ACME™
FOUNDRY FLUX COMPANY

CLEANAL

CLEANAL range of fluxes are used for:

- Covering and drossing of aluminium melts.
- Modifying aluminium silicon alloys.
- Removing aluminium oxide build up on the furnace walls.
- Recovering aluminium from the dross.
- Melting of turnings, borings and chips.

BENEFITS: CLEANAL range of -

- Covering flux prevents oxidation losses.
- Covering cum drossing fluxes absorb oxides and form dross with less metal.
- Modifying fluxes improve tensile strength and elongation of aluminium – silicon alloys.
- Furnace cleaning flux improves the life of the refractory lining and retain the melting-efficiency.
- Recovering flux helps extract aluminium from hot drosses.
- Melting flux meant for melting of chips, turnings etc. minimises the melting losses.

APPLICATION DETAILS:

- **COVERING FLUXES**: Add the recommended quantity in two stages – half as soon as the charge begins to melt and the balance when the charge is completely molten. Keep the flux cover intact till the melt is ready for further treatment.
- **COVERING & DROSSING FLUXES**: Add the flux in two stages – half of the recommended quantity during melting and the balance when the metal is ready. In the second stage, mix the flux with the dross thoroughly till red glowing powdery dross is obtained.
- **MODIFYING FLUX**: Degas and dross off the metal as soon as the desired temperature of the metal is reached. Sprinkle the flux on a clean metal surface. Work the flux well in to the metal and allow the metal to stand for about five minutes before starting the casting operation.
- **FURNACE CLEANING FLUX**: Sprinkle Cleanal – 88 on the furnace walls just after the furnace is emptied. Put on the burners for about 15 minutes and then scrape the furnace walls to remove the oxide build – up.
- **FLUX FOR RECOVERING ALUMINIUM**: Add Cleanal – 65 and hot dross in alternate layers in to a dross bogie provided with perforations at the bottom. Stir the dross and the flux thoroughly till no more metal runs through the perforations.
- **FLUX FOR MELTING OF CHIPS, TURNINGS & BORINGS**: Prepare a heel of metal in the furnace by melting Ingots or solid scrap. Add adequate amount of Cleanal-75 to form fluid cover. Then plunge chips, turnings, etc. a little at a time through the flux cover into the melt. Ensure the cover is kept in a fluid condition by adding extra quantity of Cleanal – 75 from time to time.

Manufactured by:
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NON FERROUS PRODUCT RANGE FOR ALUMINIUM & it's ALLOYS

Powder Fluxes for Covering / Drossing / Modifying & Recovery

Product	Colour	Application Rate	Dross Type	Melting Point	Melting Unit	Alloy Type	Remark
CLEANAL – 6 / CLEANAL – 6 (S) (Covering & drossing flux)	Pink	1%	Dry	-	Crucible and electric furnace	Good drossing flux for alloys except Al. Mg. alloys	Prevents furnace wall build-up. Usually used in smelters
CLEANAL – 15 (Covering & drossing flux)	White	1%	Dry	630° C	Reverberatory rotary and large electric resistance furnace	For alloys except Al. Mg. alloys	Prevents furnace wall build-up. Usually used in smelters
CLEANAL – 55 (Covering flux)	White	2 – 3 %	Pasty	500° C	Crucible	Alloys Containing 2 – 6% Mg. and hypereutectic Al. Si. alloys	Sodium free
CLEANAL – 63 (Modifying flux)	Blue	3%	Liquid	670° C	All furnaces	Hypo-eutectic & eutectic Al. Si. alloys	For metal temperature between 730-750 Deg.C
CLEANAL – 65 (Dross recovering flux)	White	5 – 10%	Liquid	635° C	-	All aluminium alloys	For recovery of aluminium from hot drosses in a dross bogie.
CLEANAL – 66 (Covering & drossing flux)	Yellow	2 – 3%	Dry	-	Crucible & bale out	Alloys containing 1 – 10% Mg. and hypo-eutectic Al. Si. alloys	Sodium free
CLEANAL – 75 (Melting flux for chips, turnings etc.)	Red / Pink	2 – 10%	Liquid	590° C	Reverberatory crucible rotary & low frequency induction	All alloys except those containing high Mg.	Recovery of grindings, skimmings, turnings and dirty scrap etc.
CLEANAL – 85 (Modifying flux)	White	3%	Liquid	645° C	All furnaces	Hypo-eutectic & eutectic Al. Si. alloys	For metal temperature between 710-720 Deg.C
CLEANAL – 88 Furnace cleaning flux)	White	Depends on the furnace size	-	-	Reverberatory rotary	All aluminium alloys	To remove oxide build up formed on the furnace walls
CLEANAL – 92 (Modifying flux)	White	1.5%	Liquid	780° C	All furnaces	Hypo-eutectic & eutectic Al. Si. alloys	For metal temperature between 780-800 Deg.C