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Technical Data Sheet • CHEMEON® Organic Dyes

Description:

CHEMEON offers a full range of organic dyes for anodized aluminum. This Technical Data Sheet contains information on the following CHEMEON Dyes.

- Graphite
- Gray
- Gray GL

Operating Conditions:

Method of Application:	Immersion
Concentration:	Varies with dye – See color sample
Immersion time:	2 - 15 minutes depending on desired color
Temperature:	120 – 140 °F (50 – 60 °C)
pH:	Varies with dye
Water:	Use low hardness water or deionized water.
Tank:	Stainless steel or other acid resistant material, which is stable to 150 °F

Graphite
pH: 5.2-6.0
Concentration 0.5 g/L
Time: 2 min

Recommendations for make-up and maintenance:

1. Deionized water or high quality tap water should be used for make-up.
2. The water should be heated to 180 °F on makeup to ensure that the dye dissolves completely, then cooled down to 130 °F.

Gray
pH: 6.0-7.0
Concentration: 2 g/L
Time: 15 min

Typical anodizing parameters:

Thickness	0.5 mil
Current density	12 amps/ft ²
Tank temperature	70 °F (21 °F)
Tank chemistry	180 – 200 g/L sulfuric acid 4-12 g/L aluminum ions

Gray GL
pH: 5.0-5.5
Concentration: .5 - 6 g/L
Time: 5 - 20 min



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Seal parameters: CHEMEON Seal 6100

Temperature: 160-190°F

Immersion Time: 10-20 minutes

A mid-temperature nickel seal is recommended to seal the anodic coating and set the dye.

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