



INCREMENTAL CHANGE

Release Notification Date: 05/11/2022

SPM 70-00-99 S1186 - PLATING REMOVER SOLUTION - C04-244

DISCLAIMER

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HIGHLIGHTS

HIGHLIGHT REFERENCE DESCRIPTION OF CHANGE

sk70-00-99-809-398 Technical Change: Changed limits of pH concentration in the plating remover.

TASK 70-00-99-801-186

1. Composition.

Consumable Product	No.	Concentration (Initial Mix)
Enstrip EN-86A	C04-244	33% by volume
Enstrip EN-86B	C04-244	8 oz/gal (60 g/l)
Sodium Hydroxide	C04-084	To maintain pH
Enstrip Regenerator	C04-157	To maintain solution

2. Preparation.

Subtask 70-00-99-809-397

WARNING: NEVER ADD WATER TO ALKALINE CONCENTRATE. ADD ALKALINE CONCENTRATE TO WATER WHILE STIRRING VIGOROUSLY. LOCALIZED HEAT OF SOLUTION CAN CAUSE BOILING OR SPLATTERING. ALKALINE SOLUTIONS ARE VERY ACTIVE AND CAUSE SERIOUS BURNS. AVOID CONTACT WITH SKIN, EYES AND CLOTHING. IF CONTACT OCCURS, WASH IMMEDIATELY WITH ABUNDANT QUANTITY OF WATER. AVOID BREATHING VAPORS. OPERATOR SHOULD WEAR FACE SHIELD, GLOVES, PROTECTIVE CLOTHING AND SHOES.

WARNING: ENSTRIP EN-86B IS A FLAMMABLE SOLID, DO NOT STORE NEAR EXCESSIVE HEAT OR OPEN FLAMES.

WARNING: ENSTRIP EN-86A AND THE ENSTRIP EN-86 OPERATING SOLUTION ARE STRONGLY ALKALINE IN NATURE AND MAY CAUSE SKIN AND EYE BURNS. AVOID SKIN AND EYE CONTACT. IN CASE OF CONTACT, FLUSH SKIN AND EYES WITH PLENTY OF COOL, CLEAN WATER FOR 15 MINUTES; FOR EYES, OBTAIN IMMEDIATE MEDICAL ATTENTION.

WARNING: ENSTRIP EN-86A, ENSTRIP EN-86B AND THE FINAL STRIPPING SOLUTION SHOULD BE HANDLED WITH CARE AND PROPER PROTECTIVE CLOTHING SUCH AS RESPIRATOR, RUBBER GLOVES, AND SAFETY GLASSES, SHOULD BE WORN TO PREVENT CONTACT WITH THE SKIN OR EYES. DO NOT INHALE DUST OR MIST FROM THE BATH COMPONENTS OR FROM THE OPERATING SOLUTION.

A. Enstrip EN-86 is supplied as two components: Enstrip EN-86A, a liquid material, and Enstrip EN-86B, a powder. Both components are then combined with water to make up the working solution.

Prepare the solution as follows:

- (1) Fill the stripping tank with warm water to within 1/2 the operating volume of the tank.
- (2) Add EN-86B equal to 8 oz/gal (60 g/liter) of the final working solution to the warm water.
- (3) Stir the EN-86B solution until all powder is completely dissolved.
- (4) Cautiously add the EN-86A equal to 33% by volume of the final working solution.
- (5) Fill the stripping tank to its final working volume with water and heat to the operating temperature.
- (6) Cover solution when not in use.

3. Check.

Subtask 70-00-99-809-398

A. Determine the concentration of the plating remover:

Checks	Limits	Recommended Interval
Enstrip EN-86A	33% by volume	Weekly
pH	12.0-12.8	Weekly
Enstrip Regenerator	See NOTE	Weekly

B. Follow the manufacturer's control procedures to maintain the solution.

NOTE: Analysis and replenishment of the Enstrip EN-86 operating solution is required after each mil ft²/gallon (4.5 g/l nickel metal) is stripped.

NOTE: Follow the control procedures as recommended by the manufacturer and in the order listed by the manufacturer.

NOTE: Replenish the Enstrip Regenerator concentration after analyzing and adjusting the solution for Enstrip EN-86A, EN-86B and pH.

4. Regeneration.

Subtask 70-00-99-809-399

- A. Each day, remove the surface contamination from the tank.
- B. Maintain solution within check limits by addition of appropriate products.
- C. Losses through evaporation will be made up by filling the tank with water up to working level on a daily basis.
- D. Replace the solution if it loses its effectiveness.

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