

Approvals and conformities

AIRBUS France	IPDA 62-03, 62-16, 62-02, 62-21, 62-23, 27-05
AIRBUS Group	AIPI 02-01-003, 02-01-002, 02-05-001
AIRBUS UK	ABP8-1296
DASSAULT AVIATION	DGQT 0.4.2.0027 indice U
EADS CASA	Z-23321
TURBOMECA	CCT 00508, CCT 00608
AIRBUS HELICOPTERS	ECA 3135.35 (Socosurf A1806), ECA 3135.20 (Socosurf A1858), ECA 3135.10 (Socosurf A1850)
THALES ALENIA SPACE	TASI-SG-QTR-0001
BOEING	BAC 5765 PSDS 6-235
SAFRAN	Pr-1030, Pr-1038
BOMBARDIER	BAPS 180-032 rev B

The SOCOSURF A1858/1806 bath is designed for the etching, de-smutting and deoxidation of aluminium and its alloys after alkaline treatment.

- The SOCOSURF A1858/1806 bath is used by immersion. For use by spraying, refer to the tds of "SOCOSURF A1858/A1806 WS" mix.
- It is especially suited for use prior to chromic conversion or solgel treatment such as SOCOGEL, anodising, penetrant inspection, chemical milling, bonding and welding operations.
- SOCOSURF A1858 can be used alone when the subsequent treatments are not critical.
- As it is free from hexavalent chromium and fluoride ions product handling and waste treatment are easier and lower cost. It complies with current environmental and safety requirements
- The absence of fluoride provides a homogeneous attack on alloys and provides stability to the bath and its performance.
- SOCOSURF A1858 is the acid concentrated part for setting up the etching deoxidizing bath.
- SOCOSURF A1806 is the part essential to give all its characteristics to the treatment bath.
- All the bath active components can be readjusted either by adding products used for the setting up or by adding SOCOSURF A1850 or SOCOMUL TA to lengthen the bath life and maintain its performance.
- SOCOSURF A1850 is an acid additive.
- SOCOMUL TA is an additive which allows readjustment of the the bath surface tension.

DIRECTIONS FOR USE

BATH SET-UP

The tank, pumps and pipes must be made of stainless steel 316 L or acid resistant plastic. The SOCOSURF A1858/A1806 bath is not compatible with lead.

BATH CONCENTRATION FOR SETTING-UP

SOCOSURF A1858 = 30 to 50%
SOCOSURF A1806 = 6 to 15%
Demineralised water = 35 to 64%

- Fill the tank up to 40% in volume with demineralised water at ambient temperature.
- Start the bath agitation.
- Add the calculated volume of SOCOSURF A1858.
- Add the calculated volume of SOCOSURF A1806.
- Top up with the remaining demineralised water to the required volume.

Be careful to avoid splashes when adding product.

PREPARATION

Before SOCOSURF A1858/1806 treatment, degrease parts in a degreasing bath type SOCOCLEAN A3432.

TREATMENT

- The SOCOSURF A 1858/1806 bath is used by immersion between 40°C and 60°C (104°F and 140°F).
- The contact time varies from 1 to 10 minutes according to alloy and metal.
- Agitate the bath to improve the process (mechanical or air agitation).
- Rinse with recirculated water and/or demineralised water. A final rinsing with demineralised water can be carried out.

PROCESS TO USE SOCOSURF A1858/A1806

- **Scenario 1.** Alkaline degreasing SOCOCLEAN A3432 > rinsing > alkaline treatment > rinsing > SOCOSURF A1858-A1806 > Rinsing > Treatment (chromic conversion, anodising...)
- **Scenario2.** Alkaline degreasing SOCOCLEAN A3432 > rinsing > SOCOSURF A1858-A1806 > Rinsing > Treatment (chromic conversion, anodising...)

TECHNICAL CHARACTERISTICS

SOCOSURF A1858 appearance	clear liquid
SOCOSURF A1806 appearance	clear liquid
SOCOSURF A18850 appearance	clear liquid
SOCOMUL TA appearance	clear liquid
SOCOSURF A1858 colour	colourless to yellow
SOCOSURF A1806 colour	dark brown
SOCOSURF A1850 colour	colourless to yellow
SOCOMUL TA colour	colourless
SOCOSURF A1858 specific gravity	1.4
SOCOSURF A1806 specific gravity	1.5
SOCOSURF A1850 specific gravity	1.3
SOCOMUL TA specific gravity	1
SOCOSURF A1858 undiluted pH	< 1
SOCOSURF A1806 undiluted pH	< 1
SOCOSURF A1850 undiluted pH	< 1
SOCOMULTA undiluted pH	7.0

PRECAUTIONS FOR USE AND STORAGE

For more information regarding the danger of the product, please consult the product safety data sheet according to local regulation before using SOCOSURF A1858, A1806, A1850 and SOCOMUL TA..
For professional use only.

This technical data sheet replaces and cancels the previous one.

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