

RIAG Clean 640

Electrolytic degreasing process

RIAG Clean 640 is an alkaline electrolytic degreasing process for iron and nonferrous metals.

Properties

- Suitable for iron, steel, brass, copper or zinc die-cast
- Highly alkaline powder
- High conductivity
- Contains no detergents

Ingredients

- Silicates
- Carbonates
- Sodium hydroxide

Make up of 100 Litres

RIAG Clean 640 Salt

RIAG Cleaner 669
Emulsifier *

Temperature

Time

* optional

Electrolytic degreasing

6 – 8 kg

0.2 – 0.6 L

20 – 40 °C

1 – 10 min.

Density (20 °C)

RIAG Clean 640 Salt 60 g/L

RIAG Clean 640 Salt 80 g/L

Standard value

1.058 g/cm³

1.075 g/cm³

Make up

The tank is filled to $\frac{2}{3}$ with water and heated to approx. 30 °C. Add the calculated amount of **RIAG Clean 640 Salt** and stir until the salt is dissolved. Finally add water until the working level has been reached. 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 640 should be analysed and corrected regularly.

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.

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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: 25 mL **RIAG Clean 640** are transferred via pipette into a
250 mL beaker, add
100 mL deion. water, add
10 drops Methyl orange solution
Titrate with Hydrochloric acid 1 mol/L from yellow to red

Calculation: **RIAG Clean 640 Salt** (g/L) = use of HCl in mL x 2.13

Adding 1.2 g/L **RIAG Clean 640 Salt** will increase the density 0.001 g/cm³.

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.