

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

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 bath 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

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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
Tropaeolin 000 No.1 (orange 1), 0.1 % in water

Procedure:

50 mL bath are transferred via pipette into a

100 mL beaker, add

10 drops Tropaeolin 000 No.1

Titrate with
Sodium hydroxide solution 1 mol/L from yellow to red

Calculation:

RIAG Act 655 Salt (g/L) = consumption of mL NaOH x 3.0