



Bernite DB 22

Bernite DB 22 is a chemical compound that will quickly and effectively dissolve the salts used in aluminum dip brazing without affecting the base aluminum. It will completely remove all traces of the flux bath in a fraction of the time heretofore required and will also eliminate the need to rework the parts multiple times.

Bernite DB 22 is supplied as a white crystalline powder made up of a complex of acid salts with wetting agents, sequestering agents and inhibitors. It is mixed with hot water and can be used in a soak tank or in ultrasonic equipment.

This most effective flux salts remover was originally evaluated on aluminum alloys 6061 and 1100 and on brazing sheet) 21, 22, 11 and 12 with no changes in critical dimensions. Bernite DB 22 was used initially on aluminum structures in the form of channels, cores, honeycombs, angles and flat surfaces. The complete removal of the aluminum dip brazing salts was tested by x-ray and a 5% silver nitrate solution. The various parts were exposed to a humidity chamber for 24 hours and then tested again.

Features & Benefits

Fast acting	High productivity
Inhibited	Less substrate attack; high productivity due to lower reject rate

Operating Conditions

Application

1. Bernite DB 22 can be used as a hot soak in a stainless steel (316) or plastic-lined tank in the concentration of 8 ounces of powder per gallon of water heated to 175°F to 190° F. The length of time of immersion should be up to one hour depending upon the accessibility of the salts. Agitation of the solution will generally be very beneficial. In addition, pumping the solution through cavities will also expedite the salts removal. Periodic additions of powder are recommended to maintain the solution at a pH of 2.5. The entire solution should be discarded once the residual brazing salts contaminate and inhibit the efficient operation of the solution.

2. Bernite DB 22 can also be used as an ultrasonic cleaner. It has been generally determined that the higher frequencies (80 KC) require 1-2 ounces per gallon of water



while the lower frequencies (25 KC) require 2 to 4 ounces per gallon of water. Temperatures above 150°F. improve the efficiency of this operation.

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