

F 3212

**ALKALIT R/2 1199 W**  
(chloride-free)

GA 2094

**Alkalit R/2 1199 W** removes oil, grease and preservatives from iron and steel.

**Alkalit R/2 1199 W** is particularly suitable for the removal of rolling and drawing skin from cold-formed iron and steel products and for the removal of drawing compounds and phosphates.

**Alkalit R/2 1199 W**, when used at high concentrations, also removes rust.

**Alkalit R/2 1199 W** is a versatile compound and is particularly suitable for the pre-treatment for removal of grease and activation of the surface before chemical blackening or phosphating. It can be used to clean and activate copper and brass parts in order to permit more uniform chemical blackening.

**Never immerse light metals, zinc or zinc alloys in Alkalit R/2 1199 W, since these will decompose, releasing hydrogen!**

**Delivery:** in 25 kg plastic sacks

**Application:** immersion process

**Alkalit R/2 1199 W** is dissolved in cold water. **Caution: this is an exothermic reaction!**  
**Add the required amount of salt slowly, in small quantities, to the cold water, stirring continuously. Never pour water into the salt!!**

For details of bath maintenance and regeneration see our **information sheet no. 122** "Rapid analysis of Alkalit baths".

The bath can be monitored even more quickly with the aid of a manual refractometer (refractometer value = approx. percentage of Alkalit R/2 1199 W).

<b><u>Process I</u></b>	<b>or</b>	<b><u>Process II</u></b>	<b>or</b>	<b><u>Process III</u></b>
<b>Degreasing + activation</b>		<b>Derusting + activation</b>		<b>Paint removal + activation</b>

If you want to remove paint, first carry out practical experiments to determine whether **Alkalit R/2 1199 W** is suitable for removing the type of paint concerned from iron or steel surfaces.

Depending on the number of parts processed and the tested bath parameters, the bath can be topped up as required with **Alkalit R/2 1199 W**. If the bath becomes very dirty, it must be discarded and a fresh bath prepared.

In order to remove the oil film from the surface of the bath, the degreasing bath should be operated with a slight overflow or fresh water should be added regularly such that it flows towards the grease trap.

After treatment in **Alkalit R/2 1199 W**, the parts must be rinsed thoroughly, using a cascade rinsing bath.

**Caution when adding cold water:** delayed boiling and splashing are possible if baths are inadvertently concentrated.

The transfer of **Alkalit R/2 1199 W** to the following baths should be avoided by water-saving rinsing methods.

Safe operation of the baths:

**Caution:** Boiling concentrated alkalis may tend to surge. Use temperature limiters to prevent overheating and level controllers to monitor level reductions due to evaporation. Mount air extractors over the baths.

Keep incompatible substances (see EU safety data sheet) away from the baths.

Parameters:

Operating temperature:	75–95 °C	75–95 °C	75–95 °C
Treatment time:	5–15 min.	5–15 min.	5–15 min.
Concentration:	10–20 kg/100 l	25–35 kg/100 l	35–45 kg/100 l
pH range	Above 13	Above 13	Above 13
<b>ALKALIT factor</b> (Phenolphthalein) (free alkalinity)	<b>0.8 ± 0.1</b>	0.8 ± 0.1	0.8 ± 0.1
ALKALIT factor (Bromophenol blue) (total alkalinity)	<b>0.6 ± 0.1</b>	0.6 ± 0.1	0.6 ± 0.1

Environmental protection: **Alkalit R/2 1199 W** is classified as slightly hazardous to water (water hazard classification 1) according to the Federal Water Act.

Product safety: **Alkalit R/2 1199 W** is subject to be labelled in accordance the German Ordinance on Hazardous Substances.

Danger symbols:



GHS05

Signal word: **Danger**

See the EU safety data sheet for further details.

Precautions:

Before using and handling **Alkalit R/2 1199 W**:

- Read the EU safety data sheet.
- Read and comply with the instructions for use.
- Wear suitable protective clothing (goggles, gloves)

In the case of contact with your eyes: rinse thoroughly with water for at least 15 minutes and consult an ophthalmologist without delay.

Observe the locally applicable regulations for the handling of caustic substances.

**Containers:** We recommend the use of tanks made of steel or stainless steel from our range of standard tanks.

**Storage:**

- Store in sealed containers made of suitable materials.
- Store in a cool, dry place.
- Store away from incompatible substances (light metals, acids).
- Observe the applicable regulations for storage and handling of water pollutants.
- Do not allow the product or its solution to enter the sewers without suitable neutralisation (this also applies to the rinsing water).

**Disposal:** Waste code, product: AVV 11 01 07\*  
Solution: AVV 11 01 07\*

Alkalit and its solution, including the rinsing water, must be disposed of as special waste in accordance with the applicable local regulations.

If the waste is neutralised and disposed of via the sewers, observe the limit values for oil traps and pollutants.

The delivery sacks must be completely emptied. Waste code for contaminated packing materials: AVV 15 01 10\*.

**Warranty:**

All of the above information is provided to the best of our knowledge on the basis of practical and laboratory testing, but without guarantee.

Since we have no control over possible incorrect use of our products, we provide a warranty only for the product as delivered. Our customer service department and our development and technology department will gladly answer any questions with respect to the application (telephone +49 (0)9122/9868-19).