

Approvals and conformities

SAFRAN HELICOPTER ENGINES (formerly TURBOMECA)	CCT 00540 / RTC 70-20-22-110-801
PRATT & WHITNEY	SPMC 244, SPS 244
PRATT & WHITNEY (V2500)	CoMat 01-584 (Solution code 193)
SAE	ARP1755B Category 4 Conform except on AMS 5040 STEEL and AMS 6431 STEEL
GE	C 04-290

Engine cleaner for hot sections of gas turbine engines. Removes rust, metallic oxides and heat scale.

HDL 73W is a neutral deoxidizer which sequesters the metal particles (oxides, ions, etc.) not chemically related to the substrate surface.

HDL 73W is the key component of our new innovative 3-step process in the removal of complex metallic oxides. To complete the surface treatment it is recommended to follow with immersion in an alkaline permanganate solution (HDL 2524) then returning to HDL 73W.

Main product features:

- Effectively removes metallic oxides and heat scale
- Liquid form provides ease of handling
- Does not contain strong acids, pH near neutrality
- Eliminates one step in the 4-step process

HDL 73W is a product from the MagChem range.

USES

- It is used in the cleaning of the hot section of gas turbine engine components and other similar parts.
- Approved for use on high strength steels, alloy steels and heat resistant alloys.
- Used for scale and rust removal.

DIRECTIONS FOR USE

- Parts should be cleaned, degreased and if necessary de-carbonized prior to this process.
- Maintain solution at a concentration of 30 - 40% volume solution, and a temperature of 77 - 88 °C (170 - 190 °F).
- The parts to be processed should be immersed in the solution for 15 to 30 minutes, preferably with agitation, followed by a spray rinse or in an overflowing rinse tank.

The typical sequence would be the following:

- 1) HDL 73W (neutral deoxidizer), 40%, 180 °F, 20 minutes
- 2) HDL 2524 (alkaline permanganate), 50%C, 25%P, 190 °F, 30 minutes
- 3) HDL 73W, (neutral deoxidizer), 40% , 180 °F, 20 minutes

- On heating, this solution was found to darken with time; this in no way affects the performance or tank longevity of the product.
- Concentration can be maintained in accordance with the method supplied by Socomore ou MagChem.
- It is recommended to use 304 or 316 stainless steel in the construction of the immersion tanks.

TECHNICAL CHARACTERISTICS

Appearance	clear amber liquid
Specific gravity	1.16 (+/- 0.01)
pH	6.0 (+/- 0.2)

PRECAUTIONS FOR USE AND STORAGE

For more information regarding the danger of the product, please consult the product safety data sheet according to local regulation.

For professional use only.

This technical data sheet replaces and cancels the previous one.

The above details have been compiled to the best of our knowledge. They have, however, an indicative value only and we therefore make no warranties and assume no liability in connection with any use of this information, particularly if a third party's rights are affected by the use of our products. The above information has been compiled based upon tests carried out by SOCOMORE. All data is subject to change as Socomore deems appropriate. The data given is not intended to substitute for any testing you must conduct in order to determine the suitability of the product for your particular purposes. Please check your local legislation applicable to the use of this product. Should you need any further information please contact us.