

COMPOUND D (#41004R)

COMPOUND D is a liquid vibratory burnishing/descaling solution designed for use in Raytech Vibratory Finishing (and other manufacturers) equipment. It was developed for use with most finishing medias including ceramic, porcelain and steel/stainless steel. Not generally recommended for use with plastic finishing media. **COMPOUND D** is particularly suited for burnishing of gold, silver, brass and copper. Can also be used successfully to burnish some alloys of aluminum. Will help keep metal free of oxides while maintaining cleanliness of the process media. Will keep steel and stainless steel finishing media bright and residue free. **COMPOUND D** is mildly acidic and not generally recommended for processing of steel or other ferrous metal parts because of potential for corrosion. When using **COMPOUND D** with carbon steel finishing media, it is recommended that a proper corrosion inhibitor be used to hold the media until next use.

PHYSICAL PROPERTIES (Typical)

COLOR:	Yellow, clear	PH (2% solution):	5.3-5.7
ODOR:	Faint	WATER SOLUBILITY:	Complete
LBS./GAL:	8.7	FREEZE TEMP.:	32-38°F
PH (conc.):	5.1-5.4	FOAM CHARACTER:	Moderate

USE DIRECTIONS

- In a vibratory tumbling application, recommend using a flow through method; Use a 1-1.5% (by volume) mixture to keep both the processed parts and media clean and residue free. In a conventional vibratory application, recommend a flow rate of 1-2 gals./hr. per cubic ft. of the vibratory working capacity. For use in a centrifugal disc finishing application, recommend a flow rate (1-1.5% solution) of 8-10 gals./hr. per cubic ft. of the disc finisher working capacity. Always be certain that process equipment drains are free and clear.
- Can also be used in a conventional tumbling application with or without finishing media. Generally, recommend slightly higher use dilution of 2-3% (by volume).
- **COMPOUND D** can be used as an effective descaler to remove minor surface rust from steel or ferrous metal. Will also help remove oxidation from brass/copper surfaces without dulling the surface.

PROCESS EQUIPMENT

- Raytech Vibratory Finishing Mill
- Open tumbling barrel (not recommended for use in closed tumbling barrel due to possible gas buildup)
- Centrifugal Disc Finishing

PACKAGING: 1 gallon bottles

SAFETY/DISPOSAL: Refer to current Safety Data Sheet (SDS) before using this product.

The suggestions and data in this bulletin are based on information we believe to be reliable. They are based on good faith, but offered without guarantee, as conditions and methods of use of our product(s) are beyond our control. Jan 2018