

riag Act 655

Activation of zinc die-cast, aluminium, copper and steel

riag Act 655 is a multi-purpose dry acid. It is used for pickling, neutralisation and activation of metals like iron, steel, brass, copper, nickel, aluminium as well as zinc die-cast. The **riag Act 655** is water-soluble and contains in addition cleaning and wetting substances. **riag Act 655** is particularly suitable for the activation of plumbiferous nonferrous metals. After the treatment in **riag Act 655** the pieces present a light, clean surface.

Make up of 100 Litres

Activation of zinc die-cast

(working at room temperature)

riag Act 655 Salt

Standard value

0.5 – 3 kg

Activation of steel and brass

riag Act 655 Salt

Standard value

5 kg

Make-up

The tank is filled at $\frac{2}{3}$ with DI-water and heat to approx. 30 °C. Add the calculated amount of **riag Act 655 Salt** and stir until the salt is dissolved. Finally add DI-water until the working level has been reached.

Operating Parameters

Temperature	20 – 40 °C
Treating time	Depending on material (mainly 30 – 180 seconds)
Agitation	Recommended (shorter treating time)
Tanks	Plastic or lined steel
Heating	Immersion heaters, but thermostatic control is essential.
Fume extraction	Recommended

Maintenance

riag Act 655 should be analysed and corrected regularly. As soon as the desired effect weakens, the electrolyte is replenished with 20 % of the Make-up quantity.

Environmental Considerations

All concentrates, rinse waters and waste solution must be treated and discharged in accordance with local effluent control regulations.

Further information can be gleaned from the MSDS.

Liability

This instruction manual was compiled with reference to the state of the art and all current standards, and is based on the long-term knowledge and experience of riag. However, riag cannot monitor compliance with this instruction manual and the methods described herein at the customer/end-user's premises. Work carried out with riag products must be adapted accordingly to meet local conditions. In particular, riag cannot accept liability for damage, loss or cost incurred due to a failure to adhere to this instruction manual, improper application of the methods, unauthorised technical modifications, insufficient maintenance or the absence of maintenance in respect of the requisite technical hardware or equipment, or in the event of use by unqualified personnel. riag is not liable for damage or loss caused by riag or its employees except where intention or gross negligence can be proved. riag furthermore reserves the right to make changes in relation to products, methods and the instruction manual without prior notice.

Our goods and services are subject to the General Terms and Conditions for Delivery of the Association of Surface Technology Suppliers (VLO), which can be viewed at www.riag.ch (link "terms and conditions", document "General Terms and Conditions for Delivery", version 3/2018), which we gladly send you on request.

This transaction is governed by material Swiss law (Law of Obligations), excluding private international law (conflict of laws) and intergovernmental treaties, specifically the CISG.

riag Oberflächentechnik AG
Murgstrasse 19a
CH-9545 Wängi
T +41 (0)52 369 70 70
F +41 (0)52 369 70 79
riag.ch
info@riag.ch

Analysis (Analytical methods)

Sample preparation:

The sample must be taken from a well-mixed point and allowed to cool down to 25 °C.

Reagents: Sodium hydroxide solution 1 mol/L
Toluylene red, 0.1 % in water

Procedure: 50 mL bath are transferred via pipette into a
100 mL beaker, add
3 drops toluylene red
Titrate with
Sodium hydroxide solution 1 mol/L from pink to light-yellow

Calculation: **riag Act 655 Salt** (g/L) = consumption of mL NaOH x 3.0