

## TECHNICAL DATA

### A-STRIP

#### Description

A liquid stripping medium, typically used for the removal of polyester powder coatings from aluminium and steel substrates. It is not suitable to remove coatings applied over an anodic film or epoxy powder coating.

#### The Control of Substances Hazardous to Health Regulations 2002 (COSHH)

This product contains the following substances either listed in the Approved Supply List or otherwise classified as having hazards defined by the Chemicals (Hazard Information and Packaging for Supply) Regulations 2002.

SUBSTANCE		GENERAL NATURE OF RISK
Sodium Hydroxide	>2 <5%	Corrosive
Methanol		Highly flammable & Toxic (As 100%)
Dichloromethane		Harmful

#### Instructions for use

#### See also the Aluminium Finishing Association Code of Practice – Stripping of Polyester Powder Coatings

The product described in this data sheet will remove, in various degrees, organic coatings from several substrates. We are always pleased to conduct laboratory scale tests of customer's workpieces and to demonstrate samples at the customer's premises in order to assist in determining the most suitable product for his stripping requirements. Nevertheless, because the exact nature of the coating is not always known and because coatings, pretreatments and operating conditions change, the final suitability for a particular purpose must always be determined by the customer.

A-STRIP is used as received. The solution should not be heated. Components for stripping should be immersed with care to avoid splashing. Keep immersion times to a minimum. When all the coating has been removed, the work should be water rinsed. Rinsing by a pressure wash system is most effective, preceded if required by a static rinse. In addition to A-STRIP used for normal make up and replenishment, the following materials are used to control the bath.

- (1) SOLVENT REPLENISHER to raise specific gravity when required. Non Flammable.
- (2) A-STRIP ADDITIVE to raise the alkalinity when required. Highly Flammable and Corrosive.
- (3) WT ADDITIVE to increase the water tolerance of the stripping bath. Non Flammable.

UNDER NO CIRCUMSTANCES should an operator enter a tank that has been used for the storage or usage of A-STRIP without taking all necessary precautions. As a minimum these should be:-

- (1) An independent air supply.
- (2) A safety harness whereby the operator can be removed from the tank without another operator entering it.
- (3) Constant supervision.
- (4) A permit to work.

**A-STRIP has a flash point varying with use. As the Specific Gravity falls, so does the Flash Point. Below a Specific Gravity of 1.08 the product classification changes from Flammable to Highly Flammable. Post NO SMOKING and FLAMMABLE signs in the work area.**



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## Control

When making additions to an A-STRIP bath, always mix thoroughly. All additions should be first tried on a laboratory scale to ensure the solution does not “phase out” into separate layers. Regular small additions are preferable to large infrequent ones. The following 3 parameters should be checked daily and records kept.

(1) Specific Gravity: Freshly manufactured A-STRIP has a Specific Gravity of approximately 1.12.

Take 250 mls of the stripper and filter. Transfer 100mls to a measuring cylinder and measure the Specific Gravity at 20°C. Maintain the Sp.Gr. above 1.08, usually with additions of A-STRIP, but if the Sp.Gr. needs increasing in isolation, the addition of 40 litres of Solvent Replenisher per 1000 litres of working solution will increase the Sp.Gr. by approximately 0.01.

(2) Accelerator: Take 50mls of the A-STRIP bath and filter. Titrate a 10ml sample of the filtrate against 1.0N Hydrochloric Acid to the colourless end point using Phenolphthalein indicator. Control the level of alkalinity between 6 and 8ml. The addition of 15 litres of A-STRIP ADDITIVE per 1000 litres of A-STRIP will raise the alkalinity by 1 point. Do not allow the alkalinity to fall below 6 points before making an addition.

(3) Water Tolerance: Take the 100ml sample from (1). Add Solvent Replenisher so that the sample is of the same specific gravity as the corrected bath. Add water in 1ml increments until the sample separates into two distinct phases.

If less than 2mls can be added, the water tolerance of the bath should be increased by the addition of 2% WT ADDITIVE. Alternatively higher water tolerances may be achieved by the addition of 1% WT ADDITIVE for every unit increment in water tolerance required.

## Equipment

Use a heavy gauge mild steel tank. **A close fitting lid should be in place at all times other than when items are being loaded or unloaded.** Do not allow tank to become pressurised. Tanks in excess of 2000 litres give improved chemical stability. Keeping the surface area to a minimum reduces vapour loss. Consider incorporating a wax seal (FEDERSEAL) or polypropylene spheres to lessen surface area. A WATER SEAL IS UNSUITABLE. A sloping bottom encourages stripped powder to flow to one end which assists removal. Incorporate a frame to the base to keep the work out of the removed residues. Provide a long handled scoop to remove residues without need for an operator to enter the tank.

Site the tank in a well ventilated area. Maintain the vapour concentration in the working area to a minimum but avoid permanent extraction to the tank, as this will artificially deplete the solvent. Site away from welders, radiant heaters and internal combustion engines as these may cause solvent decomposition. Electrical equipment, if any, in the vicinity of the stripping tank should be flame proof. Upon ignition toxic gases and smoke are given off.

## Storage

Due to the chemical composition of A-STRIP, a chemical reaction takes place from the moment of manufacture. This reaction is faster at higher temperatures. A-STRIP therefore has a finite shelf life. This can be 3-4 months at low temperatures, but if stored during the summer months in direct sunlight, this can reduce to a few weeks. This reaction which causes a precipitation in the barrel can be corrected in the tank. A-STRIP should therefore be stored and used in a cool position.

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