



Oxide Replacement Process

<u>PROCESS STEPS</u>	<u>TEMPERATURE(°F)</u>	<u>DWELL TIME (min)</u>
1.) Acid cleaner: PB-409	70-90°F 20-32 C	1 to 2 minutes
2.) DI water rinses 2x cascade	Room temp.	1 to 2 minutes
3.) Alkaline Cleaner	110-120°F 43-49 C	2 to 3 minutes
4.) DI Water rinses 2x cascade	Room temp.	1 to 2 minutes
5) Pre-dip PB-433	70-80F 21-27C	30 to 60 seconds
6.) Oxide Replacement PB-445	80-85°F 27-29 C	1.5 to 2 minutes
7.) DI water rinse	Room temp.	1 to 2 minutes
8.) Warm DI water rinse	85-105°F 30-40 C	1 to 2 minutes
9.) Dry		

***Please note, that all baths and rinses require DI water. Chlorides that contaminate this process will stop it from working.

