



## Specialty Bordeaux R

Aluminum Dye

### 1. Description

Specialty Bordeaux R is a single component, water soluble dye, used to color anodized aluminum strawberry red.

- RoHS compliant
- REACH compliant

### 2. Application instructions

|                    |   |
|--------------------|---|
| Concentration:     | 2-6 g/l   |
| pH:                | 5.0-6.0   |
| Buffering:         | Not required  |
| Temperature:       | 135-145°F / 57.22-62.77°C   |
| Coating thickness: | 0.50 mils. or greater   |
| Dye time:          | Depending on the shade desired, dye times could range from 10-20 minutes, but can only be determined by sampling in plant production. |
| Preferred sealing: | Specialty Sealant MTL<br>Specialty Sealant  |

### 3. Conditions for using Specialty Bordeaux R

|                 |   |
|-----------------|---|
| Tank:           | Stainless steel or other acid resistant materials such as neoprene, polyethylene and polypropylene that can withstand a constant operating temperature of 135-145°F.  |
| Water quality:  | Deionized   |
| pH adjustments: | Raise with sodium hydroxide.<br>Lower with acetic acid.<br><br>The pH should be checked once per shift with a calibrated meter and maintained within recommended range.   |
| Bath agitation: | Mild agitation must be used for high uniformity of color.   |
| Rinsing:        | It is important to remove all acid residues clinging to the work and acid retention in the oxide pore itself. Rinse work load thoroughly after anodizing. A minimum of two rinses is recommended, with the second rinse at over-flow.<br><br>To increase rinsing effectiveness, add vigorous air agitation in all rinse tanks. This also improves your rinsing of surfaces on complicated shaped parts. |

#### 4. Lightfastness

Rating: 3-5 (1=poor, 8=excellent)

This color is not recommended for outdoor applications or other situations where it is subjected to intense UV radiation.

#### 5. Storage

Store in original container in a cool dry location.  
Close package tightly after removal of dye.  
In humid environments, dye powder may clump-up.

#### 6. Preparation of a new dyebath

1. A cleaned tank is filled with deionized water to about 75% of final volume and raised to dyeing temperature.
2. The required amount of dye is weighed out and dissolved in hot deionized water (160-180°F) in a separate container until a slurry is formed. This is your stock solution.
3. With agitation turned on in tank, pour stock solution into tank.
4. Top off the tank to final working solution volume with more hot deionized water and agitate for 15 minutes.
5. Using a calibrated pH meter, check the pH and adjust if necessary.
6. The dyebath is brought to dyeing temperature, 135-145°F.

#### 7. Conversion factor

Converting grams per liter (g/l) to ounces per gallon (oz/gal)

$$\text{g/l} \times 0.134 = \text{oz/gal}$$

#### 8. Dyebath concentration determination

Dyebath concentration can only be determined by spectrophotometric analysis. Full instructions are available upon request.

#### 9. Product safety

We recommend that the company/operator read and review the **Safety Data Sheet** for the appropriate health and safety warnings before use.

U.S. Specialty Color Corporation® recommendations, notices or instructions as to handling, use, storage of any product, including its use alone or in combination with other products, or as to any apparatus or process for the use of any product, are based upon information believed to be reliable, but U.S. Specialty Color Corporation® shall have no liability with respect to any recommendations or instructions. U.S. Specialty Color Corporation® sole and exclusive warranty is that its products comply with U.S. Specialty Color Corporation® published chemical and physical specifications. U.S. Specialty Color Corporation® makes no other warranties, other express or implied with respect to its recommendations, instructions, products, apparatus, and process or otherwise and specifically disclaims any implied warranties of merchantability, suitability, fitness for a particular or otherwise.