



ALUDYE GREEN C

ANODISING DYE

INTRODUCTION

ALUDYE GREEN C is a highly concentrated chrome free dye which produces a muted deep green shade.

BENEFITS

- Consistent colour
- Suitable for cold sealing
- Chrome free

SOLUTION MAKE-UP

ALUDYE GREEN C 1-2g/L in DI water

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

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

OPERATING DATA

Concentration	1 - 2 g/L
pH	5.2 – 5.8
Temperatures	55 - 60°C
Time	5 minutes depending on colour required
Anodic coating thickness	10 – 25µm
Sealing	The dyed oxide film must be properly sealed using ALISEAL CS

EQUIPMENT

Tanks	Polypropylene, Stainless Steel
Heaters	PTFE, Stainless Steel



PROCESS SEQUENCE

1. Anodise
2. Rinse
3. ALUDYE GREEN C,
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 GREEN C are added to maintain required colour.

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 2g/l Aludye GREEN C.
2. Pipette 5ml of standard solution in to a 1000ml volumetric flask and make up to the mark with DI water. Label as A
3. Pipette 5ml of the dye bath in to a 1000ml volumetric flask and make up to the mark with DI water. Label as B
4. Measure the absorption at 440nm and record as A and B respectively.

Calculation

$$(B/A) \times 2 = \text{g/l}$$

NOTES

Aludye Green C Will give slight bleed in the cold seal. The life of the seal can be extended by continuous carbon filtration.

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 GREEN C	250021
ALISEAL CS	251005

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