polyethylene, Unplasticised PVC.
Heaters	Teflon coated, PTFE with thermostatic control.

If in any doubt as to the compatibility of equipment contact PMD (UK) Limited Technical Department.

## INSTALLATION

It is essential that the equipment to be used for PMD Ferravel is thoroughly cleaned before any product is added.

1. Half fill the equipment with the required volume of water.
2. Dissolve the correct amount of Ferravel A in the water.
3. Slowly and with continuous stirring, add the required volume of Ferravel B.
4. Make up to the required volume with water and mix thoroughly.
5. Heat to operating temperature.

**FERRAVEL-06/02**

**ISSUE 5**

Page 1 of 2

## **PROCESS SEQUENCE**

1. Clean parts as necessary.
2. PMD Ferravel.
3. Rinse.
4. Continue dependent upon application.

## **MAINTENANCE AND CONTROL**

The solution is not normally maintained by analysis, but used until exhausted and replaced.

A white viscous film forms on the surface of the work and gas is vigorously evolved from the solution.

As the solution ages, this action slows down and eventually ceases.

It is possible to regenerate the solution for an indefinite period by making a 50ml/L addition of Ferravel B as required.

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## **DISPOSAL**

Dispose of in accordance with local authority requirements.

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## **PRODUCT FAMILIES**

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

<u>Product Name</u>	<u>Product Number</u>
PMD Ferravel A	223002
PMD Ferravel B	227004

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