

## OrcoAluminum™ Brown OR

OrcoAluminum™ Brown OR is a medium shade brown with a reddish-brown hue with very good light fastness.

### Features:

- RoHS Compliant
- Metal free anthraquinone
- Stable color
- Minimal bleeding during sealing
- pH Stabilized chemistry

### Operating Parameters:

Concentration: 1 to 3 g/l  
pH: 5.5 to 5.8  
pH Adjustment: With dilute 10% conc. acetic acid or sodium hydroxide  
Temperature: 130°F to 150°F  
Time: 1 to 3 min

### Operating Procedures

Maintain pH and concentration for color reproducibility from load to load. A dilute nitric acid rinse of 5 to 10% at ambient temperature will produce uniform color.

### Analysis

Maintain concentration with visual analysis against standard concentrations or analysis of solution by spectrophotometer according to ORCO Dye Analysis Document. Please consult your technical representative.

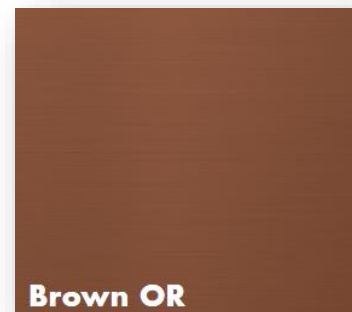
### Handling and Environmental

This is a metal free dye. Please handle in accordance with local regulations.

### Dye Bath Analysis

1. Use a fixed wave Spectrophotometer and set to the wavelength of least transmission (ORCO will supply that wavelength number for each color)
2. Make known standards of regular concentration, 50% below that number and 50% above that number in grams/liter
3. Pipette 5 ml of each of the standard into 1000 ml volumetric flask
4. Read the transmission vales of each of the know standards
5. Plot a curve using the transmittance values and the corresponding concentration
6. Pipette a 5 ml sample of the process dye bath and dilute to 1000 ml in a volumetric flask
7. Read the transmittance of the dye and using the graph plotted above determine the concentration of the dye.

Actual dye samples must be evaluated in a laboratory in the chemical system or medium in which they are to be used for accurate shade and physical property results. Shades shown on print material and computer monitors are for general reference only as they are inherently inaccurate due to calibration variations and technical limitations of monitors and printers. Revised 1219 RY



# Technical Bulletin

## Anodizing Dyes



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