



Better Chemistry. Better Business.

Stripol™ CBR

Product Code: 2582002
Revised Date: 03/18/2009

Stripol™ CBR

DESCRIPTION

Stripol™ CBR is a dry powder used for stripping electroplated nickel from copper and copper alloys when mixed with water and sulfuric acid. The work may be stripped either in bulk (barrel or basket) or on racks.

Stripol™ CBR will not strip a nickel-iron electroplate or chrome plate. The chrome plate must be stripped in an alkaline, anodic cleaner and then processed through the Stripol™ CBR solution.

The original surface finish of the stripped parts will not be affected by the Stripol™ CBR solution when used in accordance to the recommendations given.

FEATURES AND BENEFITS

- Free flowing non-regulated powder
- No base metal attack
- Easily waste treated
- Long bath life
- Fast stripping rate
- No electrical current required

TYPICAL APPLICATIONS

Removal of electroplated nickel from copper alloys

OPERATING CONDITIONS

Concentration of Stripol™ CBR: 16 oz/gal (120 gms/l)

Concentration of sulfuric acid (66 be'): 3% (volume)

Operating temperature range: 145 - 175f

Preferred temperature: 150f

Ventilation: required 100 cfm per square foot of solution surface



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When stripping bulk parts in a basket, leave at least 5 to 6 inches clearance between the tank bottom and bottom of the basket in order to prevent the parts from coming into contact with the metallic sludge which accumulates there.

Also remove, if possible, parts that have fallen off racks or from baskets, into the Stripol™ CBR solution.

SOLUTION MAKEUP PROCEDURE

1. Fill 2/3 of the tank with cold water.
2. Slowly add the sulfuric acid - note: do not make large sudden additions.
3. Heat the above solution to 130f.
4. Add, with agitation, the 1 lb/gal Stripol™ CBR to the above solution - agitate until the Stripol™ CBR is dissolved.
5. Bring above solution to the final volume and heat to 160f.

EQUIPMENT

Tanks: koroseal, rubber, polyethylene. Do not exceed 150f (66c) if koroseal is used.
Heating coil: quartz, tantalum or lead.

AGITATION

Propeller type agitation is preferred rather than air.

RACKS & BASKETS

Plastisol covered steel, copper, bronze and polyethylene or polypropylene.

STRIPPING CYCLE

1. Immerse in Stripol™ CBR solution until parts become black or brown colored.
2. 1 minute cold water rinse.
3. 1 minute cold water rinse.
4. 30 second immersion in 2 to 3 oz/gal of sodium cyanide at room temperature (removes black coating).
5. 1 minute water rinse.



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STRIPPING RATE

The stripping rate is rather rapid but it varies with the temperature of the solution, concentration of sulfuric acid, concentration of Stripol™ CBR, and the age of the Stripol™ CBR solution.

The stripping rate drops linearly with the amount of nickel dissolved. Approximate rates of a freshly prepared solution is as follows:

At 160f, the Stripol™ CBR solution will dissolve 0.004 inches of nickel per hour.

At 175f, the Stripol™ CBR solution will dissolve 0.007 inches of nickel per hour.

TROUBLESHOOTING

Problem

Cause

Remedy

Low strip rate

improper make-up
low temperature
exhausted stripper
high metal content
excessive plate
thickness
chrome not stripped

check product bulletin
Increase temperature

discard and renew

longer strip time
strip chrome

Problem

Cause

Remedy

Low capacity (many
Of the factors
Causing low rate
Will also affect
The capacity.
Check table above)

high loading factor
(a large number of
small parts can
quickly exhaust a
Small volume of
stripper)

discard and renew

Etching of brass

excessive strip time
high temperature
excessive activator

minimize exposure
lower to 145f.
minimize additions



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To increase stripping rate of a "used solution" when it is at operating range, the following steps should be taken:

1. Add sulfuric acid. The volume may be increased up to 8% (vol).
Note: cool bath to 120f before addition of acid is made.

Also a corresponding addition of Stripol™ CBR must be made approximately 2.4 oz/gal for each 1% (vol) of sulfuric acid.

CAUTION

Solutions of Stripol™ CBR are acid and should be handled with caution. Avoid skin, eye and oral contact. Wear protective clothing, gloves and goggles when handling the product. Flush exposed areas immediately with clean, cold water. Contact a doctor immediately in case of injury.

WASTE DISPOSAL

Neutralize the solution to a ph between 6 to 8 with either soda ash or caustic soda. Add caustic slowly with caution. Wear goggles and protective clothing. Nickel hydroxide or carbonate will precipitate and can be separated from the solution. The solution can then be discharged to the sewer.

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.