



CLEANER 606LF

soak/electrolytic/spray cleaner

INTRODUCTION

Cleaner 606 LF is a highly effective, economical, low foaming, soak/electrolytic/spray cleaner which will rapidly remove soils from many types of surface without attack on the base metal. Cleaner 606 LF will quickly remove soils such as oils, greases, heavy machine oils, light polishing compositions, lanolin greases and swarf.

BENEFITS

- Will remove difficult soils.
- Low foam.
- Dual purpose - soak and electrolytic capability enables a single tank to be used for both processes.
- Versatile, effective on a wide range of materials.
- Economical, effective cleaning over a long life.

SOLUTION MAKE -UP

Cleaner 606 LF

35-75g/L

OPERATING DATA

Concentration	35 – 75g/L Optimum 50g/L
Temperature	20 – 60°C
Time	30 seconds – 5 minutes
Current Density	30 - 45 ASF (3.0 - 4.5 A/dm ²)
Voltage Cathodic	6 – 8 Volts
Anodic	4 Volts



EQUIPMENT

Tanks	Stainless steel, polypropylene, polyethylene, unplasticised PVC, titanium
Heaters	Teflon coated, PTFE or titanium with thermostatic control.

INSTALLATION

Equipment to be used for Cleaner 606 LF should be cleaned thoroughly before any product is added.

If in any doubt as to the cleaning procedure contact PMD Technical Department.

1. Half fill the equipment with clean water.
2. Add, with constant stirring, the required amount of Cleaner 606 LF.
3. Continue stirring until all solids have dissolved.
4. Make up to correct volume with clean water.
5. Mix well and heat to operating temperature.

Note: The temperature of the solution will rise as Cleaner 606 LF dissolves

PROCESS SEQUENCE

The following are typical process sequences which have been shown to give excellent results. If in any doubt as to the correct process sequence, contact PMD Technical Department

Mild Steel

1. Soak Clean, Cleaner 606 LF
2. Anodic Clean, Cleaner 606 LF
3. Rinse.
4. 50% hydrochloric acid dip.
5. Rinse,
6. Rinse.
7. Anodic clean, Cleaner 606 LF.
8. Rinse
9. 10% sulphuric acid dip.
10. Rinse.
11. Nickel Electroplate.



Brass and Copper

1. Soak clean, Cleaner 606 LF
2. Cathodic clean, Cleaner 606 LF
3. Anodic flash clean, if required, in station 1
4. Rinse
5. Rinse
6. Econovate Dry Acid Salts
7. Rinse
8. Electroplate

Leaded Brass

1. Soak clean, Cleaner 606 LF
2. Cathodic clean, Cleaner 606 LF
3. Anodic flash clean, if required, in station 2
4. Rinse
5. Rinse
6. Econovate Dry Acid Salts
7. Rinse
8. Electroplate

MAINTENANCE AND CONTROL

The solution should be regularly analysed and replenished as necessary.

Evaporation losses should be replaced by using water.

Concentration losses should be replaced with Cleaner 606 LF.

The solution should be discarded and a fresh one made up when the solution is so loaded with absorbed soils that replenishment does not regain performance.



ANALYSIS METHOD

Reagents

1.0N sulphuric acid

Methyl orange indicator.

Method

1. Pipette a 10.0ml sample of the working solution into a 250ml conical flask.
2. Add approximately 50ml of deionised water and mix well.
3. Add 2-3 drops of methyl orange indicator. Mix well.
4. Titrate with 1.0N sulphuric acid to an orange/red end point.
5. Record Titre = t mls.

Calculation

$t \times 5.43 = \text{g/L Cleaner 606 LF.}$

DISPOSAL

Dispose of in accordance with local authority requirements.

PRODUCT FAMILIES

The following products are referred to in this data sheet.

PRODUCT NAME	PRODUCT NUMBER
Cleaner 606 LF	206002
Econovate Dry Acid Salts	223001

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