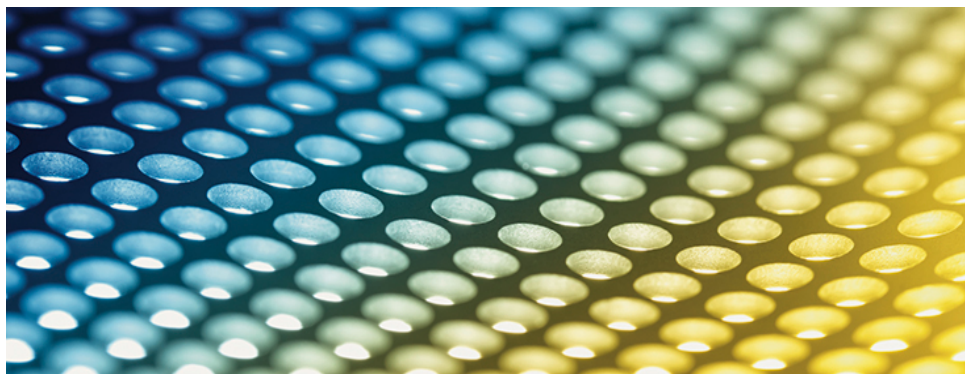


**SANODURE®
ORANGE RL**



HOMOGENEOUS, WATER SOLUBLE DYESTUFF FOR THE ADSORPTIVE DYEING OF ANODIZED ALUMINUM

The main applications for Sanodure Orange RL are:

- Indoor
- Jewellery

Only recommended for interior use.

1. DYE-SPECIFIC DATA

Commercial form:	Fine granules
Chemical character:	Azo-dyestuff, unmetallized
Density:	700 g/l
Solubility in water:	40 g/l at 20 °C
Storage stability:	10 years
Ecotoxicological data:	See safety data sheet

CLARIANT INTERNATIONAL LTD

Rothausstrasse 61
4132 Muttenz
Switzerland

BUSINESS UNIT PIGMENTS
MARKETING AND SALES PLASTICS
AND SPECIAL APPLICATIONS

Phone +41 (0)61 469 79 45
Fax +41 (0)61 469 75 40

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2. APPLICATION CONDITIONS

Concentration, dyeing temperature and time

	CONCENTRATION g/l	DYEING TEMPERATURE °C	DYEING TIME min
Bright shades	0.05-0.2	25-60	10-20
Medium shades	0.3-0.8	25-60	10-20
Dark shades	1.0-3.0	25-60	20-40

pH:	6.0±0.5
Water quality:	Preferably deionized
Sealing:	Preferably with Anodal® ASL (one or two stage)

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3. SETTING THE DYEBATH

When setting the dyebath, care must be taken that the dyestuff is well dissolved. Dissolve the dye preferably with hot water (80 °C) in a separate container (approx. 5 parts water to 1 part dye). Then this mother solution will be added to the dyebath while stirring.

4. LIGHT FASTNESS OF THE DYEINGS (ISO 2135)

Light fastness of dark dyeings (12 µm): Note 5-6 (ISO 2135)

5. SPECIAL REMARKS

- The dyestuff is very yielding
- Unsealed dyeing can be stripped with diluted nitric acid (30 %). The best results concerning stripping will be achieved with nitric acid 10 % + potassium permanganate 5 %. After the treatment in potassium permanganate, neutralization must be carried out for 1-5 min in a sodium bisulphite 5 % solution.
- The dyebaths are sensitive to aluminum; anodized objects should therefore be rinsed thoroughly before dyeing

- **Prevention of mould formation:**
We recommend the addition of a suitable antimicrobial product

6. DISPOSAL OF THE DYE BATHS

Spent dyebaths can be readily precipitated with Anodal WT-1 Liquid. The method is described in detail in the technical information bulletin for Anodal WT-1 Liquid.

The table below shows the additions required for precipitating Sanodure Orange RL.

PRECIPITATION METHOD	FeCl ₃ , 40 % ml/g dye	ETCHING LYE ml/g dye	ANODAL WT-1 LIQUID ml/g dye	RESIDUAL DYE IN THE FILTRATE mg/l
A	2.0	—	0.9	< 1
B	2.0	—	0.9	~ 7
C	—	2.0	1.5	~ 9

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