

## TECHNICAL DATA SHEET

### PHOS-PREP® PP60S ORGANIC BASED PAINT STRIPPER

#### INTRODUCTION

PHOS-PREP® PP 60S is an organic Methylene Chloride free paint stripper for the removal of polyester paint finishes from ferrous and non ferrous metal substrates. (PHOS-PREP® PP 60S will remove some epoxy – polyester paints with low epoxy contents).

PHOS-PREP® PP 60S is safe to use on multi metal applications however we do recommend testing on site to ensure no surface damage occurs to sensitive substrates.

PHOS-PREP® PP 60S can be used at temperatures from ambient to 60° C.

PHOS-PREP® PP 60S is based on a high boiling point solvent (b.p 200° C) hence low volatility when used at 50° C, blended with alkaline accelerators and is very effective for the removal of polyester paint finishes, despite being alkaline base the non aqueous formulation of the PHOS-PREP® PP 60S ensures no attack on aluminium parts

#### EQUIPMENT

The recommended material of construction for tanks and pipe-work is 316 stainless steel, although some plastics or rubber may be suitable, with mechanical pump agitation / filtration to extend product life, to remove particulate debris and allow the accelerator PHOS-PREP® PP 60A to be added to the bath.

#### PROCESS

Appropriate chemical treatment ahead of PHOS-PREP® PP 60S depends on the condition of the components to be processed, removal of any heavy oil deposits should be removed if present.

PHOS-PREP® PP 60S will remove paint within 5 – 10 minutes when used as recommended (dependant on coating thickness) breaks down the paint to very fine particles rather than sheets, which assist intricate components being treated.

Place parts in the PHOS-PREP® PP 60S bath by jigs or work baskets, after the required dwell time remove, rinse the parts with water, seal mild steel parts with PHOS-PREP® PP 973 to prevent rapid oxidation, dry the parts.

#### PROCESS CONTROL

##### MAKE UP

PHOS-PREP® PP 60S, is used as supplied, (keep away from water), clean out existing tank purge with water, dry thoroughly; determine the volume of the tank. Add PHOS-PREP® PP 60S as supplied to the operating level required.

## REPLENISHMENT

PHOS-PREP® PP 60A is used to replace consumed accelerator to the PHOS-PREP® PP 60S bath, when adding the PHOS-PREP® PP 60A place the PHOS-PREP® PP 60A in the basket directly below the inlet flow of the filtration unit to allow for the PHOS-PREP® PP 60A to be fully dissolved in solution, or follow instructions under pH control method under laboratory testing.

PHOS-PREP® PP 60S contains other active ingredients that will be consumed during use, in practice as the bath levels lowered due to natural production losses, we recommend that PHOS-PREP® PP 60S added weekly, to ensure a correct balanced solution we ask for a sample to be sent for evaluation every 6 month.

## LABORATORY TESTING

During use the alkaline accelerator will be consumed requiring an addition of PHOS-PREP® PP 60A to return the bath to the correct strength, the concentration is measured as follows:

### FREE ACID POINTAGE

The bath is controlled by testing the acidity.

Take a 5ml sample of the bath (filtered) add 100mls of water allow to mix well add 5 to 10 drops of phenolphthalein indicator, contents will turn pink, titrate with 0.1 N hydrochloric Acid until the changes from pink to clear.

A pointage of 12 should be used for a new solution, for each 1 point short of 12 add 1.3grams PHOS-PREP® PP 60A per litre of working solution

The working bath should be tested regularly, small frequent additions of PHOS-PREP® PP 60A are recommended for consistent results.

## pH Control of PHOS-PREP® PP 60S

Should the pH of the working solution fall below 8.3 the titration test will not work, in which case the solution should be tested by pH and for each 1pH unit short of 13pH add 3.5grams of PHOS PREP® PP 60A for each litre of the bath solution

To blend the PHOS-PREP® PP60A remove some of the bath solution place into a container and place the required amount of PHOS-PREP® PP 60A in a basket and agitate until all the PHOS-PREP® PP 60A has dissolved replace the contents back to the working solution, repeat as required.

Specific Gravity for the solvent content / wetting agent is carried out this should be maintained at 1.055 by checking with a Hydrometer, to raise the Specific Gravity add 15% of PHOS-PREP® PP 60S for each 0.005 short of 1.055



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