

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.

- Burnt Orange
- Golden Orange
- Orange Concentrate

Operating Conditions:

Method of Application:	Immersion
Concentration:	Varies with dye – See color sample
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

Burnt Orange
pH: 6.8-7.2
Concentration: 2 g/L
Time: 10 min

Golden Orange
pH: 6.8-7.2
Concentration: 2 g/L
Time: 10 min

Recommendations for make-up and maintenance:

For best results, warm the water to operating temperature prior to adding the dye to the tank. Allow the dye to completely dissolve prior to use.

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

Orange Concentrate
pH: 6.0-7.0
Concentration: 2 g/L
Time: 10 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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