



ABSTRIP 63A (T1)

INTRODUCTION

An alkaline liquid used by dip to remove stove cured paints and powder coatings from both components and jigs.

BENEFITS

- Faster processing - can be used at high temperatures.
- Contains no halogenated hydrocarbons.
- Most paint and powder coatings removed as a readily handleable sludge.
- Water miscible - allowing easy rinsing of the bath and paint residues.

TYPICAL PROCESS SEQUENCE

1. Immerse the work in baskets or on jigs in the tank at room temperature for as long as necessary. As a guide:

(i)	Under 300 microns	30 –60 mins.
(ii)	Above 300 microns	Typically 2 – 6 Hours.
2. Rinse with clean cold water (see RINSING below).
3. Dry off (see DRYING below).

NOTES:

- (i) Temperatures up to 90°C may be routinely used, but specific guidance on operational and safety aspects should be sought before using a hotter bath.
- (ii) Longer process times may be required for properly pre-treated surfaces and for coatings with noteworthy chemical resistance properties, e.g. epoxy powder coatings.

BATH MAKE-UP

For each 1000 litres of bath. Add 200 litres of ABSTRIP 63A(T1) and 500 litres of 32% caustic soda liquor and top up to 1000 litres with water.



The stripper tank should be designed so that it can accommodate the largest work with a clearance of 20 cm from the bottom of the tank; allowing complete immersion of the work below the surface and a resultant freeboard of at least 10 cm to ensure an adequate safety margin in operation.

CONTROL POINTS

Pointage	cm 5 – 7 cm ³
Temperature	°C 50 – 80
Immersion Time	1 – 6 hours*

* See NOTES under APPLICATION above.

BATH CONTROL/REPLENISHMENT

The bath is controlled by a Pointage Titration done routinely according to useage.

Pointage Titration:

Measure 10 cm³ of the bath into a flask; dilute it accurately to 100 cm³ with water. Take 10 ml of this solution and add 4 – 6 drops of Phenolphthalein Indicator solution. Titrate with 1.0 M Hydrochloric Acid until the pink colour changes to clear colourless.

Titration:

Each point (1 cm³) is equivalent to 40 g/l Caustic Soda Solid

Replenishment:

Add 10 litres of 32% caustic liquor per 1000 litres for each increment in 0.1 cm³ Pointage required.

RINSING

The work should be thoroughly rinsed in a tank with a flow of clean, cold water, either by dip or spray, and possibly helped by a long-handled impervious brush or jet, to remove all residues of the bath and any adhering paint residues. Where required, a second hot rinse can be used to



assist in drying the work; this may contain PB Seal MEA (MP0242) to prevent the metal staining, especially if steel is being processed.

DRYING

The work should be dried as soon as possible. For best results, work should be dried in an indirect-fired oven up to 125°C. Should the finishing of mild steel be delayed or not required, a light coating of protective oil can significantly retard any corrosion. For temporary protection, Dewatering Oil 4 (MP0100) can be applied by dip after the cold-water rinse without force drying. For more lasting protection, Protective Oil 2 (MP0066) should be used after drying. Either oil can be applied by wiping, dipping, or spraying.

MAINTENANCE

The paint residues must be removed from the bath periodically; usually by a transfer desludge retaining as much of the bath as possible. To prolong the life of a heavily used tank where sludge (largely pigment) accumulates rapidly, the contents of the bath should be passed through a filter press of suitably alkaline resistant construction.

EQUIPMENT

The stripper tank and heating coils may be made of mild steel, the heating system should be designed to be at least 30cm above the tank bottom to allow for settlement of sludges beneath the heaters. Operators should wear goggles and PVC gauntlets along with a rubber apron and boots for protection. Guidance on suppliers of processing equipment may be obtained from our Sales Offices.

ENVIRONMENTAL CONSIDERATIONS

The bath is alkaline and the rinse water may rise above pH 10 and require CONSIDERATIONS: adjustment before discharge. If the ABSTRIP 63A(T1) needs to be discarded, a contractor experienced in the disposal of such chemicals should remove the spent tank contents

SAFETY AND HANDLING PRECAUTIONS

Before use, refer to the Product Safety Data Sheet.



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
ABSTRIP 63A	MP0905
PROTECTIVE OIL 2	MP0066-20
PB SEAL MEA	MP0232-25
DE WATERING OIL 4	MP0100

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