

Lectroetch Electrolyte and Cleaner Chart

METALS, ALLOYS, PLATINGS	ELECTROLYTE	POWER UNIT CIRCUIT	COLOR	COMMENTS
ALUMINUM AND ALLOYS	210A	DC	BLACK	Allow a few seconds for color to develop before cleaning.
	LNC-9, LNC-3	DC	GRAY	Deep mark. Dark color on some alloys.
	LNC-5, LNC-2, 250A	DC	WHITE	Used on bright finish or polished surfaces.
ALUMINUM ALLOYS - HIGH MAGNESIUM OR SILICA	LNC-5, LNC-2, 250A	DC	CLEAR	Cannot be color marked.
ANODIZED ALUMINUM				Must be marked prior to anodize - see special instructions.
ALUMINUM BRONZE, BRONZE, PHOSPHOR BRONZE-BRASS, BRASS ELECTROPLATE	220A, 117A, LNC-5	AC	BLACK	Electrolyte depends on composition of alloy.
		DC	CLEAR	
CADMIUM ELECTROPLATE	LNC-5, 117A, 112A	AC	BLACK	Excess electrolyte may cause staining.
CARBIDES	LNC-3, 250A, 255A, LNC2	AC	DARK	Use maximum Power Unit output.
CHROME PLATE-HARD	LNC-3, LNC-4, GB-77	DC	CLEAR	Cannot be color marked, unless deep-etched through plating.
CHROME PLATE-DECORATIVE	LNC-7	AC	DARK	
		DC	CLEAR	
COBALT ALLOYS, STELLITE	LNC-1, LNC-3, 260A	AC	BLACK	Sandblast surface should have light oil film before marking.
		DC	CLEAR	
COPPER AND ALLOYS, COPPER ELECTROPLATE	220A, LNC-5, 117A	AC	BLACK	Electrolyte depends on composition of alloy.
		DC	CLEAR	
COVAR	255A, GB-2	AC	BLACK	
DEEP-ETCH ALUMINUM, FERROUS METALS	LNC-3, LNC-9, GB-77	DC	CLEAR	Use deep-etch Hand Pad, Type F Wick, interrupted current.
BRASS, BRONZE, COPPER	LNC-5			
DISCALOY	LNC-3, 260A	AC	BLACK	
GOLD AND ALLOYS, GOLD PLATE	LNC-1, LNC-3, 2611A	AC	BLACK	Use minimum electrolyte
		DC	CLEAR	
	GB-2 (Plate)	DC	BLACK	Reverse polarity.
HASTELLOYS	LNC-1, LNC-3, LNC-4, LNC-8	AC	BLACK	
INCONEL	251A, LNC-1, LNC-3, 2611A	AC	BLACK	
	GB-2 (PLATE)	DC	BLACK	Reverse polarity.
IRON	LNC-1, LNC-3, 2611A, 112A	AC	BLACK	
LEAD AND ALLOYS, LEAD PLATE	LNC-4, 250A	AC	BLACK	
		DC	CLEAR	

METALS, ALLOYS, PLATINGS	ELECTROLYTE	POWER UNIT CIRCUIT	COLOR	COMMENTS	
MAGNESIUM AND ALLOYS	LNC-4, LNC-5, 250A	DC	CLEAR	Mark before galvanic anodize - cannot be color marked.	
MONEL METAL	LNC-1, LNC-3, 2611A	AC	BLACK	Circuit depends on surface finish and results desired.	
		DC	CLEAR		
NICKEL AND ALLOYS, NICKEL PLATINGS	LNC-2, 250A, LNC-9	AC	BLACK		
		DC	CLEAR		
STEEL-LOW CARBON, MILD	LNC-1, LNC-3, 2611A, 112A	AC	BLACK		
STEEL-HIGH ALLOY, TOOL	LNC-3, LNC-9, 260A	DC	CLEAR		
SAW STEEL	L-50, LNC-1, 2611A	AC	BLACK		
STAINLESS STEEL	300 SERIES	D462, 53NC, LNC-2	AC	BLACK	Color depends on series of stainless.
	400 SERIES	LNC-8, CF-25, 260A	DC	CLEAR	
SILVER, SILVER PLATE	LNC-6, 117A, 251A	AC	BLACK	Permanency of mark depends on composition.	
		DC	CLEAR		
TIN AND ALLOYS, TIN PLATE	LNC-5, 117A, 112A	AC	BLACK		
TITANIUM	250A, (Nuc. Gr.), LNC-3, 251A, 260A	AC	DARK	Minimum power, electrolyte.	
	GB2 (plate)	DC	BLACK	Reverse polarity.	
	2611A	DC		Deep etch.	
ZINC AND ALLOYS, ZINC PLATING, ELECTRO-GALVANIZE	112A, 117A, LNC-5	AC	BLACK		
	GB-2 (plate)	DC	BLACK	Reverse polarity.	
CHROMATED CADMIUM, ZINC	LNC-2, LNC-5, 117A	AC	BLACK	Surfaces partially passivated. Use max. output and pressure.	
		DC	CLEAR		
BLACK OXIDE	270A	AC	WHITE	Electrolyte, circuit, power unit output depends on coating involved. See special instructions/submit samples for test marking.	
	D462, LNC-4, LNC-3	DC	WHITE		
BLUE FURNACE OXIDE, PHOSPHATED STEEL, OTHER SUPPLEMENTAL COATINGS	D462, LNC-3, LNC-4	DC	WHITE		

NUCLEAR-GRADE ELECTROLYTES AND CLEANERS

Contain less than 250ppm of Halogens, Sulphur, and Lead. Available in LNC-2, LNC-3, LNC-5, and 250 A Electrolyte formulations, and #2 and #3 Cleaner formulations. Certified Trace Analysis available at additional cost.

POSTCLEANERS AND PROTECTIVE OIL

#2 CLEANER - for ferrous metals by manual wiping.

#3 CLEANER - for non-ferrous metals by manual wiping.

#1 All Purpose Cleaner } General purpose cleaners for all metals by manual wiping.
Neutralyte }

LIC CLEANER - Concentrate to be diluted 9:1 with water for immersion cleaning or wiping.

CT CLEANER TISSUES - for light cleaning applications on non-ferrous metals
(pkg of 1,000)

RV OIL - a water-displacing (polarized) oil for in-plant protection after marking and cleaning.

SPECIAL CFX-2 NON-CLEANING ELECTROLYTE

For marking high carbon and mild steel, hardened/case-hardened steels, some high-speed steels, and iron. Requires little or no post-cleaning. Ideal for bearings, feeler gauges, and other parts prone to corrosion.

All Electrolytes and Cleaners are available in 1-quart plastic bottles (1, 4, 6, and 12-quart packages), 1-gallon plastic jugs, and 5-gallon plastic pails. Some electrolytes and cleaners available in 55-gallon drums. Prices on application.

SEND SAMPLES!

If in doubt as to which electrolyte is best for your parts, submit samples to LECTROETCH for test marking. Please include information on metal composition, and type of mark (AC mark, DC etch, Deep Etch, etc.). There is no charge for this service. We will return parts with our recommendations.