

Cee-Bee[®] A-480

Cee-Bee[®] A-480 is a water-based, heated, immersion solvent cleaner specifically designed to remove carbon and other tenacious soils from turbine engine components. Cee-Bee[®] A-480 can be used as an alternative or subsequent cleaning process to light-duty aqueous degreasing when used as directed.

Conforms To

- Pratt & Whitney
 - SPMC 183-3
 - SPS 183-3
 - SPOP 207

Benefits

- Effective in removing carbon and fuel/oil residues from hot section turbine engine components by immersion using mechanical agitation.
- Used at moderate temperature.
 - 130-140°F (54-60°C)
- Safe on most turbine engine alloys, including aluminum, magnesium, carbon steel, stainless steel and heat-resistant alloys.
- Contains no chrome, phenol, terpenes, heavy metals or chlorinated solvents
- Long and effective bath life.
- Safe on aluminum, titanium, steel, nickel and cobalt and their alloys.
- All ingredients are REACH compliant.

Properties

- Yellow in color
- Surfactant odor

Notes Prior to Handling

Before using your Cee-Bee[®] products, all safety and operating instructions should be read and understood. If you have any questions, please contact your Cee-Bee[®] representative before proceeding.

Use Procedure

Equipment

- Tanks constructed of #300 series stainless steel are recommended.

Remove Carbonaceous Soils

1. Pre-clean part(s) with an aqueous cleaner (Super Bee™ 300LF/G or Cee-Bee® A-7X7) to remove greases and oils and other contaminants using one of the approved aqueous degreasing and rinsing methods. Rinsing the part(s) with a high-pressure spray wand will help remove any loosened contaminants. Pre-cleaning helps prolong the bath life of Cee-Bee® A-480.
2. Immerse the part(s) fully in Cee-Bee® A-480 with mechanical agitation at 130-140°F (54-60°C) for 30 minutes up to two hours, depending on the degree of contamination.
3. Raise the part(s) slowly from the Cee-Bee® A-480 solution and allow time for parts to drain. Spray rinse the part over the Cee-Bee® A-480 solution using a fine mist spray or an air-assisted nozzle to minimize the amounts of water added to the solution tank.
4. Immerse the part(s) in a clean, cold water rinse tank, then pressure spray rinse the part(s).
 - a. If the part(s) is clean, finish by immersing fully in a clean, hot water rinse tank at 150-200°F (66-93°C) until the temperature of the part is at the water temperature in order to facilitate flash drying of the part(s).
 - b. If the part(s) is not clean, repeat steps 1-4 above, but do not exceed the total process time in Cee-Bee® A-480 of four hours.
5. If necessary, scrub part(s) with a stiff-bristled brush under hot running water to remove any remaining carbon deposits.
6. Rinse again by immersing fully in a clean, hot water rinse tank at 150-200°F (66-93°C) until the temperature of the part is at the water temperature in order to facilitate flash drying of the part(s).
7. To prevent flash rusting of steel parts, apply corrosion inhibiting compound as directed by the OEM's Standard Practice Manual.

Note:

- Cee-Bee® A-480 may soften or remove some paints.

Solution Control

- Maintain the working level of solution to replace drag out loss by making additions of fresh Cee-Bee[®] A-480 to the tank.
- To determine the concentration of Cee-Bee[®] A-480 baths at the shop level, use a hand-held refractometer with a 0-30 Brix scale.

Prepare A Standard Solution

1. Pull a fresh (as-received) sample of Cee-Bee[®] A-480 from its shipping container. The sample should be at room temperature.
2. In a 10 ml graduated cylinder, add Cee-Bee[®] A-480 up to the 5.0 ml mark. Fill the rest of the graduated cylinder with deionized water. Mix well.
3. Transfer one or two drops of this solution to the inclined rectangular window of the refractometer. Immediately close the plastic cover over the window.
4. Point the refractometer toward a strong light source and read the refraction value on the scale of 0 to 30 units (Note: Clean water will read -0.0-).
5. Record this value as Standard Reading
 - a. **Note:** The value should be close to 21.0 – 22.0.

Analyze Sample Solution

1. From an agitated, heated in-service solution, pull a sample of the Cee-Bee[®] A-480 from center of the bath and allow it to cool to room temperature (72°F / 25°C).
2. In a 10 ml graduated cylinder, add the Cee-Bee[®] A-480 bath sample up to the 5.0 ml mark. Fill the rest of the graduated cylinder to 10 ml with deionized water. Mix well.
3. Transfer this solution to the inclined rectangular window of the refractometer. Immediately close the plastic cover over the window.
4. Point the refractometer toward a strong light source and read the refraction value on the scale of 0 to 30 units.
5. Record this value as Sample Reading.

Calculations

$$100 - (100 \times [(Standard Reading - Sample Reading)]) = \% \text{ by volume of Cee-Bee}^{\text{®}} \text{ A-480.}$$

- Maintain the bath between 85-100% by volume by making additions of Cee-Bee[®] A-480.
- **Note:** Some loss of accuracy may occur in the refractive reading over time as soils accumulate in the bath. Once the bath has been in use, it will never actually be at 100% due to water dilution.

Safety, Handling, and Precautions

- **WARNING!** Avoid contact with eyes, skin and clothing.
- Cee-Bee[®] A-480 causes severe eye irritation and may cause skin irritation.
- Harmful if swallowed.
- Refer to the Cee-Bee[®] A-480 Safety Data Sheet for more details.
- Use with adequate ventilation, which is typically push/pull air agitation over the tank.
- Avoid breathing mists by wearing a NIOSH-approved organic filter respirator.
- Proper Personal Protective Equipment (PPE), such as a chemical face shield or chemical goggles, apron, boots and gloves made from solvent resistant material (neoprene) should be worn when using Cee-Bee[®] A-480.

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