

## TECHNICAL DATA SHEET

### PHOS-PREP® PP934 MULTI METAL SPRAY/IMMERSION DEGREASER

#### GENERAL

PHOS-PREP® PP934 is a multi metal alkaline cleaner and degreaser. It is suitable for use by spray or immersion, and is designed to give a light etch on aluminium and aluminium alloys.

PHOS-PREP® PP934 is suitable for use ahead of either painting or aluminium anodising. However, for optimum surface appearance after anodising it will be necessary to process through a PHOS-PREP® PP 933 alkaline etch subsequent to the PHOS-PREP® PP 934 and prior to the anodising stage.

#### LABORATORY CONTROL

To a 100-ml bath sample add bromophenol blue indicator and titrate with 1 Normal Hydrochloric acid to a yellow green end point, (the initial blue colour changing through blue/green to a pale yellow green).

|              |   |                                    |
|--------------|---|------------------------------------|
| Titre x 6.3  | = | g/l concentration PHOS-PREP® PP934 |
| Titre x 0.53 | = | % vol/vol PHOS-PREP® PP934         |

#### PLANT AND EQUIPMENT

The process tank and associated pipe work may be constructed from mild steel.

Bath heating equipment is required and air agitation of the bath is recommended.

#### OPERATION

The PHOS-PREP® PP934 bath can be operated between ambient and 70°C and at a concentration of 1.5 to 6 % vol/vol, depending on the time of processing and the degree of cleaning required.

Standard extrusions for caustic soda etching usually require an immersion time of about 5 minutes, a concentration of 2 % vol/vol, and a temperature of 45°C. Fabricated aluminium, particularly ahead of chemical brightening, is normally processed through a PHOS-PREP® PP934 bath of around 5% vol/vol and at 60°C.

Air agitation of the bath may be used to enhance cleaning efficiency.

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