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QUICK CUT II® CSA-597 TECHNICAL DATA SHEET

Revision: 001

CSA-597

CSA-597 accelerated chemistry is a liquid acidic compound used primarily for accelerated vibratory refinement of hardened carbon steel. CSA-597 will also work in many mild steel applications.

Physical Properties:

Appearance: Liquid, colorless, free of debris or foreign matter

Reactivity: pH = 3.0

Typical Application

Grind line removal and surface refinement. The most effective process should be selected based on performance testing in full production conditions. CSA-597 can be used with a wide range of tumbling media including plastic, porcelain and ceramic. Ceramic media 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 media 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-597 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. KJE:dd 1/11/05



1600 Douglas Avenue • Kalamazoo, MI 49007

(269) 345-7151 • FAX (269) 345-1710

SALES@ROTO-FINISH.COM • WWW.ROTO-FINISH.COM

