

Wet-End

Automotive



Process	%	kg	Product	Time	Comments
ARTICLE steering wheel CLIENT ACLE MATERIAL US BULL (DZXL) RECIPE NO. MC1935 QUANTITY 1 sides DATE 28 April 2019 % based on shaved weight Substance 1.05-1.10 mm weight: 13 kg TECHNICIAN Max Cui					
	200	26,000	water 38°C		
	0,4	0,052	SELLATAN® PA Liq		
	0,2	0,026	BORRON® A	30'	Drain
	100	13,000	water 35°C		
	1	0,130	CORIPOL® AV	10'	
	2	0,260	MAGNOPAL® IPF		
	2	0,260	TANNESCO® HN Gran		
	3	0,390	Chrome	90'	
	1,5	0,195	HCOONa		
	0,7	0,091	NaHCO3	20X3	o/n, pH: 4.0,d/w
	50	6,500	water 30°C		
	2	0,260	HCOONa		
	2	0,260	SELLASOL® NG Liq	20'	pH: 4.6-4.7
	0,2	0,026	NaHCO3	40'	pH: 4.9,d/w
	60	7,800	water 30°C		
	0,5	0,065	CORIPOL® AV		
	3	0,390	MAGNOPAL® SFT-F	10'	
	4	0,520	MAGNOPAL® PGN	40'	
	0,5	0,065	CORIPOL® LEO		
	1	0,130	SELLASOL® TN		
	5	0,650	SELLATAN® TMC		
	5	0,650	SELLATAN® MBS		
	5	0,650	SELLATAN® RLS Liq		
	5	0,650	SELLASOL® FTF	30'	
	1	0,130	SELLASOL® TN		
	5	0,650	Tara		
	4	0,520	SELLATAN® MBS		
	0,5	0,065	INVADERM® LU		
	2	0,260	SELLA® Fast Turquoise 2BL	60'	
	100	13,000	water 50°C		
	1,3	0,169	HCOOH 85%	30'	pH: 3.8, d/w
	150	19,5	water 50°C		
	2	0,26	SELLASOL® FTF	15'	
	5	0,65	CORIPOL® AV		
	4,5	0,585	CORIPOL® LEO	80'	
	1	0,13	HCOOH 85%	20'	d/w
	150	19,5	water 35°C		
	0,5	0,065	SELLA® Fix E	30'	Drain
	200	26	water 20°C		
	0,2	0,026	BORRON® A	20'	Drain
	200	26	water 20°C		
	0,5	0,065	SELLA® Tec DEO	30'	Drain

horse up o/n, set-out, vacuum(240"/50°C),hang-dry,condition, stake, mill 6hr:

Comments:

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