



ALODINE

PRODUCTS:

<u>Part Number</u>	<u>Description</u>
594015	Alumiprep 33. Cleaner and conditioner for aluminium. 1 gallon bottle. 3 years shelf life. Hazardous material. Corrosive liquid, acidic, n.o.s. (Phosphoric acid, Hydrochloric acid). Class 8, UN 3264, Packing group II.
592939	Alodine 1132. Touch –N-Prep. Pen to cover scratches & smaller areas 2 years shelf life. Environmentally hazardous substances, liquid, n.o.s.. Class 9, UN 3082, Packing group III.
594418	Alodine 1201. Ready to use in 1 gallon bottle. 3 years shelf life. Environmentally hazardous substances, liquid, n.o.s. Class 9, UN 3082, Packing group III.
006798	Alodine 1200S. Powder to mix with water. 20 grams per liter. 16OZ can. 4 years shelf life. Hazardous Material. Chromium trioxide, anhydrous. UN 1463, Class 5.1 (6.1,8). Packing Group II.

Alodine is a strong chemical oxidizer that is used to protect aluminium alloy surfaces from corrosion, and to allow a better bond for the following layer of primer/paint. It is usually brushed on to the aluminium surface and creates an oxide layer that will not corrode and which can be e.g. painted over.

The proper procedure is to first deep clean and brighten the surface with a product called Alumiprep 33. Alumiprep 33 is a non-flammable phosphoric based cleaner, brightener and prepaint conditioner for aluminium. It should not be used on high copper bearing aluminium alloys or on aluminium castings. It can be used either for brush-on or immersion application.

Brush-on application:

For light oxidation and corrosion removal, dilute one part of Alumiprep 33 with five parts of water.
For heavy oxidation and corrosion removal, dilute one part of Alumiprep 33 with two parts of water.

Immersion application:

For each 100 parts of bath, add 25 parts of Alumiprep 33 to 75 parts of water.

The usual process to prepare the surface for a chemical coating consists of the following steps:

- A. Apply the Alumiprep 33 solution for 2 -5 minutes.
- B. Water rinse
- C. Apply the Alodine solution for 2-5 minutes. Do not let it dry before rinsing. Rewet as required.
- D. Water rinse
- E. Dry



Alodine is sold in three forms, all conforming to specification MIL-DTL-81706, Class 1A & 3.

The Alodine 1132 is a “marker” pen. Its tip can be cut to any shape needed and contains enough liquid to treat up to 50 square feet. This is a very environmentally friendly product since it does not require rinsing with water after application, and can be applied after only light sanding of area to be treated, without need for the Alumiprep 33 to be used.

The Alodine 1201 is a ready-to-use solution packed in 1 gallon bottles.

The Alodine 1200S is a powder which, when mixed with water, is the same as Alodine 1201. Mixing ratio : 20 grams powder per liter water.

Here is what the MIL specification means:

M 81706 1 A 2 B

