

# ACCU-LABS INC.

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**A2LA Accredited ISO/IEC 17025:2005 Certificate # 2558.01**

## **PATSTRIP N-I NICKEL STRIP**

**ACCU-LABS' Patstrip N-I** Nickel Strip is a powdered material that is mixed with sulfuric acid and water to strip nickel from brass, copper and copper alloys. No electric current is needed as **Patstrip N-I** dissolves the coatings chemically.

### **MAKE-UP**

- **ACCU-LABS' Patstrip N-I** should be made up at a concentration of 1 lb. per gallon and 10% per gallon Sulfuric Acid.
- Fill tank  $\frac{3}{4}$  full with tap water.
- Slowly add the required amount of 66° Be sulfuric acid.
- Add required amount of **Patstrip N-I** and mix thoroughly. Note: Adding the **Patstrip N-I** powder while solution is 90-120°F will aid in dissolving the **Patstrip N-I**.
- Fill to final volume with water while mixing.
- Heat to desired temperature as required. See operating guidelines.

### **OPERATING GUIDELINES**

- The recommended temperature range for stripping is 70-180°F. It is recommended to perform initial testing with a minimal amount of parts to determine an acceptable stripping dwell time. If attack on the substrate occurs then reducing the temperature and/or dwell time is recommended.
- Parts should be free from oil and heavy oxides before stripping. A reverse current cleaning and/or acid activation step may be necessary to prepare the nickel surface.
- **Patstrip N-I** will not strip chrome therefore parts plated with chrome over nickel must have the chrome stripped before attempting to strip the nickel.

**NOTE:**

When the parts have been nickel stripped a thin dark deposit (smut) may be present, this is typical and is due to impurities that may be present in the nickel, these impurities will not dissolve in the stripping solution and dipping the parts in a 2 oz/gallon solution of sodium cyanide at room temperature for a few seconds should easily remove the smut and leave a shiny surface. Note: Some acidic solutions may be used if the use of sodium cyanide is not an allowed, however the parts may not exhibit as bright of a surface as when processed with sodium cyanide. Contact your technical representative for possible acidic options.

**CONTROL:**

When the stripping time increases due to drag out and consumption, additions of 4oz/gal **Patstrip N-I** and 2.5% sulfuric acid can be performed to reduce stripping time. After 2 additions, it may be more economical to make up a new bath. The old bath should be disposed of properly.

**EQUIPMENT:**

**Patstrip N-I** should be contained in tanks constructed of lead, Koroseal®, polyethylene, or PVC lining. Coils may be lead, carbon or Pyrex®. Proper ventilation is recommended.

**CAUTION:**

**Patstrip N-I** should be handled by trained personnel while wearing personal protective gear and eye protection. If contact is made with skin flush with copious amounts of cold water. If contact is made with eyes flush with copious amounts of cold water and obtain medical attention. Read MSDS before handling this or any chemical product.

**DISCLAIMER:**

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