

T.C. 259 Deburring Compound

PRIMARY APPLICATION

T.C. 259 is a powdered acidic compound for barrel finishing, deburring (with or without abrasive media), and descaling. It removes heat scale and discoloration from steel stainless steel, brass and copper parts and brightens their surfaces.

CHEMICAL CHARACTERISTICS

Chemical composition	Mixture of organic and inorganic acids with an inhibitor
Physical form	As received: dark brown powder As used: light brown solution
Odor	Slight amine odor
Specific gravity	Not applicable
Bulk density	10.0 lbs/gal
Viscosity	Not applicable
Flash point	None
Hygroscopic tendency	None
Foaming tendency	Moderate
Recommended diluent	Water
Maximum solubility	10 oz/gal at 70°F
Behavior in hard water	No effect
Rinseability	Good
Biodegradable	No
Phosphate-free	Yes
Normal working concentrations	1 to 4 oz/gal of water
Normal operating temperatures	Room temperature (50° to 100°F)
PH at working concentrations	to 11.0 to 1.5 at 70°F
Effect of working concentrations on metals	Rate of metal loss from one-hour immersion is T.C. 259 – 4 oz/gal at 70°F as follows:

<u>Metal</u>	<u>Inched per Year</u>	<u>Description</u>
Brass	.002	Negligible
Stainless	.002	Negligible
Steel	.003	Negligible
Copper	.003	Negligible
Aluminum	.284	Moderate
Zinc	.376	Moderate
Magnesium	.500	Attacks

APPLICATION PROCEDURE

T.C. 259 is used at room temperature (50 to 100°F), 1 to 4 oz/gal with or without abrasive media. Exact concentration, temperature and barrel time will depend upon the degree of cleaning, descaling or deburring required. Because it dissolves quickly, T.C. 259 can be added to the barrel in concentrate form.

Solution Control: Titration factor is 7 mi. using Procedure 4.

NOTES ON USE

T.C. 259 is a highly acidic material and proper handling precautions should be observed. Use acid-resistant solution tanks and barrels.

If T.C. 259 is used in a closed barrel, the barrel should be vented to allow for gas release.

After tumbling in solutions of T.C. 259, steel parts should be neutralized in a Tru-Chem Company, Inc. alkaline solution.

DISPOSAL

Neutralize before discharging into sewage system.

PACKAGING

Packaged in non-returnable fiber drums of 450 lbs. net.

SHIPMENT

May be shipped by any common carrier. Freight classification is "Cleaning Compound, NOIBN, Powder".

STORAGE

Suitable for general indoor storage
Freight classification is "Cleaning Compound".