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A2LA Accredited ISO/IEC 17025:2005 Certificate # 2558.01

265PD Stainless Steel Electropolish

Accu-Labs 265PD is formulated to electropolish austenitic stainless steels (300 series) to produce a high degree of brightness and a chemically clean surface. Accu-Labs 265PD can also be used for deburring and for polishing forgings before inspection.

OPERATING GUIDELINES:

Pretreatment: Parts should be completely free of any grease, oil, or shop soil; if necessary process parts in a soak/electrocleaner (Accu-Labs 134-B) prior to electropolish. For parts that are severely oxidized or exhibit uneven oxide it is recommended to descale (Accu-Labs SR-9) prior to electropolish.

Concentration: RTU (Ready To Use) as is.

Dwell Time: 30 seconds – 30 minutes depending on condition of parts and brightness desired.

Current Density: 100 ASF is typical; your experience is your best guide.

Anodes: 316 stainless steel, graphite, or lead are recommended; other materials may be suitable per evaluation.

Temperature: $150^{\circ} \pm 25^{\circ}\text{F}$ **DO NOT EXCEED 175°F USE ADEQUATE VENTILLATION!**

Tank: Glass lined, Kel F lined, acid proof ceramic, polypropylene, or rubber lined steel tank.

Heaters: Pyrex® steam coils, Karbate® steam coils, tantalum steam coils, or quartz sheathed electric heaters.

Agitation: Mild air agitation is recommended.

New Bath Conditioning: Prior to processing parts in a new bath it is recommended to “dummy polish” parts to condition the bath. This is best accomplished by polishing scrap stainless steel parts at 0.5 amps/in² for 8 – 12 hours.

Maintenance: Maintain solution level with DI water to compensate for evaporative loss and drag out. As the 265PD solution ages the specific gravity will climb and the performance of the polishing action will decline with regards to speed and quality. This is compensated for by occasional decanting of the solution. Record the initial new bath startup specific gravity (typically in the 1.50 – 1.60 range) and monitor the solution performance. As the solution performance declines (typically in the 1.75 – 1.80 range) it is recommended to decant part of the 265PD bath. This can first be performed in the lab prior to committing the production tank. Best results are obtained by maintaining the solution specific gravity between 1.65 – 1.70 however, individual applications may vary and this information is a guideline only.

SAFETY AND HANDLING

Accu-Labs 265PD should be used with all precautions that are normally taken when handling strong acids and strong oxidants. Wear proper personal protective gear when working with or around this or any other chemical. Avoid contact with skin and eyes. Read MSDS prior to use. Use adequate ventilation with this product.

DISCLAIMER

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