

METAL RESOURCE SOLUTIONS



Cleaning Options

1. Remove oil and lubricants by immersing fasteners in hot water at a minimum temperature of 70-80 degrees Celsius. Agitation will enhance cleaning effect. Immerse the fasteners in a 10-20% sodium hydroxide solution at a temperature of 70-80 degrees Celsius for 20 minutes or more. Agitation will enhance the process. Rinse the fasteners with water to remove residual cleaning solution.
2. Remove oil and lubricants by immersing fasteners in hot water at a minimum temperature of 70-80 degrees Celsius. Agitation will enhance cleaning effect. Passivate the surface by immersing the fasteners in 10-15% Nitric Acid solution at a temperature 50-65 degrees Celsius for a duration of 20 minutes. Rinse the fasteners to remove residual solution.
3. Remove oil and lubricants by immersing fasteners in hot water at a minimum temperature of 70-80 degrees Celsius. Agitation will enhance cleaning effect. Immerse fasteners in a solution of 10% H₂SO₄ at 60 degrees Celsius or higher for a duration of 20 minutes. Rinse the fasteners to remove residual solution.

Cleaning Precautions

1. Use of a Carbon Steel or Nickel-Plated Basket is recommended for effectively removing 4MAX coating when using Sodium Hydroxide Solution cleaning method.
2. Venting is required in the cleaning process when removing the 4MAX coating from the surface of the part.
3. Stainless Steel baskets are recommended for the Passivation process.
4. The Electrolytic Process can be used to remove impurities from the Sodium Hydroxide cleaning solution. Once removed the solution can be reused.