



PRODUCT INFORMATION



Stellar Solutions, Inc.
4511 Prime Parkway
McHenry, IL 60050
Phone (847) 854-2800
Fax (847) 854-2830
stellar@citrisurf.com
www.citrisurf.com

Technical Data:

Description: *CitriSurf 8050* is a high quality blend of chemicals formulated for the derouging, descaling, and passivation of stainless steel products. *CitriSurf 8050* is specifically designed to provide low cost and efficient removal of all iron oxides and free iron from the surface of stainless steel, providing the highest chrome oxide levels possible.

Physical Properties:

Specific Gravity	1.2
Approx. wt. /gallon	10.0 lb/gal
Viscosity	5 cps
Form	Liquid
Chemical Composition	Citric acid, Phosphoric acid, water, proprietary ingredients
Operating Temperature	Room temp or higher (120-160°F preferred)
Flash Point	None
Water solubility	Complete
Normal working concentration	25% by volume in water
pH at working concentration	approx. 1.0

Packaging: 5 gallon or 55 gallon plastic containers. Larger sizes available upon request.

Application Procedure: To assure best results and help extend the life of the solution, the parts or system to be passivated may be cleaned with an appropriate cleaning solution prior to treatment with *CitriSurf* solution, especially when heavy grease and oils or residue of other materials are present.

All equipment, mixers, tanks and pumps should be clean and dry prior to mixing of *CitriSurf* solution. *CitriSurf 8050* should be mixed with clean water (purified water if desired) at a ratio of **1 part of CitriSurf 8050 with 3 parts of water by volume** to fill the tank or pipe system used so as to fill the clean in place (CIP) loop or adequately cover all parts and surfaces to be treated. Polypropylene, stainless steel, or equivalents should be used for construction of all tanks and devices used in the *CitriSurf* solution. For parts, agitation of the solution in the tank is recommended to attain optimum results. Optimum results can be obtained by using this product in an ultrasonic tank. Optimum results can be obtained with many parts by using *CitriSurf* in an ultrasonic tank.

Heat the solution for optimum performance. 120-160°F is typical. Room temperature is often adequate with increased flow or immersion time. Teflon coated (or equivalent), stainless steel or titanium heating devices are recommended.

Flush the solution through the CIP loop or completely immerse the parts to be passivated in the solution for a period sufficient to remove all free iron and contaminants from the surface. CIP operations are typically run for 30-60 minutes. For parts this is typically 20-30 minutes, depending on temperature, grade of stainless steel, hardness, use of ultrasonics, and the condition of the surface of the parts. Your tests should indicate the best combination of bath parameters for the products you manufacture.

Rinse the CIP loop or parts thoroughly with clean water. Flowing water is optimum. Purified water may be used to prevent water spotting. Dry completely in air immediately. Drying of parts can be accelerated by use of a hot air oven or other drying medium to attain a highly passive surface.

Notes on Use: *CitriSurf 8050* is a Phosphoric Acid and Citric Acid based material, and as such it may cause irritation to exposed surfaces of the body. **See Safety Data Sheet before using this material.**

Maintenance: Replenish the bath with *CitriSurf* and water as appropriate to compensate for dragout, evaporation, and acid consumption. The pH of the *CitriSurf 8050* passivation bath should be held to within +0.1 of its initial value for normal operation.

Disposal: Dispose of according to all federal, state and local regulations.

Storage: *CitriSurf 8050* should be stored at temperatures between 50°F and 120°F in 316 stainless steel or approved plastic containers (polyethylene or polypropylene). (If accidentally frozen, thawing will return product to normal.)

Technical Services: For technical assistance, please contact Stellar Solutions at (847) 854-2800.

Standards: When used correctly, *CitriSurf 8050* meets the requirements of the ASTM A967, ASTM A380, ASTM B600, and AMS 2700 standards.

Testing of your products with *CitriSurf* before using in production is recommended. Every product and production facility is different, and requires testing to ensure that *CitriSurf* is compatible with the particular situation. No warranty is implied, or may be given in writing or verbally without the written permission of Stellar Solutions, Inc.

04/2018

CitriSurf and Stellar Solutions are registered trademarks of Stellar Solutions, Inc., McHenry, IL, USA



Nonfood Compounds
Program Listed A3
139951