

POLIGRAT-PRODUCT INFORMATION

POLIGRAT E 520



Electropolishing of iron and steel

Properties and effect

The electropolishing process **POLIGRAT E 520** is suitable for workpieces made from iron and mild steel. The surface becomes bright, burr-free, clean and smooth on a microscopic scale. **POLIGRAT E 520** is free from hexavalent chromium.

Depending on the alloy and structure, the workpieces can be polished bright to satin finish. Alloyed and hardened tool steels can be deburred

POLIGRAT E 520 removes affected material surfaces without mechanical, thermal and chemical impact and develops the pure properties of the material.

Application

POLIGRAT E 520 can be applied by immersion or run through process. Immersion method for smaller parts is in baskets, suspension jigs and the POLIBOX. Partial electropolishing processes use moving cathodes. Pumping through is suitable for long drill holes and tubes.

POLIGRAT E 520 and the rinsing water from the process are acidic and contain heavy metal. They have to be treated and disposed of according to the statutory laws and regulations.

Technical data

Specific weight/density:	1.18 – 1.24 g/ml
Voltage:	12 to 24 V
Current density:	3 to 30 A
Process temperature:	+25 to +50°C
Application time:	0.5 to 30 minutes
Conductivity at 30 °C:	10 to 25 mS/cm

Supply

The electrolyte **POLIGRAT E 520** is delivered in 2 components:

POLIGRAT E 520 KA and **POLIGRAT E 520 KB**.

Required chemicals for 100 litres **POLIGRAT E 520** bath ready for use:

- 30 l **POLIGRAT E 520 KA**
- 70 l **POLIGRAT E 520 KB**

POLIGRAT E 520 is supplied in following packing units:

POLIGRAT E 520 KA

- Single-use canister 15 kg (9.78 l)
- Single-use canister 40 kg (26.12 l)

POLIGRAT E 520 KB

- Single-use canister 10 kg (8.54 l)
- Single-use canister 35 kg (30.32 l)

Your Advantages

- free of chromic acid
- burr-free, micro-smooth and metallically clean surfaces
- ideal for a wet to wet galvanic coating