

## DARACLEAN® 615 INHIBITOR

### General Description:

DARACLEAN® 615 Inhibitor is a non-foaming additive that prevents rust and corrosion. It is hard water tolerant, free-rinsing, and will not leave any mineral films on part surfaces.

### Composition:

DARACLEAN® 615 is formulated with a blend of inhibitors and emulsifiers. It is safe for use with most metals and is non-aggressive towards aluminum, brass, copper, and titanium alloys.

### Lasting Protection:

DARACLEAN® 615 is a blend of three different corrosion inhibitors plus a chelating agent for hard water conditioning. This provides excellent broad-spectrum corrosion resistance to critical part surfaces, without depositing any mineral scale or insoluble films. DARACLEAN® 615 forms a monomolecular layer over clean metal surfaces, providing a barrier between the metal and environmental oxidizers and humidity. This results in excellent protection against oxidation, corrosion, and rust for medium-term parts storage. The monomolecular film rinses away cleanly with solvent, coating prep, or aqueous cleaning.

### Application Method

DARACLEAN® 615 is designed to for use with immersion and spray rinses.

Cleaning Method	Concentration	Temperature	Typical Duration
Immersion	2 - 10%	80° - 180°F (27 - 82°C)	2 - 30 Minutes
Ultrasonic	2 - 10%	80° - 180°F (27 - 82°C)	2 - 30 Minutes
Spray	2 - 10% 2 - 5% Recommended	130 - 180°F (54 - 82°C)	0.25 - 3 Minutes

*Operating parameters should be optimized for each individual application.*

### Simple to Use:

DARACLEAN® 615 is simple to use and easy to maintain. Typical dosage for rinse tanks is only 2% to 10%, keeping consumption at a minimum while still providing full protection. It is effective in immersion and spray applications, with very low foam levels and broad temperature stability. DARACLEAN® 615 should be stored in well-ventilated areas at temperatures between 40 and 100°F (4–38°C). Recommended shelf life is one year.

### Packaging:

5 Gallon Pail (18.9 Liters) Part Number: 01-6120-40  
55 Gallon Drum (208 Liters) Part Number: 01-6120-45

## DARACLEAN® 615 Inhibitor Typical Properties

Appearance	Clear, Colorless to Pale Straw
Odor	Amine
Foam Level	Very Low
Cloud Point, 10% in DI Water	None to Boiling, > 212°F (> 100°C)
pH at 77°F (25°C)	Concentrate (10.0 - 10.5)    5% Solution (9.4 - 9.8)
Conductivity at 77°F (25°C)	14.8 mS
Refractive Index at 77°F (25°C)	11.5 °Brix
Specific Gravity	1.02
Density	8.5 lb./US gal.
Surface tension, 10% DI Water	56 dyne/cm
Vapor Pressure at 68°F (20°C)	18 mmHg
VOC (EPA Method 24)	Concentrate (41 g/L or 0.34 lb./US gal.)    10% Solution (41 g/L or 0.03 lb./US gal.)
Cast Iron Corrosion	Concentrate (2%/5% - Excellent)    10% Solution (10%/20% - Excellent)

## DARACLEAN® 615 Concentration Test Methods

### Test Kit Triation Method

Sample Size	10 mL
Titrant	.05N Acid (HCl)
Indicator	Phenolphthalein
% DARACLEAN® 615 =	0.25 x Drops Titrant

OR

Sample Size	10 mL
Titrant	1.0N Acid (HCl)
Indicator	Phenolphthalein
% DARACLEAN® 615 =	0.5 x Drops Titrant

### Conductivity Method

% DARACLEAN® 615 =	Conductivity (µS) x 140
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NFPA Rating (Concentrate)

