

## 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.

- Coppertone
- Deep Bronze

### Operating Conditions:

Method of Application:	Immersion	
Concentration:	Varies with dye – See color sample	Coppertone pH: 5.5-7.0 Concentration: 1 g/L Time: 5 min
Immersion time:	5 - 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	Deep Bronze pH: 5.5-6.0 Concentration: 5 g/L Time: 10 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.

### Typical anodizing parameters:

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



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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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