riag Oberflächentechnik AG · Postfach 169 · CH-9545 Wängi TG

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riag Clean 628

All-purpose degreasing process

riag Clean 628 is a mild alkaline degreasing process, which is being used in immersion applications for all base materials. The degreasing product leaves a hydrophobic layer, which may be used as a temporary corrosion protection. **riag Clean 628** may be used as an auxiliary material for vibratory finishing (wetting agent component).

Properties

- Mild alkaline liquid
- Suitable for all base materials
- Intensive cleaning and degreasing
- Temporary corrosion protection (alkaline removable)
- Auxiliary material for vibratory finishing (approx. 10 mL/L)

Ingredients

- Anionic and nonionic surfactants
- Corrosion inhibitors
- Amine

Make up of riag Clean 628

	Corrosion protection	soak	ultrasonic
riag Clean 628 Additive	5 – 20 mL/L	30 – 50 mL/L	30 – 50 mL/L
Temperature	20 – 90 °C	60 – 90 °C	60 – 90 °C
Time	0.1 – 1 min	2 – 10 min	1 – 5 min

The degreasing system already contains surfactants, usually no additional detergents are necessary. In case of degreasing problems contact our sales department for the best solution.

Make up

The tank is filled to $^{2}/_{3}$ with water and the calculated amount of **riag Clean 628 Additive** is added. Finally add water up to the working level. Once the cleaner has reached its working temperature, it is ready for use.

Operating parameters

Temperature	20 – 90 °C
Time	0.1 – 10 min.
Agitation	Recommended (shorter treating time), as it supports the cleaning process
Tanks	Plastic or lined steel, when using ultrasonic high alloy steel
Ultrasonic	Ultrasonic will increase the cleaning efficiency essentially. The removing power of polish on copper-alloys is around 10 W/L.
Heating	Immersion heaters, but thermostatic control is essential.
Fume extraction	Recommended
Water	To ensure the longest possible service life and trouble-free use, we recommend the use of deionised water.

Maintenance

riag Clean 628 is used with different concentrations, due to the various possibilities of application. The concentration has to be checked after each make up by analysis to stay in the desired working range. The addition of **riag Clean 628 Additive** is carried out after the analysis.

Environmental considerations

All concentrates, rinse waters and waste solution must be treated and discharged in accordance with local effluent control regulations. Further information can be gleaned from the MSDS. Chemicals may not be stored below 10 °C:

Liability

This instruction manual was compiled with reference to the state of the art and all current standards, and is based on the long-term knowledge and experience of riag. However, riag cannot monitor compliance with this instruction manual and the methods described herein at the customer/end-user's premises. Work carried out with riag products must be adapted accordingly to meet local conditions. In particular, riag cannot accept liability for damage, loss or cost incurred due to a failure to adhere to this instruction manual, improper application of the methods, unauthorised technical modifications, insufficient maintenance or the absence of maintenance in respect of the requisite technical hardware or equipment, or in the event of use by unqualified personnel. riag is not liable for damage or loss caused by riag or its employees except where intention or gross negligence can be proved.
riag furthermore reserves the right to make changes in relation to products, methods and the instruction manual without prior notice.

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This transaction is governed by material Swiss law (Law of Obligations), excluding private international law (conflict of laws) and intergovernmental treaties, specifically the CISG.

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Analysis (Analytical methods)

Sample preparation:
The sample must be taken from a well-mixed location and allowed to cool down to 25 °C.

Reagents:	Hydrochloric acid 1 mol/L Methyl orange solution 0.1 % in water	
Procedure:	100 mL	**riag Clean 628** are transferred via pipette into a
	250 mL	beaker, add
	5 drops	methyl orange solution
		Titrate with hydrochloric acid 1 mol/L from yellow to red
Calculation:	**riag Clean 628 Additive** (mL/L) = use of HCl in mL x 7.04	

If the degreasing process doesn't work properly even though the concentration is within the desired range, a new make up is necessary.

Attention:

Chemicals not intended to be added to the process may disturb and influence the quality of the processed surfaces.