



Effective Date: 21 June 2005

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## QUICK CUT II® CSA-550 TECHNICAL DATA SHEET

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Revision: 001

### CSA-550

CSA-550 accelerated chemistry is a liquid acidic compound used primarily for accelerated vibratory refinement of mild carbon steel. CSA-550 will also work in many hardened steel applications.

### Physical Properties:

Appearance: Liquid, colorless, with a slight acidic odor

Reactivity: pH of 1% solution = 4.0; pH of 100% = 2.62

Specific Gravity = 1.200; 10 lbs./gallon

### Typical Application

Grind line removal and surface refinement. The most effective process should be selected based on performance testing in full production conditions. CSA-550 can be used with a wide range of tumbling medias including plastic, porcelain and ceramic. Ceramic medias provide for the fastest metal removal rates. Typically metal removal is monitored by surface roughness or weight loss. Surface roughness readings are closely related to the type and abrasiveness of the media selection. Abrasive medias will generally produce Ra readings of 6-10. Polishing medias can produce Ra readings as low as 3-5. Weight loss also varies according to the media being used and is affected by the alloy plus the heat treatment process.

### Typical Process

CSA-550 is designed for closed drain, batch-processing applications. A typical process in a 5-10 cubic foot bowl is 1 gallon per 3,000 square inches of work part surface area. The solution is added directly in to the vibratory machine. Cycle times will vary depending on the vibratory machine, condition of the work piece prior to processing and the media selection. Following the accelerator cycle a burnish cycle of 45 min to 1 hour may be necessary.

To establish the most efficient process and techniques for your application, contact your Hammond Roto-Finish representative.

The data presented are believed accurate. Roto-Finish Company, Inc. can guarantee only its product. User must verify suitability to his own application.

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