

RIAG Clean 611

All-purpose degreasing process

RIAG Clean 611 is an alkaline degreasing process for iron and nonferrous metals.

Properties

- Suitable for iron, steel, brass, copper, magnesium or aluminium
- Alkaline powder
- Emulsifying

Ingredients

- Silicates
- Carbonates
- Phosphates
- Nonionic surfactants
- Salts of organic acids

Make up of 100 Litres

	ultrasonic	soak	spray
RIAG Clean 611 Salt	1 – 3 kg	2 – 5 kg	0.5 – 1 kg
Temperature	40 – 70 °C	60 – 80 °C	70 – 90 °C
Time	1 – 5 min.	1 – 10 min.	
Density (20 °C)			Standard value
RIAG Clean 611 Salt	20 g/L		1.013 g/cm ³
RIAG Clean 611 Salt	50 g/L		1.035 g/cm ³

Make up

The tank is filled to $\frac{2}{3}$ with water and heated to approx. 40 °C. Add the calculated amount of **RIAG Clean 611 Salt** and stir until the salt is dissolved. Adjust the required amount water up to the working level. Once the cleaner has reached its working temperature, it is ready for use.

Operating parameters

Agitation	Recommended (shorter treating time), as it supports the cleaning process
Tanks	Plastic or lined steel, when using ultrasonic high alloy steel
Heating	Immersion heaters, but thermostatic control is essential
Fume extraction	Recommended
Water	Tap water may be taken for the makeup, however the use of low calcium or DI water is recommended.

Maintenance

RIAG Clean 611 is used with different concentrations, due to the various possibilities of application. The concentration has to be checked after each make up by analysis or density to stay in the desired working range.

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. Chemicals may not be stored below 10 °C:

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Analysis (Analytical methods)

Sample preparation:

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

Reagents: Hydrochloric acid 1 mol/L
 Methyl orange solution 0.1 % in water

Procedure: 50 mL **RIAG Clean 611** are transferred via pipette into a
 250 mL beaker, add
 100 mL deion. water, add
 5 drops Methyl orange solution

Titrate with hydrochloric acid 1 mol/L from yellow to red

Calculation: **RIAG Clean 611 Salt** (g/L) = use of HCl in mL x 2.06

If the degreasing process doesn't work properly, even though the concentration is within the desired range, a new makeup is necessary.

Attention:

Chemicals not intended to be added to the process may disturb and influence the quality of the processed surfaces.