



Anodal[®] DA-5 Powder

Phosphate and silicate free degreasing agent and detergent for aluminium parts and their alloys.

Anodal DA-5 Powder

- is a weakly alkaline, degreasing agent free of phosphate and silicate
- was specially developed for aluminium
- exhibits good degreasing and detergent action with little loss in metal weight
- contains a surfactant system which is even resistant to stress from buffing and polishing pastes in the bath.

1. Requirements

Degreasing agents are particularly important for cleaning aluminium before anodizing. Aluminium objects cannot be anodized and dyed without previous cleaning.

For a uniform dyeing, careful pretreatment is essential because the electrolyte must be able to uniformly wet out the aluminium parts to be anodized. This means that contamination such as oils, fats, rolling, drawing, pressing and age-hardening skins as well as buffing and anticorrosive oils must be removed before anodizing.

A clean surface is essential for the production of a high quality oxide film.

Anodal DA-5 Powder meets all these requirements.

2. Properties

Appearance :	white powder
Bulking volume :	ca. 800 g/l
Solubility :	at least 100 g/l at 50°C
Storage stability :	at least 5 years
Foaming behaviour :	very little foaming at the application temperature
Ecotoxicological data :	see Safety Data Sheet.

3. Application

Anodal DA-5 Powder is readily soluble in cold water.

The bath can be agitated by injecting air or forced circulation.

Process:	Immersion process
Applicable amount:	30-50 g/l Anodal DA-5 Powder
Temperature:	55-75°C
Treatment time:	3-15 min depending on the degree of contamination

4. **Bath monitoring**

In order to obtain uniform degreasing results it is necessary to keep the **Anodal DA-5** concentration in the treatment bath at 30-50 g/l. The reinforcing amounts required can be determined by analytical control of the degreasing bath.

Reagents

0.5 N hydrochloric acid
0.2 N caustic soda
sorbite
pH meter
or phenolphthalein 1% solution

Titration

The Anodal DA-5 concentration is determined by titration and the use of a pH meter or a phenolphthalein solution.

Dilute 20 ml bath solution with 250 ml demineralized water, add 25 ml 0.5 N hydrochloric acid while mixing, boil for 10 min and cool again to room temperature.

With 0.2 N caustic soda adjust to pH 9.0 with a pH-meter or after adding 2-3 drops phenolphthalein solution until it turns distinctly pink.

Then add 10 g sorbite and with 0.2 N caustic soda adjust to pH 9.0 or titrate again until it turns pink (= **V**).

Calculation

g/l Anodal DA-5 Powder = V ml x 3.6

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The information and recommendations presented here were compiled with the utmost care, but cannot be extended to cover every possible case. They are intended to serve as non-binding guidelines and must be adapted to the prevailing conditions.