



ALUDYE BROWN R

ANODISING DYE

INTRODUCTION

ALUDYE BROWN R is a non-metalised dye that produces a red-brown and copper shades.

BENEFITS

- Pleasing red-brown shade
- Single component dye
- REACH and RoHS compliant

SOLUTION MAKE-UP

ALUDYE BROWN R 0.5-2g/l in DI water
ALUDYE BUFFER 5ml/l

It is essential that the tanks to be used for ALUDYE BROWN R are thoroughly cleaned and leached before any chemistry is introduced. If in any doubt as to the cleaning procedure please contact PMD (UK) Technical Department.

1. Add DI water to tank and heat to 60°C
2. Add ALUDYE BROWN R and mix thoroughly until fully dissolved
3. Add ALUDYE BUFFER and mix.
4. Check pH and adjust if required

OPERATING DATA

Concentration	0.5-2 g/l
Temperatures	55- 60°C
Buffer	The bath must be buffered with Aludye Buffer.
Time	5 minutes or as required
Sealing	The dyed oxide film must be properly sealed properly using ALISEAL CS
PH	5.2 – 5.8
Agitation	Air or solution movement

EQUIPMENT

Tanks	Polypropylene, Stainless Steel
Heaters	PTFE, Stainless Steel

PROCESS SEQUENCE

1. Anodise
2. Rinse
3. ALUDYE BROWN R, 0.5-2g/l, 5mins
4. Rinse
5. ALISEAL CS
6. Rinse
7. DI water rinse
8. Dry

MAINTENANCE AND CONTROL

Maintain solution level with DI water.
 Additions of ALUDYE BROWN R, are added to maintain colour required
 pH is maintained by the addition of dilute sodium hydroxide to raise or dilute acetic acid to lower.

ANALYSIS METHOD

Analysis is carried out using spectrophotometer.

Method

1. Prepare a standard solution at 5g/l Aludye BROWN R.
2. Pipette 5ml of standard solution in to a 250ml volumetric flask and make up to the mark with DI water. Label as A
3. Pipette 5ml of the dye bath in to a 250ml volumetric flask and make up to the mark with DI water. Label as B
4. Measure the absorption at 460nm and record as A and B respectively.

Calculation

$$(B/A) \times 5 = \text{g/l}$$

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
ALUDYE BROWN R	250047
ALUDYE BUFFER	250042
ALISEAL CS	251005

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