

## PRODUCT INFORMATION

POLIGRAT E 520

Electropolishing of iron and steel

**POLIGRAT**  
DEUTSCHLAND GMBH



### Properties and effect

The electropolishing process POLIGRAT E 520 is suitable for workpieces made from iron, mild steel but even stainless 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.

### Technische Daten

- ▶ 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 bis 25 mS/cm



### Your Advantages

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

### Supply

The electrolyte POLIGRAT E 520 is delivered in 2 components:

- ▶ POLIGRAT E 520 KA
- ▶ POLIGRAT E 520 KB

Required chemicals for 100 liters POLIGRAT E 520 bath ready for use:

- ▶ **POLIGRAT E 520:**
  - ▶ 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
  -  40 kg (26,12l)
  -  15 kg (9,78 l)
- ▶ POLIGRAT E 520 KB
  -  35 kg (30,32 l)
  -  10 kg (8,54 l)

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