

615 INHIBITOR

CORROSION-INHIBITING ADDITIVE

- Low Foam Levels
- Hard Water Tolerant
- Non-Nitrating
- Low VOCs
- RoHS Compliant
- Multi-Metal Safe
- No Silicates
- No Phosphates
- No Chlorine, Sulfur

• **Safe and Effective**

DARACLEAN® 615 is a non-foaming additive that prevents rust and corrosion. Formulated with a blend of inhibitors and emulsifiers, DARACLEAN® 615 is hard water tolerant, free-rinsing, and will not leave any mineral films on part surfaces. Designed to be used with immersion and spray rinses, it is safe to use with most metals and is non-aggressive towards aluminum, brass, copper, and titanium alloys.

• **Lasting Protection**

DARACLEAN® 615 is a blend of three different corrosion inhibitors plus a chelating agent for hard water conditioning. This provides excellent broad-spectrum corrosion resistance to critical part surfaces, without depositing any mineral scale or insoluble films. DARACLEAN® 615 forms a monomolecular layer over clean metal surfaces, providing a barrier between the metal and environmental oxidizers and humidity. This results in excellent protection against oxidation, corrosion, and rust for medium-term parts storage. The monomolecular film rinses away cleanly with solvent, coating prep, or aqueous cleaning.

DARACLEAN® 615 is simple to use and easy to maintain. Typical dosage for rinse tanks is only 2% to 10%, keeping consumption at a minimum while still providing full protection. It is effective in immersion and spray applications, with very low foam levels and broad temperature stability. DARACLEAN® 615 should be stored in well-ventilated areas at temperatures between 40 and 100°F (4–38°C). Recommended shelf life is one year.

Typical Applications

Cleaning Method	Concentration	Temperature	Typical Duration
Immersion	2–10 %	80–180 °F (27–82 °C)	2–30 minutes
Ultrasonic	2–10 %	80–180 °F (27–82 °C)	2–30 minutes
Spray	2–10 % 2–5% Recommended	130–180 °F (54–82 °C)	0.25–3 minutes

**Operating parameters should be optimized for each individual application.*

MAGNAFLUX®

A Division of Illinois Tool Works Inc.

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www.magnaflux.com

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Typical Properties

Appearance	Clear, colorless to pale straw			
Odor	Amine			
Foam Level	Very Low			
Cloud Point, 10% in DI Water	None to boiling, > 212°F (> 100°C)			
pH at 77°F (25°C)	Concentrate 10.0–10.5		5 % Solution 9.4–9.8	
Conductivity at 77°F (25°C)	14.8 mS			
Refractive Index at 77°F (25°C)	11.5 °Brix			
Specific Gravity	1.02			
Density	8.5 Lb/US Gal			
Surface Tension, 10% in DI Water	56 dyne/cm			
Vapor Pressure at 68°F (20°C)	18 mmHg			
VOC (EPA Method 24)	Concentrate 41 g/L (0.34 Lb/US Gal)		10% Solution 4 g/L (0.03 Lb/US Gal)	
Cast Iron Corrosion	2% Excellent	5% Excellent	10% Excellent	20% Excellent

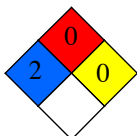
Concentration Test Methods

Test Kit Titration Method

Sample Size	10 mL	OR	10 mL
Titrant	0.5N Acid (HCl)		1.0N Acid (HCl)
Indicator	Phenolphthalein		Phenolphthalein
% DARACLEAN® 615 =	0.25 x drops titrant		0.5 x drops titrant

Conductivity Method

% DARACLEAN® 615 =	Conductivity (µS) x 140
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NFPA Rating (Concentrate)

DARACLEAN® 615 5 US Gallons (18.9 liters) P/N 01-6120-40

DARACLEAN® 615 55 US Gallons (208 liters) P/N 01-6120-45

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