

# SurTec® 419

## Additive for Electrocleaning

### Properties

- liquid additive for alkaline electrolytical cleaning and descaling baths
- free of hard complexing agents as EDTA or NTA
- soluble even in high alkalinity
- as a weak complexing agent, it improves the cleaning result of alkaline immersion cleaners
- excellent results in electrolytical and descaling cleaning together with SurTec 194, or even with only sodium hydroxide
- suited for dephosphating

### Application

#### 1. Alkaline immersion cleaning

make-up values: surfactant containing base cleaner according to the separate data sheet, additional:

SurTec 419	2 %vol	(0.8-3.5 %vol)
	2.3 kg per 100 l	(1-5 kg per 100 l)

temperature: according to base cleaner (50-80°C)

application time: according to base cleaner (2-15 min)

#### 2. Electrolytic cleaning/descaling

make-up values:	SurTec 194	10 %vol	(8-12 %vol)
		15 kg per 100 l	(12-18 kg per 100 l)

SurTec 419	3.5 %vol	(3-4 %vol)
	4 kg per 100 l	(2.6-4.5 kg per 100 l)

temperature: room temperature up to 60°C

application time: 3 min (2-5 min)

current density: 5-10 A/dm<sup>2</sup> (anodic); cathodic cleaning is not allowed for hardened parts

#### 3. Dephosphating

make-up values:	SurTec 194	10 %vol	(5-15 %vol)
		15 kg per 100 l	(7.5-23 kg per 100 l)

SurTec 419	7 %vol	(5-10 %vol)
	8 kg per 100 l	(6-12 kg per 100 l)

temperature: > 60°C

application time: 15 min (5-30 min)

## Technical Specification

(at 20°C)	Appearance	Density (g/ml)	pH-value (at 20 g/l)
SurTec 419	liquid, light yellow to yellowish brown, clear	1.128 (1.11-1.14)	8.2 (7.6-8.8)

## Maintenance and Analysis

Analyse and adjust the NaOH content resp. the base cleaner and dose SurTec 419 in the same ratio as for the initial make-up.

## Ingredients

- salts of organic acids

## Stock Keeping

In order to prevent delays in the production process, per 1,000 l bath the following amount should be kept in stock:

SurTec 419                      100 kg

## Product Safety and Ecology

The safety instructions and the instructions for environmental protection have to be followed in order to avoid hazards for people and environment. The Material Safety Data Sheets (according to European legislation) contain explicit details for this.

The following hazard designations and classifications into water hazard classes (WHC) have to be taken into account:

<u>product</u>	<u>hazard designation</u>	<u>water hazard class</u>
SurTec 419	-	WHC 1

## Warranty

We are responsible for our products in the context of the valid legal regulations. The warranty exclusively accesses for the delivered state of a product. Warranties and claims for damages after the subsequent treatment of our products do not exist. For details please consider our [general terms and conditions](#).

## Further Information and Contact

In our forum, you can discuss topics of the surface technology:  
<http://forum.SurTec.com/>

If you have any questions concerning the process, please contact your local technical department: <http://SurTec.com/International.html>