



PICKLEEN™ AS-10

- **Removes oxides, heat and weld scale.**
- **Eliminates the hazards of mineral acids.**
- **Outstanding activation.**
- **Minimal attack on base metal.**
- **Use in a variety of applications.**
- **Free flowing, non-caking material.**
- **Easy and economical to use.**

PREMIUM METAL FINISHING ACTIVATOR

PICKLEEN AS-10 is a unique premium blend of acid salts, activators and surfactants designed as a replacement for liquid mineral acids. It eliminates the hazards of storage, fuming and handling problems caused by mineral acids.

PICKLEEN AS-10 removes oxides, rust, heat treat scale and welding scale thus is suitable for a variety of metal finishing applications. It provides activation without generating smut and with minimal attack on base metals. This is especially important when processing base metals where a bright, polished finish is an advantage.

PICKLEEN AS-10 can be used to activate nickel for replating, improve chrome coverage, strip chrome, as an acid dip for copper, copper alloys and zinc die cast.

PICKLEEN AS-10 comes as a free-flowing, non-caking, low dust material that dissolves easily in water. Its powerful formulation is ideal for most any application and with its long operating life, makes it the perfect substitute for mineral acids.

OPERATING DATA

<u>Application</u>	<u>Concentration</u>	<u>Temperature</u>	<u>Time</u>
Rust removal.	1-3 lbs/gallon (120-360 g/l)	130-150° F. (54-65° C)	As required
Acid dip on steel prior to plating.	12-16 opg. (90-120 g/l)	70-90° F (21-32° C)	15-90 sec.
Prior to phosphate.	1-2 lbs/gallon (120-240 g/l)	70-90° F (21-32° C)	1-3 min.
Activating cast iron.	1-2 lbs/gallon (120-240 g/l)	100-120° F. (38-49° C)	15-30 sec.
Acid dip for copper plate before nickel, tin, or tin-lead.	8-16 opg. (60-120 g/l)	70-90° F (21-32° C)	10-30 sec.
Pickling heat treated or welded steel or SS.	2-3 lbs/gallon (240-360 g/l)	130-150° F. (54-65° C)	Varies
Zinc die cast prior to plating.	4 opg (30 g/l)	70-90° F (21-32° C)	10-15 sec.
Buffed brass or copper before nickel.	8-16 opg (60-120 g/l)	70-90° F (70-90° C)	10-60 sec.
Stripping chrome.	2 lbs/gallon (120 g/l)	130-150° F. (54-65° C)	Varies
Plating nickel over passive nickel.	1-2 lbs/gallon (120-240 g/l)	100-130° F. (38-54° C)	2 min.:6-9 v cathodic.
Solder flux removal.	1 lb/gallon (120 g/l)	180-250° F. (82-121° C)	As Required
Activating Kovar or Monel before plating.	4-12 opg (30-90 g/l)	70-90° F (21-32° C)	15-30 sec.

SOLUTION CONTROL

Analytical:

- 1) 10 ml. sample.
- 2) Add 5 drops of methyl orange indicator.
- 3) Titrate with 1.0N Sodium Hydroxide.

Calculation: Mls of 1.0N Sodium Hydroxide x 1.6 = opg (x 12.0 = g/l) **PICKLEEN AS-10.**

EQUIPMENT

Koroseal, polypropylene, polyethylene or PVC tank, or tank linings are suggested. Heaters should be made of teflon. **PICKLEEN AS-10** contains fluorides, hence quartz heaters are not satisfactory. Solutions normally do not require ventilation. However, if required, recommended materials are polypropylene, PVC or fiberglass.

STORAGE/HANDLING

PICKLEEN AS-10 is stable on standing and has excellent shelf life. Store in a dry area in closed containers. The handling of the salts or solution requires the handling of acidic, fluoride containing materials. Avoid contact with skin and eyes. Always wear proper protective clothing, face shield, and rubber boots and gloves. If solution is splashed on skin and eyes, flush immediately with large volumes of cold water and seek medical assistance as soon as possible. **Refer to the Material Safety Data Sheet for more complete information.**

WASTE TREATMENT

Spent solutions and normal effluents generally require treatment prior to discharge. **A BRITE** has a staff of trained professionals to assist in the proper disposal of this or any metal finishing material.

MATERIAL SAFETY DATA SHEETS

Material Safety Data Sheets (M.S.D.S.) are readily available on this product. It is strongly recommended that all personnel thoroughly read and understand the information contained in both the Technical Data Sheet and the Material Safety Data Sheet before using this product.

WARRANTY

The information presented herein, while not guaranteed, is to the best of our knowledge true and accurate. No warranty or guarantee expressed or implied is made regarding the performance of any products, since the manner of use is beyond our control. No suggestion for product use nor anything contained herein, shall be construed as a recommendation for its use in infringement of any existing patent, and we assume no responsibility or liability for operations which do infringe any such patents. The above includes confidential and information of **A BRITE** and is furnished to you for your use solely on products or processes supplied to you by us.