Product Bulletin

Better Chemistry. **Better Business.**

Enerox Stripper ANO

Product Code: 2582021
Revised Date: 8/16/2017

Enerox Stripper ANO
Rack Stripper For Anodize Coatings

FEATURES

• Rapid, Efficient Stripping of Anodize Coatings

• Inhibited to Minimize Attack on Aluminum Surfaces

• Contains No Chromium Compounds. Easier to Waste Treat

• Thin Foam Blanket Prevents Corrosive Misting

• Suitable for Most Anodizing Process Cycles

RECOMMENDED APPLICATION

	Range	**Optimum**
Concentration	16-32 oz/gal (120 -240 g/l)	24 oz/gal (180 g/l)
Temperature	65-100 deg F (18-38 deg C)	83 deg F (28 deg 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 Stripper ANO** contains sodium hydroxide. Consult **Enerox Stripper ANO** MSDS sheet before handling this product. It should be handled with all the safety precautions associated with Sodium Hydroxide.

info@hubbardhall.com
P.O. Box 790 ● Waterbury, CT 06720-0790● Tel: (203) 756-5521 ● Fax: (203) 756-9017
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Be sure the process tank has been drained and cleaned. Fill tank with 25% of the total volume of cold water required to make up the bath. With good solution stirring, slowly add the required amount of **Enerox Stripper ANO**.
Rapid additions may result in localized heating, boiling and spattering!

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

ANALYSIS PROCEDURE

The active components are consumed in the stripping process. Drag out of the bath also depletes these active components. Regular maintenance additions of **Enerox Stripper ANO** are recommended to replenish the bath. This can be accomplished by observing quality of stripping the anodize coating, and making appropriate additions per requirements of the particular process. Alternatively, the process bath can be analyzed to determine actual concentration of **Enerox Stripper ANO** and the required addition of product made to restore the balanced ratio of all the components. The following analysis procedure is recommended:

1. Pipette a 2 ml sample of the bath into a 250 ml Erlenmeyer flask.

2. Add 50 mls of water.

3. Add 10 mls buffer solution. (125 grams AR grade ammonium chloride dissolved in concentrated AR grade ammonium hydroxide and diluted to one liter with ammonium hydroxide).

4. Add **Either** 25 mls of 37 % Formaldehyde solution, **OR** 40 mls of 50 % Triethanolamine.

5. Add 0.25 to 0.50 grams of Eriochrome Black T powder (1 gram ground with 100 grams Sodium Chloride)

5. Immediately titrate with **Either** 0.0575 M **OR** 0.1 M EDTA until the solution color changes from purple to blue.

Enerox Stripper ANO (oz/gal) = mls of EDTA X M of EDTA X 38.1

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PROCESS SUGGESTIONS

Enerox Stripper ANO 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 -50% v/v Nitric Acid.

Prior to racking a fresh set of aluminum parts for anodizing, thorough rinsing of racks is recommended after **Enerox Stripper ANO** 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.

The Technical Center or your Hubbard Hall Inc. sales representative will be glad to help determine optimum bath life and recommend the appropriate Hubbard Hall products for effective surface preparation before anodizing.

PHYSICAL CHARACTERISTICS

Appearance	Free flowing, light brown powder
Odor	Slight
Dusty	No
Foaming Tendency	Moderate
Maximum Solubility	64 oz/gal at 75 deg F (480 g/l at24 deg C)

PRODUCT PROFILE

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

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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

* contains Sodium Hydroxide

WASTE TREATMENT & DISPOSAL

Enerox Stripper ANO and it's 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 Stripper ANO** solutions may contain dissolved metals from the stripping process. Therefore, additional treatment of the solution may be required to meet discharge requirements.

SAFETY INFORMATION

Please read and understand the **Enerox Stripper ANO** Material Safety Data Sheet before handling and using this product.

Recommended safety procedures for **Enerox Stripper ANO** tank make up are described on page 2 of the Technical Data bulletin.

WARRANTY

THE QUALITY OF THIS PRODUCT IS GUARANTEED ON SHIPMENT FROM OUR PLANT. IF THE USE RECOMMENDATIONS ARE FOLLOWED, DESIRED RESULTS WILL BE OBTAINED. SINCE THE USE OF OUR PRODUCTS IS BEYOND OUR CONTROL, NO GUARANTEE EXPRESSED OR IMPLIED IS MADE AS TO THE EFFECTS OF SUCH USE, OR THE RESULTS TO BE OBTAINED.

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