

### Approvals and conformities

AIRBUS DEFENCE & SPACE	IDP 072 / Z-23321
AIRBUS France	IPDA 62-03,62-16,62-02,62-21,62-23,27-05
AIRBUS Group	APII 02-01-003, 02-01-002, 02-05-001
AIRBUS HELICOPTERS	ECA 3135.35 (Socosurf A1806), ECA 3135.20 (Socosurf A1858), ECA 3135.10 (Socosurf A1850)
AIRBUS OPERATIONS SPAIN	IDP 072 / Z-23321
AIRBUS UK	ABP8-1296
BOEING	BAC 5765 PSDS 6-235
BOMBARDIER	BAPS 180-032 rev B
DASSAULT AVIATION	DGQT 0.4.2.0027 indice U, DGQT 0.4.2.0415
LEONARDO AIRCRAFT	NTA 73557 (Sealing after TSA anodizing)
LEONARDO AIRCRAFT	NTA 72278 (Conversion)
LEONARDO HELICOPTERS	AWPS015T (Conversion)
PILATUS AIRCRAFT	Procedure VV 0602 – 10 D
SAFRAN	Pr-1030, Pr-1038
SAFRAN HELICOPTER ENGINES (formerly TURBOMECA)	CCT 00508, CCT 00608
THALES ALENIA SPACE	TASI-SG-QTR-0001

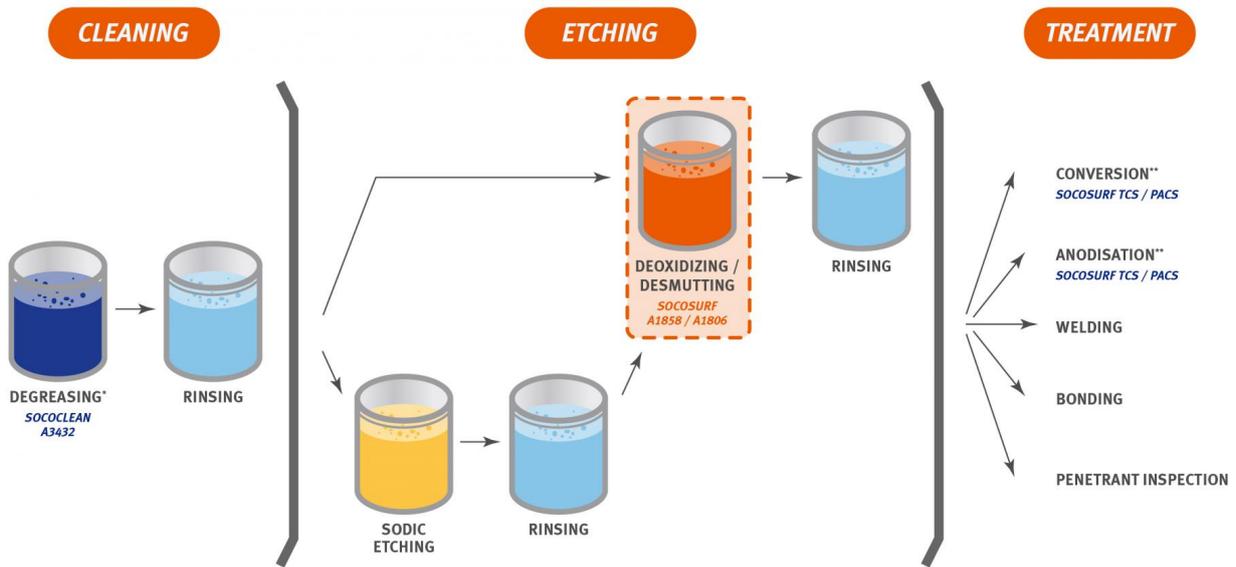
**SOCOSURF A1858/A1806** is a REACH compliant **fluoride- and chrome-free** deoxidant and neutraliser (after sodic etching) for aluminium alloys. A process used before anodizing, conversion, bonding, penetrant testing or welding.

### Advantages / Benefits :

- As the product does not contain fluoride the attack rate is stable over time. It is not necessary to adjust the attack rate with additives, or to change the immersion time.
- Improves the overall performance of the surface treatment process, especially for conversion and anodization
- Approved by many OEMs: it enables use of the bath to be optimised for different OEMs and limits authorisation procedures with these OEMs

The stability and performance of the bath allow its working life to be extended and its renewal frequency to be reduced, hence reducing the associated operating costs.

Process type :



\* DEGREASING IS POSSIBLE WITH **SOCOCLEAN A3432** (REFER TO TDS).  
 \*\* CONVERSION & SEALING AFTER ANODIZING ARE POSSIBLE WITH **SOCOSURF TCS / PACS** (REFER TO TDS).

Characteristics :

- **SOCOSURF A1858** is the part concentrated in acids for the assembly of the deoxidizing bath.
- **SOCOSURF A1806** adds additional elements into the bath to ensure its performance and stability.
- All the active elements in the bath can be adjusted by the addition of assembly products and also by **SOCOSURF A1850** and **SOCOMUL TA** additives to extend the working life of the bath and maintain its performance.
- **SOCOSURF A1850** is an acid additive.
- **SOCOMUL TA** is an additive for adjusting the surface tension of the bath allowing an even attack of the surface.
- The **SOCOSURF A1858/A1806** is used by immersion. For spray application, refer to the "**SOCOSURF A1858/A1806 WS**" data sheet.
- **SOCOSURF A1858** can be used alone if the following treatments are not critical, and depending on the qualifications
- The absence of fluorides stabilises the bath and its performance.
- It is chrome 6- and fluoride-free. This facilitates product handling and waste processing. It satisfies current HSE requirements in force.

## DIRECTIONS FOR USE

### BATH SET-UP

Equipment and recommendations :

- The equipment constituting the tank, pumps, pipes and heating elements will necessarily be made of materials resistant to hot acids, such as stainless steel 316 L, PVDF and Teflon.
- The **SOCOSURF A1858/A1806** bath is not compatible with lead.

## BATH CONCENTRATION

	Recommended set-up concentrations*	Recommended working concentrations*
SOCOSURF A1858	40% v/v	35-50 % v/v
SOCOSURF A1806	10% v/v	6-15 % v/v

\* Or refer to the OEM requirements

## IMPLEMENTATION INSTRUCTIONS

- Fill the tank up to 30% 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**.
- The **SOCOSURFA1858/A1806** bath can also be used to neutralise/desmut surfaces after sodic etching.

## TREATMENT

- The SOCOSURF A 1858/1806 bath is used by immersion between 40°C and 60°C (104°F and 140°F), ideally at 50°C (122°F)
- The contact time varies from 1 to 10 minutes according to alloy and metal. Pleaser refer to the OEM requirements.
- Recommended agitation : mechanical or air agitation.
- Rinsing with recirculated water and/or demineralised water is required. Prefer an acid pH (<3) in the first rinsing tank. A final rinsing with demineralised water can be carried out.

## TECHNICAL CHARACTERISTICS

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	<b>SOCOSURF A1858</b>	<b>SOCOSURF A 1806</b>	<b>SOCOSURF A1850</b>	<b>SOCOMUL TA</b>
Appearance	Colourless to yellow clear liquid	Colourless to brown clear liquid	Colourless to yellow clear liquid	Colourless to yellow clear liquid
pH undiluted	<1	<1	<1	7
Specific gravity	1.425	1.51	1.325	1.01

## ***PRECAUTIONS FOR USE AND STORAGE***

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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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