



Technologies

TECHNICAL BULLETIN

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TURCO 5668

DIPHASE HOT TANK PAINT REMOVER

1. DESCRIPTION:

TURCO 5668 is a diphasic, liquid paint remover developed without phenols, chromate and chlorinated solvents or acids to remove resistant coatings, such as polyurethanes, acrylics, epoxies and chromated primers.

TURCO 5668 is ideal for the removal of PRC-1560MC and PRC-1560M coatings and is not detrimental to aircraft metals, such as aluminium, titanium, magnesium, cadmium, conversion coatings, Dow coatings and ferrous alloys.

TURCO 5668 is supplied with a built-in non-aqueous chemical seal which retards evaporation and helps minimise drag out losses.

2. BENEFITS:

TURCO 5668 offers these benefits:

1. Does not contain phenols, chromate, chlorinated solvents or acids.
2. Supplied with built-in seal.
3. Easily rinsed from parts with steam, or high pressure water.
4. Ideal for use on multi-layers of paints.
5. Flash point greater than 93°C. COC method.
6. Long tank life through use of additives.

3. USE INSTRUCTIONS:

Equipment:

Tanks and associated equipment may be fabricated from mild steel or stainless steel.

3. USE INSTRUCTIONS (continued)

Preclean

Parts that are contaminated with oils, greases and shop soils should be precleaned to prevent contamination of the remover. Your HENKEL Representative can recommend a suitable precleaner based upon your requirements.

Tank Make-Up:

Add entire contents of container to stripping tank to ensure proper stripper to seal ratio. When less than a full container is required, thoroughly agitate the container prior to making the additions to ensure proper stripper to seal ratio. Heat tank to 65 - 80°C. Maintain the seal layer at a minimum depth of 100 mm at all times by periodic addition of **TURCO 5668 SEAL ADDITIVE** to ensure optimum performance.

Paint Removal:

Immerse parts in **TURCO 5668** making sure the parts are under the seal layer. Maintain tank temperature at 65 - 80°C. Immersion time will vary with different paints and paint thickness. Most paints will be removed from 15 minutes to 1 hour.

Rinsing:

Remove parts from tank and rinse as soon as possible with high pressure tap water or steam.

NOTE: Parts that are to be stored after stripping should be protected from atmospheric corrosion. Your HENKEL Representative can recommend a suitable Turco Rust Preventative based upon your production/storage conditions.

4. CORROSION DATA:

Test Method:

Panels, 1 inch x 2 inch x 0.032 inches thick, fabricated from the below listed metals, were fully immersed in **TURCO 5668** at the stated temperatures and time. Weight changes were determined on an mg/sq. in. basis.

5. TABLE OF WEIGHT CHANGE IN MG/INCH²:

<i>METAL</i>	<i>24 HOURS at 82°C</i>	<i>7 DAYS at 38°C</i>
2024 Bare Al, Chromic Anodised	-0.25 mg	+0.25 mg
2024 Bare Al, Sulphuric Anodised	+0.90 mg	+0.90 mg
7075 Bare Al	+0.20 mg	-0.02 mg
7075 Clad Al	+0.10 mg	-0.05 mg
Magnesium Bare	+0.20 mg	+0.05 mg
Magnesium Dow 7	+0.08 mg	+0.01 mg
Titanium 6, 4	-0.10 mg	- -
Titanium 6, 6, 2	-0.10 mg	- -
1020 Steel	-0.10 mg	-0.02 mg

6. CONTROL:**1. Temperature:**

- 1.1 Maintain the temperature in range of 65 - 80°C. Do not exceed 80°C to avoid loss of volatile ingredients and minimize chemical break down.

2. Liquid Seal:

- 2.1 The depth of the seal should be maintained at a minimum of 100mm thick or in the range of 15 – 17% of the total volume of solution in the tank. Add sufficient Turco 5668 Additive #1 until the proper volume is attained.
- 2.2 The height of the solvent should be adjusted as necessary to ensure that the uppermost point on all parts being cleaned is completely submerged. The parts should be at least 50mm below the bottom of the seal layer.

3. Lower Layer – Alkalinity Test:

- 3.1 The total alkalinity of the solvent is determined by taking a sample of only the lower layer.
- 3.2 Pipette 5.0 mL of the lower layer into a beaker and add 100 mL distilled water.
- 3.3 Titrate with 1.0 N Sulphuric Acid (**Warning!! Check MSDS, wear safety glasses and protective clothing**) to pH 8 using a pH meter.

7. MAINTENANCE

1. Liquid Seal: 100 mm thick or 15 – 17% by volume using **Turco 5668 Additive #1**
2. Alkalinity: 28 – 32 mL Range
 - 2.1 To increase the alkalinity, add 12L of **Turco 5668 Additive #2** 1000 L of lower layer for every 1.0 mL the alkalinity is below 30 mL.
 - 2.2 For each mL above 30 mL, add 30 L of **Turco 5668 Additive #3** per 1000 L of lower layer
 - 2.3 The principal loss of alkalinity will be due to drag-out. Parts should be positioned to minimise drag-out.

8. DISPOSAL INFORMATION:

Dispose of spent solution per local state and regional regulations. Refer to your local Henkel Representative or Henkel Material Safety Data Sheet for additional disposal information.

9. CAUTION:

TURCO 5668 contains potassium hydroxide, amines and paraffin oil. Avoid contact with eyes, skin and clothing. Do not take internally. Use with adequate (equivalent to outdoor) ventilation.

Protective clothing, such as chemical face shield or goggles, gloves, apron and boots, made from solvent resistant neoprene, should be worn when handling and using **TURCO 5668**.

Do not use **TURCO 5668** near open flames or torches since thermal decomposition may produce toxic gases. Do not store containers near strong oxidising agents, nor above 50°C. Open containers with caution to avoid spurting of contents.

Refer to container label or Henkel Material Safety Data Sheet for additional precautionary, handling and first aid information.

10. **NOTICE**

The above information and recommendations concerning this product are based upon our laboratory tests and field use experience. However, since conditions of actual use are beyond our control, any recommendations or suggestions are made without warranty, express or implied. Manufacturer's and seller's sole obligation shall be to replace that portion shown to be defective. Neither shall be liable for any loss, damage, or injury, direct or consequential, arising out of the use of this product.

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