

TECHNICAL DATA SHEET

PL-80

PL – 80 is very heavy duty electrolytic alkaline cleaner for steel. It displaces oils, grease, weak scale layers, smut, finger prints and light surface rust. It removes the contamination from the surface, leaving the surface bright and lean. It has a high soil tolerance and excellent bath life as it removes the oil rather than emulsifying and so the floating oil can be easily skimmed off.

OPERATING CONDITIONS:

Concentration	60-80 g/ltr
Temperature	70-80°C
Current density	50-100 A/sq.ft
Voltage	5-9 V
Time	1-5 min

BATH PREPARATION:

Fill the tank about 2/3rd full with water. Add the calculated amount of PL-80 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. The parts to be cleaned are electrolytically decreased at 50-100 A/sq.ft. Anodically for 1- 5 min.

Parts cleaned in PL -80 must be rinsed well in running water before being transferred into the plating bath, so that the later suffers no damage from adhering residues of greasing solution. After this any alkalinity on the surfaces should be removed by giving a dilute acid dip.

MAINTENANCE:

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

Any grease which collects on the surface during operation should be removed in order to avoid resolving of components during lifting out of the solution. The loss of water by evaporation has to be good from time to time. If the solution acts slowly after some period of usage and components are no longer sufficiently cleaned, the bath should be replaced with the new one.

EQUIPMENTS:

PL- 80 can be contained in tanks made from sheet and can be heated by steel coils. Gassing during decreasing creates a spray of the electrolyte which may become rather irritating especially with the large tanks, therefore tanks fitted with fume exhausting frames are recommended.

ANODES:

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

CAUTION:

PL-80 is alkaline in nature and contact of the salt or bath solution with the skin or eyes should be avoided.

WASTE TREATMENT:

PL-80 is a highly alkaline material. It is recommended that spent PL-80 solutions be mixed with effluent from acid solutions prior to entering the neutralization sump or tank to gain advantages of mutual adjustments of pH. Allow the precipitate that forms to settle or filter the solution prior to discharge into the sewer.

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