

TECHNICAL DATA SHEET

EC-84

ELECTROLYTIC CLEANER FOR BRASS, COPPER AND COPPER ALLOYS

EC-84 is alkaline electrolytic cleaner for the removal of traces of oil and grease from brass, copper and its alloys prior to electroplating. Being a chelated alkaline cleaner, it has a high tolerance for hard water salts and removes light tarnish from copper and brass when used cathodically.

BATH MAKE -UP:

Concentration	50 - 70 g/l
Temperature	70-80 °C
Cathodic current density	2.5-10 A/dm ²
Anodic current density	2.5-5 A/dm ²
Voltage	6-8 volts
Time	1-5 min

Fill the tank about 2/3rd full with water. Add the calculated amount of EC-84 with continuous stirring, to dissolve it completely. Make the operating level and heat to operating temperature.

OPERATION:

Visible residues of abrasive or polishing compounds, oils or grease from machining operations should be pre cleaned in an appropriate emulsifiable solvent, emulsion spray or hot alkaline cleaner. Using the current densities mentioned the pre cleaned parts can be decreased in EC-84 for 1-5 min. The cathodic cycle should be followed by a short anodic cleaning cycle to remove any metallic film which may have plated out on the part during the cathodic cycle.

For anodic treatment for copper and brass parts an immersion time 5-15 seconds. is sufficient. Zinc and Zinc alloys are treated cathodically for 20-30 seconds.

MAINTENANCE:

The concentration of the bath can be best determined by simple acid base titration using phenolphthalein as an indicator.

EQUIPMENTS:

Tanks made of mild steel and steel are recommended. Stainless steel heaters and titanium heaters can be used.

ANODES:

Where there is a steel tank, the tank itself can be made the anode otherwise stainless steel plates can be used.

CONTROL :

The concentration of EC – 84 should be controlled by with simple acid titration using phenolphthalein as an indicator.

CAUTION:

EC-84 is alkaline in nature and contact of the salt or bath solution with the skin or eyes should be avoided

DISCLAIMER:

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