Aquamill™ ST- 40 L

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Aquamill™ ST- 40 L

Aquamill™ ST- 40 L is a liquid accelerated mass finishing compound for ferrous alloys.

Aquamill™ ST- 40 L is normally used in vibratory finishing mills although it can be used in oblique finishing barrels as well. When used in vibratory mills we recommend the use of ceramic long-life or ceramic medium cut medias. Media shape and size will be determined by part configuration.

Aquamill™ ST- 40 L may be used in flow through and closed bowl vibratory processes.

OPERATING PARAMETERS:

Concentration: Full strength
Flow Rate: 50 to 100 ml per square foot of surface area (parts) per hour, depending on media and desired finish.
Time: 2.5 to 8 hours depending on starting surface finish.

MEDIA:

A. 5, 10 or 20 Bond Media will produce a reasonably bright finish after burnish without too much excess work on the part's edges. It is competitive to High Density Media when used correctly.

B. Media must be selected to prevent lodging and be large enough to move the parts.

C. Media can be various shapes and sizes; Angle Cut Cylinders, Triangles, Cones, Tristars. They are chosen based on their ability to reach critical areas; usually areas that are shielded present the biggest problem.

D. Media's are often mixed in size and shape to reach all critical areas.

EQUIPMENT:

1. Flat bottom bowl lined with chemically resistant material including the drain.

2. The bowl is generally set up with a 3 mm - 5 mm amplitude with a 60-70 degree lead angle. This is usually done with the minimum weights required to roll the media and parts.

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3. The vibratory bowl should be fitted with a closeable drain if batch processing is the method chosen to finish the work.

4. Metering pumps are required particularly when a flow through process is chosen.

5. Burnishing setup is required.

GENERAL:

Rule 1 – Generally 75 ml per square foot of surface area per hour. It is preferable to make additions to the bowl
every 3 hours as needed for longer cycles.

Rule 2 - Chemistry is depleted when the wipeable black film is no longer present or the liquid becomes too thick for the bowl to move the parts.

Rule 3 - Additions of water can be made if the bowl runs very hot and evaporation becomes a problem, however, the volume of water (metered into bowl) should not exceed 250 cc. per cubic foot per hour.

Rule 4 -The best surface finish (non-etched) is achieved by allowing the active chemistry to be consumed before burnishing.

CLOSED BOWL

1. Cut using **Aquamill™ ST- 40 L** at 50 to 100 ml per square foot of surface area per hour with the drain closed.

2. Open drain.

3. Burnish using **Lusterlume™ 3LX or Aquamill™ ST 1** at 2% to 3% by volume with a flow rate of 0.5 to 1 gallon per cubic foot of bowl capacity per hour. Normal burnish times are 30 to 60 minutes.

4. Unload

FLOW THROUGH

1. Cut feeding **Aquamill™ ST- 40 L** at a constant rate over the course of the cut cycle, using the calculation of 75 ml per square foot of surface area per hour of cut. The flow of the

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Aquamill X should be stopped approximate 0.5 hours prior to the end of the cut cycle to allow the chemistry to die.

2. Burnish using **Lusterlume™ 3 LX or Aquamill™ ST 1** at 2% to 3% by volume with a flow rate of 0.5 to 1 gallon per cubic foot of bowl capacity per hour for 30 to 60 minutes.

3. Unload.

Your Hubbard-Hall technical service representative is available to assist with process development.

It is advantageous for our technical service laboratory to process parts to fine-tune the process to your particular needs prior to field trials.

WARRANTY

THE QUALITY OF THIS PRODUCT IS GUARANTEED ON SHIPMENT FROM OUR PLANT. IF THE USE RECOMMENDATIONS ARE FOLLOWED, DESIRED RESULTS WILL BE OBTAINED. SINCE THE USE OF OUR PRODUCTS IS BEYOND OUR CONTROL, NO GUARANTEE EXPRESSED OR IMPLIED IS MADE AS TO THE EFFECTS OF SUCH USE, OR THE RESULTS TO BE OBTAINED.

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