



PRODUCT INFORMATION



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Technical Data:

Description: *CitriSurf 2325* is a high quality blend of chemicals formulated for cleaning, rust removal and passivation of stainless steel products. *CitriSurf 2325* is specifically designed to provide low cost and efficient removal of contaminants and all rust and free iron from the surface of stainless steel, providing the highest chrome oxide levels possible.

Physical Properties:

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|------------------------------|---|
| Specific Gravity | 1.07 |
| Approx. wt. /gallon | 9.5 lb/gal |
| Viscosity | 3 cps |
| Form | Liquid |
| Chemical Composition | Citric acid, water, proprietary ingredients |
| Operating Temperature | Room temp or higher (120-160°F preferred) |
| Flash Point | None |
| Water solubility | Complete |
| Normal working concentration | 20-33% by volume in water |
| pH at working concentration | 1.6 |

Packaging: 5 gallon or 55 gallon plastic containers. Larger sizes available upon request.

Application Procedure: To assure best results and help extend the life of the bath, the parts to be passivated may be cleaned with an appropriate cleaning solution prior to treatment with *CitriSurf* solution, especially when heavy grease and oils are present.

All equipment, mixers, tanks and pumps should be clean and dry prior to mixing of *CitriSurf* solution. *CitriSurf 2325* should be mixed with clean water (deionized or distilled water if desired) at a ratio of **1 part of *CitriSurf 2325* with 3 to 5 parts of water by volume** to fill the tank used so as to adequately cover all parts to be treated. Polypropylene, stainless steel, or equivalents should be used for construction of all tanks and devices used in the *CitriSurf* bath. Agitation of the solution in the tank is strongly recommended to attain optimum results. Optimum results can be obtained with many parts by using *CitriSurf* in an ultrasonic tank.

Heat the solution for optimum performance. Teflon coated (or equivalent), stainless steel or titanium heating devices are recommended. Your tests should indicate the best bath working temperature for the products you manufacture. 120-160°F is typical. Room temperature could be adequate depending on the end use.

Completely immerse the parts to be passivated in the solution for a period sufficient to remove all corrosion, free iron and contaminants from the surface. This is typically 15-30 minutes, depending on temperature, grade of stainless steel, hardness, use of ultrasonics, and the condition of the surface of the parts. Difficult rust or corrosion must be tested to determine the exact best conditions for removal. If heavy rust needs to be removed, Scotch Brite (TM) or other non iron containing abrasive may be helpful. Rinse the parts thoroughly with clean water, flowing water is optimum. DI water may be used to prevent water spotting. Dry completely in air immediately. Drying can be accelerated by use of a hot air oven or other drying medium to attain a highly passive surface.

Notes on Use: Although very safe in normal use, *CitriSurf 2325* is a citric acid based material, and as such it may cause irritation to exposed surfaces of the body. **See Material Safety Data Sheet before using this material.**

Maintenance: The pH of the *CitriSurf 2325* bath should be held to within +0.1 of its initial value for normal operation. Replenish the bath with *CitriSurf* and water as appropriate to adjust for dragout, evaporation, and pH increase.

Disposal: Dispose of according to all federal, state and local regulations.

Storage: *CitriSurf 2325* should be stored at temperatures between 50°F and 120°F in 316 stainless steel or approved plastic containers (polyethylene or polypropylene). (If accidentally frozen, thawing will return product to normal.)

Technical Services: For technical assistance, please contact Stellar Solutions at (847) 854-2800.

Specifications: *CitriSurf 2325* meets all of the requirements of ASTM A-967 and AMS 2700 specifications.

Testing of your products with *CitriSurf* before using in production is recommended. Every product and facility is different, and requires testing to ensure that *CitriSurf* is compatible with the particular situation. No warranty is implied, or may be given in writing or verbally without the written permission of Stellar Solutions, Inc.