

TECHNICAL DATA SHEET

CL - 14

CL – 14 is an efficient alkaline degreasing, rust and scale removing bath. When used with periodic current reverse, removes, scale layers, carbon smut, Oxides and light soil from steel. CL – 14 can also be used cathodically or anodically as a degreasing bath. It can be used in the pre treatment lines of both rack and barrel plating with subsequent plating of deposits with excellent adhesion.

CL - 14	100 – 125 gms/ltr
Temperature	Room
Current density	1.5-8.0 A/sq.ft (anodic)
Voltage	6-9 V
Time	2-5 min

BATH PREPARATION:

Fill the cleaning tank with cold water to 60% of its final volume. Add the calculated amount of CL - 14 and stir to dissolve. The string should be continuing till it dissolves completely. Fill the tank to the operating level.

OPERATION:

Pre treatment cycle for steel.

Heavy soil or any visible residues of abrasive or polishing compounds should be pre cleaned and the following cleaned cycle should be used to remove light soil, invisible oxide film smut from steel surface before electroless nickel.

Pre treatment cycle is as follows:

- Hot alkaline soak clean in P-25 cleaner.
- Cold water rinse.
- Acid picking or acid dip with inhibitor.
- Cold water rinse.
- Anodic cleaning in CL - 14
- Cascade water rinse
- Electroless nickel plate
- Cold water rinse

For Derusting & Descaling:

For derusting and descaling the parts should be cleaned first cathodically followed by periodic reverse current for removing carbon scale.

EQUIPMENT:

Tank should be made of low carbon steel with rubber or plastic lining.

Exhaust hood should be provided for removing fumes.

CAUTION:

CL – 14 is highly alkaline so contact with skin or eyes should be avoided.

WASTE TREATMENT:

CL – 14 is a highly alkaline material. It is recommended that spent CL – 14 solutions be mixed with effluent from acid solutions prior to entering the neutralization tank. Allow the precipitate that forms to settle or filter the solution prior to discharge into the sewer.

DISCLAIMER:

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