



# NIPOSIT™ Nickel Stripper 424

Niposit Nickel Stripper 424 rapidly strips electroless nickel-phosphorus deposits from mild steel and steel alloys without substrate attack.

## Advantages

- Rapid Stripping—1.0 to 1.5 mils of Niposit electroless nickel is stripped per hour when bath is freshly made up
- High Yield—Niposit Nickel Stripper 424 strips approximately 3 mil feet of nickel deposit per gallon of made-up bath before stripping rate becomes too slow
- High Stability—the bath is extremely stable, even when kept at operating temperature for extended periods of time
- Non-cyanide—the bath does not contain cyanide
- No Pitting of Steel—Niposit Nickel Stripper 424 does not pit steel substrates

## Bath Make-up

<i>Chemicals Required</i>	<i>Metric</i>	<i>U.S.</i>
Deionized water	500 ml/l	50% v/v
Niposit Nickel Stripper 424 D	120 g/l	16 oz./gal.
Niposit Nickel Stripper 424 L	500 ml/l	50% v/v

## Make-up Procedure

1. Add DI water to tank.
2. Heat to 54°C (130°F).
3. Add Niposit Nickel Stripper 424 D and mix until fully dissolved.
4. Add Niposit Nickel Stripper 424 L and mix thoroughly.

**Note:** Do not add 424 L component until 424 D salts are fully dissolved.

## Bath Operation

Immerse parts in bath until nickel is stripped from the substrate. During stripping operation, the work will exhibit a dark surface until the nickel has been removed. The surface will then be clean and pit-free. Maintain bath operating temperature between 93.3–98.9°C (200–210°F) and stir solution continuously to avoid localized overheating. Also agitate work for best results.

**Note:** Do not use Niposit Nickel Stripper 424 to remove nickel from aluminum or copper alloys.

# Niposit Nickel Stripper 424

## Bath Maintenance

Maintain bath volume with water and discard when stripping rate becomes too slow.

## Product Data

### *Niposit Nickel Stripper 424 D*

#### *Resource #10015875 (75 lbs.)*

Appearance: Dry powder

pH (5% solution): 4

### *Niposit Nickel Stripper 424 L*

#### *Resource #10015877 (55 gal.)*

Appearance: Clear yellow liquid

pH: 11

Specific Gravity: 1.3

## Equipment

Use equipment constructed of polypropylene, stainless steel, Pyrex or ceramic.

## Handling Precautions

Before using this product, consult the Material Safety Data Sheet for details on product hazards, recommended handling precautions and product storage.

**CAUTION!** When using immersion heaters, failure to maintain proper volume level can expose tank and solution to excessive heat resulting in a possible combustion hazard, particularly when plastic tanks are used.

## Storage

Store Niposit Nickel Stripper 424 D and Niposit Nickel Stripper 424 L only in upright, original containers in a dry area at 10–32°C (50–90°F). Store Niposit Nickel Stripper 424 D and Niposit Nickel Stripper 424 L away from strong oxidizers. Store Niposit Nickel Stripper 424 L away from acids. Do not store in sunlight. Store away from heat and sources of ignition. Keep container sealed when not in use.

## Waste Treatment

It is the user's responsibility to verify that treatment procedures comply with federal, state and local regulations. Contact your Shipley Technical Representative for more information.

Due to the nature of Niposit Nickel Stripper 424 D and Niposit Nickel Stripper 424 L, disposal of them, or residues therefrom should be made in compliance with federal, state and local environmental regulations.

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