

Technical data sheet for abrasive

Product designation

Electrofinishing media EF 20-1

Description

Electrolyte for wet processing of metallic surfaces on medical devices and implants, 2-component electrolyte consisting of liquid electrolytes and ion exchangers with a particle size of 0.6 – 0.8 mm.

Approved machines

The abrasive is approved for use in the following machines:

- EF-Smart
- EPAG-Smart
- EF-Flex
- EPAG-Flex
- EF-One

Permitted materials

Material	Abrasion	Polishing
Cobalt chromium	+++	++

Other materials are not approved for processing.

Before use

Thoroughly mix the abrasives in the bag.

Storage

- Store in a cool, dry place at temperatures between +5 °C and +30 °C.
- Protect from direct sunlight.
- Unopened containers can be stored for at least 12 months.

Instructions

For sintered and annealed CoCr alloys with a high tungsten content, the addition of EF-polishing powder is recommended in order to achieve optimum results.

EF- Polishing powder is available as a separate article.

Fill EF-Polishing powder completely into the container in the quantity supplied and mix for 1-2 minutes.

Liquid coverage at standstill

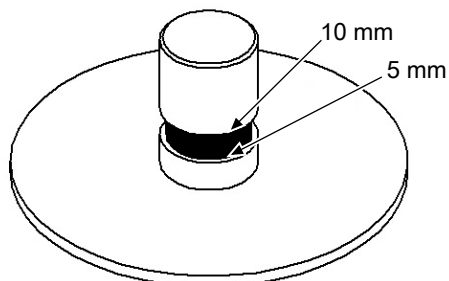


Fig. 1: Liquid indicator, example

Instructions for RF

Reference measurement with reference electrodes A320-81-020 and A316-81-001



INFO

Liquid coverage

There must be detectable liquid coverage over the solids in the process container at standstill.

Standard value: 5 – 10 mm of liquid over the solids

- ➔ Check the liquid coverage at standstill using the liquid indicator before carrying out the reference measurement.
- ➔ If necessary, top up with top-up liquid (RF 16-0) until there is detectable liquid coverage.

Shake top-up liquid RF 16-0 thoroughly before use.

Reference current value: 0.3 A

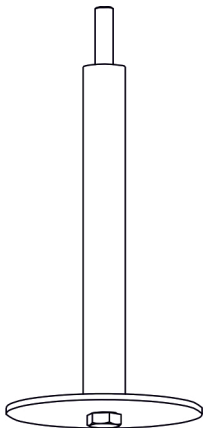
Machine	Voltage	Speed	Time	Ramp
EF-Smart	10 V	15 rpm	1 min	25 %
EPAG-Smart				
EF-Flex	10 V	45 rpm	1 min	25 %
EPAG-Flex				

Current value	Meaning	Measure
< 0.2 A	Abrasive too dry	Add distilled water. <ul style="list-style-type: none"> ■ Smart: 50 ml ■ Flex: 150 ml Repeat until the value is in the required range.
> 0.5 A	Abrasive too wet	Contact OTEC Service.

Reference measurement with
reference electrodes A320-81-030
and A316-81-010

Reference current value: 1.2 A

Machine	Voltage	Speed	Time	Ramp
EF-Smart EPAG-Smart EF-One	10 V	15 rpm	1 min	25 %
EF-Flex EPAG-Flex	10 V	45 rpm	1 min	25 %



Current value	Meaning	Measure
< 1.0 A	Abrasive too dry	Add distilled water. ■ Smart: 50 ml ■ Flex: 150 ml ■ One: 25 ml Repeat until the value is in the required range.
> 1.5 A	Abrasive too wet	Contact OTEC Service.