FERROBOND 124

FERROBOND 124 is an alkaline degreasing and rust removing bath. The system when used with periodic reverse current, removes rust, scale layers, carbon smut, oxides and light soil from steel. FERROBOND 124 gives active bright surface for subsequent plating of deposits with excellent adhesion. It can be used in the pre-treatment lines of both rack and barrel plating.

OPERATING CONDITIONS:
FERROBOND 124 : 100g/ltr.
Anodic current density : 5 - 10.0 A/dm².
Voltage : 6 - 9 Volts
Temperature : 25 - 50°C
Time : 2.0 - 5.0 min.

BATH PREPARATION:

Fill the cleaning tank with warm water to 2/3rd of its final volume. Add the required amount of FERROBOND 124 and stir to dissolve completely. Fill the tank to operating level.

OPERATION:
The components are pre-cleaned in an appropriate emulsifiable solvent, emulsion spray or hot alkaline cleaner prior to electrolytic cleaning. The components are then electrolytically cleaned in FERROBOND 124 for 30 sec. to 2 min. After cleaning in FERROBOND 124 the parts must be rinsed well in running water followed by dilute acid dip to remove any alkalinity left on the surface prior to transfer into the plating bath. FERROBOND 124 is highly suitable for pre-treatment of steel parts before processing in Electroless nickel solution and the pre-treatment cycle is as follows:

1. Hot alkaline soak cleaning in FERROLEX D-15
2. Cold water rinse.
3. Acid pickling.
4. Cold water rinse.
5. Anodic cleaning in FERROBOND 124.
6. Cascade water rinse.
7. Hot water rinse.
8. Electroless nickel plate.
9. Cold water rinse.

For derusting and descaling the parts should be cleaned first cathodically followed by a periodic reverse current to remove carbon smut and scale.

EQUIPMENT:

Tanks made up of low carbon steel or low carbon steel tanks with rubber or plastic lining can be used. Exhaust hood should be provided to remove the fumes produced during operation.

CAUTION:

FERROBOND 124 is highly alkaline in nature so contact with skin or eyes should be avoided.

NOTE:

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