

COFOMEGRA ADDITIVE OIL FOR MAGNESIUM

You have to set up your etching machine as follows:

Bath temperature: from 28°C to 32 °C maximum (82°F to 89°F) .

Between 4 to 6 °C less than the temperature you are using now.

Paddle speed: 500 +/- 50 rpm (this may vary with the type of etching machine so it must be correctly determined by you with etching tests.)

Paddle depth: 9 mm. (3/8 inch) (All the paddles must be at the same depth all over the bath. If not levelling of the machine is needed.)

Bath formula:

Nitric acid 42° Baume: 20 to 22 % by volume.

Additive oil: from 4% to 5 % by volume.

Water: about 75% by volume, so to get 100% of your bath capacity.

P.S.: This additive oil is very protective, so it is possible to use only 4% by volume instead of the standard 5% recommended from competitors. This allows you to save 20% of oil with cost and pollution reductions.

You must have a bath temperature from 28°C to 32° probably lower from 4 to 6 °C than before.

Our oil in the same etching conditions produces wider shoulders than the oil you have used up to now, so it is needed to increase paddle speed and/or acid quantity to get exactly the same shoulder.