



**Technologies**

## TECHNICAL BULLETIN

ABN: 82 001 302 996  
135-141 Canterbury Road, Kilsyth Victoria 3137  
Phone : (613) 9728 7200 Fax : (613) 9761 7179

# RODINE 50

## 1. DESCRIPTION

**Rodine 50** is a non foaming liquid inhibitor, formulated for use in conventional hydrochloric acid pickling or cleaning operations on mild and unreactive steels. **Rodine 50** is an effective inhibitor for pickling prior to electroplating.

## 2. METHOD OF USE

**Rodine 50** may be added to either concentrated or dilute hydrochloric acid. It is stable for long periods of time in the concentrated acid. It is effective from room temperature to 80°C.

## 3. CONCENTRATION

In conventional pickling operations, **Rodine 50** should be used in the amount of ½% by volume of the concentrated hydrochloric acid, regardless of the degree of acid dilution used in the pickle bath.

In chemical cleaning operations, **Rodine 50** should be used in amounts ranging from 1-2% by volume of the concentrated hydrochloric acid, regardless of the degree of acid dilution used in the pickle bath.

In pre-plating pickle baths, **Rodine 50** should be used in amounts ranging from 1/8 - 1/4% by volume of the concentrated hydrochloric acid, regardless of the degree of acid dilution used in the pickle bath.

## DISCLAIMER

Any information given is, to the best of our knowledge, the best currently available, with respect to our products and their use, but it subject to revision as additional knowledge and experience is gained. Such information is offered as a guideline for experimentation only and is not to be construed as a representation that the material is suitable for any particular purpose or use. Customers are encouraged to make their own enquiries as to the material's characteristics and, where appropriate, to conduct their own tests in the specific context of the material's intended use. This information is not a license to operate under nor is it intended to suggest infringement of any patent. We guarantee a uniform quality standard for this product. The only conditions and warranties accepted by Henkel in relation to this product or process are those implied by either Commonwealth or State statutes.

# RODINE SAVES ACID AND IRON

## PICKLE LOG

DEPARTMENT : \_\_\_\_\_

WEEK OF : \_\_\_\_\_, 20\_\_

	SUNDAY		MONDAY		TUESDAY		WEDNESDAY		THURSDAY		FRIDAY		SATURDAY					
	A.M.	PM	A.M.	P.M.	A.M.	P.M.	A.M.	P.M.	A.M.	P.M.	A.M.	P.M.	A.M.	P.M.				
TEMPERATURE	110	11	22	4	8	12	4	8	4	8	12	4	8	4	8	12	4	8
PERCENT	100	10	20	4	8	12	4	8	4	8	12	4	8	4	8	12	4	8
IRON	90	9	18	4	8	12	4	8	4	8	12	4	8	4	8	12	4	8
ACID	80	8	16	4	8	12	4	8	4	8	12	4	8	4	8	12	4	8
RODINE	70	7	14	4	8	12	4	8	4	8	12	4	8	4	8	12	4	8
PERCENT	60	6	12	4	8	12	4	8	4	8	12	4	8	4	8	12	4	8
IRON	50	5	10	4	8	12	4	8	4	8	12	4	8	4	8	12	4	8
ACID	40	4	8	4	8	12	4	8	4	8	12	4	8	4	8	12	4	8
RODINE	30	3	6	4	8	12	4	8	4	8	12	4	8	4	8	12	4	8
PERCENT	20	2	4	4	8	12	4	8	4	8	12	4	8	4	8	12	4	8
IRON	10	1	2	4	8	12	4	8	4	8	12	4	8	4	8	12	4	8
ACID	0	0	0	4	8	12	4	8	4	8	12	4	8	4	8	12	4	8
RODINE				4	8	12	4	8	4	8	12	4	8	4	8	12	4	8

**ADDITIONS AND TONNAGE**

		TURN 1	TURN 2	TURN 3	TOTAL	TURN 1	TURN 2	TURN 3	TOTAL	TURN 1	TURN 2	TURN 3	TOTAL	TURN 1	TURN 2	TURN 3	TOTAL
ACID	TURN 1																
	TURN 2																
	TURN 3																
	TOTAL																
RODINE	TURN 1																
	TURN 2																
	TURN 3																
	TOTAL																
ADDITIONS OTHER	TURN 1																
	TURN 2																
	TURN 3																
	TOTAL																
TONNES PICKLED	TURN 1																
	TURN 2																
	TURN 3																
	TOTAL																

**SUMMARY FOR WEEK**

1	TOTAL ACID		Kg	5	TONNES PICKLED		Kg	
2	ACID DUMPED		Kg	6		Kg ACID PER TONNE TOTAL, 1 ÷ 5 =		Kg
3	ACID CONSUMED, 1 - 2 =		Kg	7		Kg ACID CONSUMED PER TONNE, 3 ÷ 5 =		Kg
4	TOTAL RODINE ADDED		Kg or Litre	8		RODINE PER TONNE TOTAL, 4 ÷ 5 =		Kg or Litre

**DIRECTIONS**

Plot on chart at regular intervals acid concentrations, iron content and temperature of pickle bath.  
 Keep an accurate record of additions of acid, Rodine, salt, Foaming Compound, etc., if added, and the tonnage pickled so the consumption of the acid and Rodine per tonne can be accurately calculated for each work week.  
 To prevent wasting acid use Rodine and exhaust acid in the spent bath as far as possible before dumping it.