

ALCLENE TD322-L

ALCLENE TD322-L is a concentrated mildly alkaline surfactant based product, blended for use as an aqueous degreaser in open tumbling or soak tank applications. Optimal performance is enhanced when used with sodium hydroxide (caustic soda). Although designed specifically for cleaning steel, its' use without sodium hydroxide may effectively clean/degrease a variety of metals, including: aluminum, brass and copper alloys. Its formulation provides for excellent removal of oils and grease, preparing the base metal for additional processing in a wide range of finishing cycles. The product does not contain a corrosion inhibitor and use of a secondary inhibitor is recommended for steel parts (and other ferrous metals) that might undergo corrosion following degreasing/cleaning.

Features & Benefits

Rapid, efficient cleaning in open and/or captive tumbling (soak tank) cleaning cycles	Removes stamping, forming, cutting & rust proofing oils
Excellent oil emulsification at recommended operating conditions	Displaces oils on cooling
Reduction of dissolved solids associated with use of powdered cleaners	Very low residual dissolved solids

Physical Data

Appearance	Clear straw free flowing liquid
Odor	Slight
Foaming tendency	Moderate to High
Maximum solubility	Completely soluble – all concentrations

Operating Conditions

Soak Cleaner:

	Range	Optimum
Concentration	2.2-2.6 fl. oz/Gal (1.7-2.0% by volume)	3 fl. oz/Gal (23.4 ml/L)
Temperature	140°F – 160°F (60°C – 88°C)	150-155°F (74°C)
Time	5-10 min	As required
Agitation	Parts tumbling in the solution – open tumble or barrel tumbling	As required

Product Profile

Caustic	No
Phosphate	Yes
Silicate	Yes
Complexors	Yes
Chelates (EDTA, NTA types)	No

Soak Cleaner:

The surfactants and detergents are consumed in the cleaning process by emulsifying oils and grease. Alkaline components are used up in the cleaning process, such as by saponifying fatty acids. Drag out of the cleaner bath also depletes these active components. Regular maintenance additions of ALCLENE TD322-L are recommended to replenish the bath. This can be accomplished by observing quality of cleaning and making appropriate additions per requirements of the process. Alternatively, the cleaner bath can be analyzed to determine actual concentration of ALCLENE TD322-L and the required addition of product to restore the balanced ratio of all the cleaner components.

Waste Disposal

ALCLENE TD322-L and its working solutions are mildly alkaline. They may be neutralized with acid to meet local POTW or municipal effluent discharge requirements. Sludges and oils should be separated out before discharge. Spent ALCLENE TD322-L solutions may contain dissolved metals from the cleaning process. Therefore, additional treatment of the solution may be required.



to meet discharge requirements.

Caution

Consult ALCLENE TD322-L SDS sheet before handling this product.

Hazard Classification

DOT Hazard Class	Not Regulated
DOT Shipping Name	NA
UN Number	
Packaging Group	
Guide Number	

WARRANTY: THE QUALITY OF THIS PRODUCT IS GUARANTEED ON SHIPMENT FROM OUR PLANT. IF THE USE RECOMMENDATIONS ARE FOLLOWED, DESIRED RESULTS WILL BE OBTAINED. SINCE THE USE OF OUR PRODUCTS IS BEYOND OUR CONTROL, NO GUARANTEE EXPRESSED OR IMPLIED IS MADE AS TO THE EFFECTS OF SUCH USE, OR THE RESULTS TO BE OBTAINED.

Our People. Your Problem Solvers.

For more information on this process,
please call us at 203.756.5521 or email: techservice@hubbardhall.com

Hubbard-Hall holds certifications for **ISO 9001:2015**, Responsible Distribution, as accredited by the **ACD** (Alliance for Chemical Distributors) and as a **Women-Owned Small Business**, as well as maintaining an association with **Omni-Chem**¹³⁶.