



Enerox Anostrip HD

Rack stripper for anodize coatings.

Features & Benefits

Rapid, efficient stripping of anodize coatings	Improved anodizing process
Inhibited attack on aluminum	Minimized etching of aluminum surfaces
Contains no chromium compounds	Easier to waste treat
Thin foam blanket	Prevents corrosive misting

Physical Data

Appearance	Free flowing, light brown powder
Odor	Slight
Dusty	No
Foaming tendency	Moderate
Maximum solubility	64 oz/Gal @ 75°F (480 g/L @ 24° C)

Product profile

Caustic	Yes
Phosphate	No
Silicate	No
Chelates (EDA, NTA types)	No

Hazard classification

DOT Hazard Class	8, (Corrosive Material)
DOT Shipping Name	Corrosive Solid, Basic Inorganic N.O.S*
UN Number	3262
Packing Group	II



Guide Number	154
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* contains Sodium Hydroxide

Operating Conditions

	Range	Optimum
Concentration	1.5 – 4.5 lbs./Gal	4 lbs./Gal
Temperature	65 – 100°F (18 – 38°C)	83°F (28°C)
Time	0.5 – 5 minutes	As required
Agitation	Solution movement	As required

Equipment

Tank	Mild steel, stainless steel, reinforced polypro, or fiberglass
Ventilation	Mechanical to maintain level below permissible exposure limits
Agitation	Stirrer, pump, or work environment

Solution make up

Danger!! Enerox Anostrip HD contains Sodium Hydroxide. Consult Enerox Anostrip HD SDS sheet before handling this product. It should be handled with all the safety precautions associated with Sodium Hydroxide.

Be sure the process tank has been drained and cleaned. Fill to within two thirds of final operating volume with clean, cold water. With good solution stirring, gradually add the required amount of Enerox Anostrip HD.

Rapid additions may result in localized heating, boiling and spattering!

After the required amount of Enerox Anostrip HD has been added and dissolved, adjust final solution operating volume and cool solution to recommended temperature range, before using the bath.

Process suggestions

Enerox Anostrip HD benefits the anodize stripping process in several ways. Conditioning agents prevent the formation of hardened deposits as the bath ages. Etching of aluminum racks is significantly minimized. As the anodize coating is stripped, the exposed aluminum surface develops a thin, protective deposit which prevents any attack on the aluminum. This deposit can be readily stripped in 30% to 50% v/v Nitric Acid.

Prior to racking a fresh set of aluminum parts for anodizing, thorough rinsing of racks is recommended after Enerox Anostrip HD processing and before protective coating is



stripped. At some point during the bath life, the buildup of contaminants will effectively saturate it beyond which maintenance additions/filtration to remove solids will not maintain desired performance. When this occurs, the stripping bath should be dumped and a fresh solution prepared.

Aluminum racks used should match the alloy designation of parts anodized. Alloy 2000 series racks should not be used. Racks made of alloys 6061 and 6063 are excellent for anodizing.

Your Hubbard-Hall representative will be glad to help determine optimum bath life and recommend the appropriate products for effective surface preparation before anodizing.

Titration Method

1. Pipette a 2 mL sample of the bath into a 250 mL Erlenmeyer flask and add 50 mL of water.
2. Add 10 mL buffer solution. (125 grams AR grade Ammonium Chloride dissolved and diluted to one liter within concentrated AR grade Ammonium Hydroxide)
3. Add either 25 mL of 37% Formaldehyde solution -OR- 40 mL of 50% Triethanolamine.
4. Add 0.25 to 0.50 grams of Eriochrome Black T powder (1 gram ground with 100 grams Sodium Chloride)
5. Immediately titrate with 0.0575M EDTA until the solution color changes from purple to blue.
6. Record mL used.

Calculation

$$\text{Concentration (lb/Gal)} = \text{mL } 0.0575 \text{ M EDTA} \times 1.0$$

Waste Disposal

Enerox Anostrip HD and its working solutions are alkaline. They may be neutralized with acid to meet local POTW or municipal effluent discharge requirements. Sludges and oils should be separated out before discharge. Spent Enerox Anostrip HD solutions may contain dissolved metals from the stripping process. Therefore, additional treatment of the solution may be required to meet discharge requirements.

Caution

Please read and understand the Enerox Anostrip HD Safety Data Sheet before handling and using this product.

Recommended safety procedures for Enerox Anostrip HD tank make up are described on page 2 of the product bulletin.



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Our People. Your Problem Solvers.

For more information on this process,
please call us at 203.756.5521 or email: techservice@hubbardhall.com

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