

Cee-Bee[®] J-89

Cee-Bee[®] J-89 is a highly alkaline powder used for conditioning heat scale on titanium alloys prior to pickling.

Conforms To

- Airbus
 - CML 11-033
- ARP
 - 1555A
- ASTM
 - ASTM-F-945
- International Aero Engines
 - CoMat No. 01-042
 - CoMat No. 01-472
- Rolls Royce
 - OMat 1/170B

Benefits

- Conditions heat scale on ferrous, magnesium and titanium alloys prior to removal by acid pickling.
- Serves as a lower temperature substitute for molten salt baths.
- Safe on steel, cast iron, noble metals, super alloys, magnesium alloys and titanium.

Properties

- Free flowing powder
- Yellow in color
- Highly Alkaline

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 Recommendation

- Use 316 stainless steel tanks and heaters.
- Mechanical agitation is beneficial.
- Daily additions of water to make up evaporation loss. In hard water areas soft water is recommended.

Use Procedure

1. Fill tank about one-half full with water, then sprinkle in Cee-Bee[®] J-89 with continuous agitation. A lot of heat will be generated, so add powder slowly and cautiously to avoid boiling and splattering. After powder is completely dissolved and free of lumps, add remaining water with continuous mixing.
2. Immerse parts in a 5.0 lb/gal. (600 g/liter) bath at 190-210°F (88-99°C) for 15 to 30 minutes.
3. Remove parts and allow excess solution to drain back into the tank.
4. Rinse with a light mist of water over the tank to reduce dragout loss.
5. Dip in an air agitated, overflowing, clear water rinse tank.
6. Remove conditioned scale in a suitable acid pickling bath.

Safety, Handling, and Precautions

- **WARNING!** Contains sodium hydroxide and chromate.
- Can cause severe burns.
- Avoid eye and skin contact. Wear face shield, apron, gloves and boots.
- Use adequate ventilation.
- Do not breathe spray mist.
- Do not take internally.
- In case of contact with eyes or skin, flood with water. If irritation persists, seek medical attention.
- Bath will etch zinc, lead and aluminum. When contaminated with these metals, bath effectiveness is greatly reduced and, in some cases, will deposit a tenacious black smut on steel parts. If excessive sludge buildup occurs, dump tank and recharge with fresh material.



Solution Control

- Periodic additions of Cee-Bee[®] J-89 to replace dragout loss and active ingredient consumed during the normal cleaning process.
- To determine bath concentration, based on alkalinity, use the following procedure.
- Sludge will accumulate on the bottom of the tank when bath is used frequently. Periodic desludging will extend useful life of the bath.

Analysis Procedure

1. Place 2 mls of bath into a 250 ml Erlenmeyer flask.
2. Add approximately 100 mls of DI water and 2 to 3 drops phenolphthalein indicator solution. For very dark tank solutions additional phenolphthalein indicator solution may be required to clarify the end point.
3. Titrate with 1N acid until pink color disappears.

Calculations

$$\begin{aligned} \text{ml. acid} \times 0.172 &= \text{lbs./gal. Cee-Bee}^{\text{®}} \text{ J-89} \\ \text{ml. acid} \times 20.61 &= \text{g/ liter Cee-Bee}^{\text{®}} \text{ J-89} \end{aligned}$$

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