



PRETREATMENT TECHNICAL DATA SHEET

LOW TEMPERATURE
SPRAY ALKALINE CLEANER

PRODUCT DESCRIPTION

ULTRAX LT8630 is a liquid KOH based alkaline cleaner developed for use in low temperature cleaning processes to remove standard mill oils, non-waxy lubricants, synthetic lubricants and rust preventatives from ferrous substrates.

ULTRAX cleaners are recommended for use in any production process requiring the pretreatment and painting of metal components, for end-products such as automobile parts, appliances, lawn & garden, heavy duty equipment, tractors, recreational vehicles or office furniture.

TECHNICAL PROPERTIES

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|---|--------------------|
| • Recommended Spray Concentrations: | 2-5% by volume |
| • Recommended Immersion Concentrations: | 3-7% by volume |
| • Recommended Temperatures: | 85-120°F (29-49°C) |
| • pH (concentrate): | >13.0 |
| • pH (working bath): | 12.0 – 12.5 |
| • Foaming Tendency: | Low |

PRODUCT ADVANTAGES

- Ideally suited for TTX systems
- Easy to handle for both the initial charge and subsequent make-ups
- Easily controlled through the use of metering equipment
- Ability to remove a wide variety of mill oils, rust preventatives and synthetic lubes (to control foam a prewash is recommended with all high foaming lubricants)
- Good rinsing characteristics

NOTE: *ULTRAX LT8630 may not be suitable for use on all types of aluminum and galvanized steel substrates, therefore compatibility testing is recommended prior to use*

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USE & CONTROL INSTRUCTIONS:

Operating Properties (Typical):

- Application: Spray and Immersion
- Operating Concentration: Spray: 2-5% by volume
Immersion: 3-7% by volume
- Operating temperature: 85⁰F - 120 °F
- Operating time: Spray: 45-90 seconds
Immersion: 90-120 seconds

Charge Details:

- 1) Fill the clean tank to approximately $\frac{3}{4}$ full of the operating solution with fresh water.
- 2) Heat the tank to 85°F.
- 3) Slowly add the recommended amount of **ULTRAX LT8630** to the processing tank.
- 4) Mix well and continue filling the tank to the operating level with fresh water.
- 5) Make concentration adjustments and begin processing parts.

Analysis Procedures:

CAUTION: DO NOT PIPETTE BY MOUTH!

Free Alkalinity

Equipment needed:

- Burette
- Beakers
- 250 mL Flask
- 10 ml volumetric pipette
- Pipette Bulb

Reagents needed:

- Indicator: Phenolphthalein
- Titrant: 0.1 Normal Sulfuric Acid

Procedure:

1. Pipette 10 ml of cleaner bath into a clean, dry 250 mL flask.
2. Add 5 drops of Phenolphthalein indicator.
3. While swirling the flask, titrate the pink/red solution with 0.1 Normal Sulfuric Acid until the solution turns colorless.

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Calculation:

mL of 0.1 N Sulfuric Acid X 0.42= Percent concentration of **ULTRAX LT8630**

Concentration % by volume	Free Alkalinity (mL)
0.5	1.2
1.0	2.4
2.0	4.8
3.0	7.2
4.0	9.6
5.0	12.0
6.0	14.4

ULTRAX LT8630 Replenishment:

- To raise the concentration by 1% by volume, add 10 gallons of **ULTRAX LT8630** to each 1000 gallons of tank volume.
- To raise the concentration by one point of free alkalinity, add 4.2 gallons of **ULTRAX LT8630** for each 1000 gallons of tank volume.

TECHNICAL DATA SHEET DISCLAIMER—INDUSTRIAL COATINGS:

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PPG PRETREATMENT PRODUCTS
23000 ST. CLAIR AVE
EUCLID OH 44117
216 486 5300
www.ppg.com