



RADIO CORPORATION OF AMERICA

RCA VICTOR DIVISION
TUBE DEPT. STANDARDIZING LLL
HARRISON, N. J. LANCASTER, PA.

DATE Aug. 25, '49 PAGE 1

STANDARDIZING
NOTICE 34-34-74

SUBJECT ELECTROCLEANING - ALKALINE CLEANER
Process Specifications

SUPERSEDED DATE 1/10/47

This process describes the general specifications for electrocleaning relative to preparation and maintenance of bath and cleaning procedure.

1. EQUIPMENT

- a. Cleaning tank - constructed of sheet steel with a steam coil or hot plate to heat the cleaning solution.
- b. Steel electrodes.
- c. Air exhaust.
- d. D.C. ammeter - connected in series on anode side of circuit.
- e. D.C. voltmeter.
- f. Reversing switch.
- g. D.C. voltage supply.

2. MATERIALS

- C610 Pennsalt Cleaner K-2
- Hot Tap Water

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ALKALI HANDLING PRECAUTIONS: See S.N. 33-2-8A.

3. PREPARATION OF SOLUTION

- a. Pennsalt Alkaline Cleaner K-2: 60gm./l. (8 oz./gal.)
- b. Dissolve the required amount of cleaner in hot tap water.

4. PROCEDURE

- a. Take properly masked parts and rack or wire them so that good electrical contact is made.
- b. Immerse in bath and attach to contact bar.
- c. Electroclean.
 - Current Density: 50-60 amp./sq. ft.
 - D.C. Potential: 6-12 v.
 - Bath Temperature: 88-96°C. (190-205°F)
 - Cleaning Time: 15 sec. - 2 min.
- d. Remove parts from bath and rinse in hot tap water.

5. SOLUTION CONTROL CHECK

- a. Submit a 4 oz. sample of cleaning bath each week to laboratory, making sure that solution is well agitated before taking sample.
- b. K-2 Salt should be maintained between 52-67 gm./l. (7-9 oz./gal.)

ENGINEERING SECTION
STANDARDIZING

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