

TECHNICAL DATA SHEET

T Deoxidiser 29**Strong Acidic Etch Cleaner for Aluminium**

Description	A strongly acidic liquid cleaner for the removal of oxides and smut from aluminium and aluminium alloy surfaces.				
Features	<ul style="list-style-type: none">• Used by dip at ambient temperatures.• A rapid preparation for aluminium extrusions etc. prior to chromium treatments, anodising, or other finishing processes.• Chromate-free - reduced effluent problems.• Requires no heating in normal shop conditions.• Forms no sludge or scale.				
Product Code	MP0119.				
SG	1.29 ± 0.1 kg/l at 15°C.				
Coverage	<p>The rate of consumption will depend on the degree of oxidation, the degree of carry over from alkaline etching baths, treatment bath concentration and draining efficiency of the jigged items.</p> <p>As a guide the following range has proved reliable:</p> <table><tr><td>Heavy Oxide Removal:</td><td>25 – 35m²/kilo T Deoxidiser 29</td></tr><tr><td>Light Oxide Removal:</td><td>50 – 70m²/kilo T Deoxidiser 29.</td></tr></table>	Heavy Oxide Removal:	25 – 35m ² /kilo T Deoxidiser 29	Light Oxide Removal:	50 – 70m ² /kilo T Deoxidiser 29.
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Light Oxide Removal:	50 – 70m ² /kilo T Deoxidiser 29.				
Equipment	The T Deoxidiser 29 tank should be made of, or lined with, 316 stainless steel (EN58J), polypropylene or rigid PVC. Rinse tanks can be made of mild steel, preferably painted with a suitable paint. Guidance on suppliers of processing equipment may be obtained from Trimite.				
Initial Fill	<p>For every 1000 litres of bath:</p> <ol style="list-style-type: none">1. Add approximately 600 litres of mains water.2. Carefully add 40 – 80 litres of T Deoxidiser 29 (see Control Points below).3. Fill the bath to the operating level with mains water and stir thoroughly.				
Application	<p>Normally, the process sequence is:</p> <ol style="list-style-type: none">1. Degrease if necessary by alkaline cleaning, normally with one of the following:<ul style="list-style-type: none">(i) T Cleaner 79 (MP0019) - deep etch cleaner; or(ii) T Cleaner 70 (MP0035) - non-etching multi-metal.2. Then cold water rinse.3. T Deoxidiser 29 dip until oxide or smut is removed (see Notes below).4. Cold water rinse (see Rinsing below).5. Further treatment. <p>Notes:</p> <ol style="list-style-type: none">(i) for certain applications, T Deoxidiser 29 can be used as supplied.(ii) when treating high silicon pressure die-castings, the time may best be restricted to 30 – 60 secs or avoided altogether, to avoid smutting.(iii) Similar short times are usually adequate to desmut work after caustic etching.(iv) Prolonged immersion times after the oxide/smut is removed will result in etching of the aluminium and a decrease in the economics of use.				

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	<u>Heavy Oxide</u>	<u>Light Oxide</u>
Deoxidiser Strength:	10% v/v	5% v/v
Pointage:	9 – 12 ml	4 – 6 ml
Temperature:	5° - 30°C	5° - 30°C
Time:	30 sec to 10 min	15 sec – 3 min.

Analytic Control

The bath is controlled by a Pointage Titration done routinely according to usage and after the bath has been brought to its normal level with water. For example, a bath in continuous use should be tested and replenished at least daily, but in occasional use only weekly or before use.

Pointage Titration: measure 5 ml of the bath into a flask, dilute to approximately 100 ml with water and add 4 – 6 drops of Phenolphthalein Indicator solution. Titrate with 0.5 M sodium hydroxide until the colour changes to a permanent pink.

Replenishment: add 8 litres of T Deoxidiser 29 per 1000 litres of bath for each ml the titration is below the operating level.

A Test Kit (**MP0602**) containing all the necessary items and replacement chemicals is available from Trimite.

Rinsing

Rinse the work thoroughly with water in a tank fitted with a weir and continuously overflowed with mains water. This water should be cascaded back to the rinse tank following the aqueous cleaner, so reducing the effects of acidity in the effluent.

Shelf Life

2 years from date of manufacture when correctly stored in unopened containers.

Storage

The product should be stored in cool, dry, frost-free conditions, in sealed containers.

Health & Safety

Refer to the product's Safety Data Sheet and safety advice on the product label before use.

Technical Support

For technical support in using this product, please contact:
e: birminghamtech@trimite.com, or
t: 0121 554 7000.

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