

TURCO[®] 5668

Control Method

LIQUID SEAL

1. Determine depth of seal while tank is at operating temperature of 68°C. This may be done using a glass tube. Hold in a vertical position over tank with both ends open. Slowly lower into the seal and down into the solvent layer. Stopper top end of the tube and withdraw tube until the bottom is just barely below the surface. Measure depth of seal.
2. The depth of the seal shall be in the range of 13 to 15% of the total volume of the solution in the tank. Should the seal be less than 10 cm deep or less than 15% of the volume of the solution, add Turco 5668 Additive #1 until the proper volume is attained.
3. The height of the solvent should be adjusted as necessary to insure that the uppermost point on all parts being cleaned are completely submerged. The parts should be at least 5 cm below the bottom of the seal layer.

LOWER LAYER - ALKALINITY TEST

1. The total alkalinity of the solvent is determined by taking a sample of only the lower layer.
2. Pipette 5.0 ml of the lower layer into a beaker and add 100 ml of distilled water.
3. Titrate with 1.0 N (Normal) H₂SO₄ (sulfuric acid) to pH 8.0 using a pH meter.
4. Record number of mls of 1.0 N H₂SO₄ used.
5. This titration should be in the range of 26 - 30 ml of 1.0 N H₂SO₄. If it is within these limits no correction is required. If not, adjust to mid-range (28 ml) as follows:
 - a. For each ml that titration is below 27 add 1.2 liters of Turco 5668 Additive #2 per 100 liters of lower layer.
 - b. For each ml the titration is above 27 ml add 3.0 liters of Turco 5668 Additive #3 per 100 liters of lower layer.

CORROSION TEST

1. Polish representative aluminium 7075-bare - qq-A-250/12 and magnesium qq-M-44 alloys with an abrasive (such as pumice, diatomaceous silica, etc), rinse with alcohol and dry. Do not touch with hands after polishing.
2. After the Turco 5668 has been adjusted for alkalinity content obtain a representative sample (about 85% solvent layer - 15% seal layer) and heat to 80°C. Immerse polished panels for 24 hours making sure the panels do not touch.
3. Remove panels, rinse and examine for evidence of pitting, discoloration, or etching.
4. If corrosion is noted contact your local Turco representative for proper corrective procedures.

ADDITIONAL INFORMATION

1. The liquid seal shall not be used as a means of controlling solution height by draining portions of the seal. Removal of seal shall be accomplished only after consultation with the Turco representative who will contact the Turco Technical Department.
2. Daily checks should be made to ascertain that the Turco 5668 solution is not being contaminated with water or other chemical cleaning solutions. Such contamination must be avoided since it can cause pitting and/or etching of metal parts.
3. Samples of Turco 5668 from each tank should be compared against a sample of unused Turco 5668 for cold water rinsability. these weekly rinsability checks will indicate contamination build-up in the tanks. The Turco representative should be consulted if poor rinsability is indicated.
4. The Turco Technical Department offers service in connection with the maintenance of the Turco 5668 solutions. It should be consulted if anything unusual is detected when samples are examined.

NOTICE:

The above information and recommendations concerning this product are based upon our laboratory tests and field use experience with this or similar products. However, since conditions of actual use are beyond our control, any recommendations or suggestions are made without warranty, express or implied. Manufacturer's and seller's sole obligation shall be to replace that portion of the product shown to be defective. Neither shall be liable for any loss, damage, or injury, direct or consequential, arising out of the use of this product.

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