

# B. C .S. Company

763 Thompson Rd., Thompson, CT 06277  
(860) 923-9575 • Fax (860) 923-2093

TECHNICAL SERVICE DATA SHEET

**615**

## DESCRIPTION:

615 is a gray and white powder, which is an aggressive, fast-cut compound containing a mix of aluminum oxide and silica abrasives to produce a fast cut down and stock removal on ferrous parts. 615 is free rinsing and will provide short-term rust inhibition on ferrous parts. Parts should be clean and degreased before finishing.

## TYPICAL APPLICATION:

615 is intended for aggressive, fast deburring, or edge breaking of steel and other ferrous metal parts utilizing an aggressive, fast-cut ceramic media in vibratory bowls or tubs, open tumble barrel or high energy machines. For a fast edge breaking, running parts with 615 and no media, part on part, in an open tumble barrel, is particularly effective. Drains in vibratory or high energy equipment should be closed to retain the abrasives in the compound throughout the cycle. 615 is low-foaming, and should be used in a concentration of 2-6 ounces of powder per gallon of water. With the drain open, parts may be rinsed in the vibratory equipment or tumble barrel and still retain short-term rust inhibition.

## SPECIFICATIONS:

615 provides adequate in-process rust protection and, if lightly rinsed but not washed off, will provide short-term rust and oxidation protection. For long-term protection to protect the coating specified for long-term, protection should be used.

## OPERATING CONDITIONS:

### VIBRATORY or BATCH TUMBLING

<b>CONCENTRATION:</b>	1.0 – 3.0 oz/gal.	(8 - 24 ml/l)
<b>TEMPERATURE:</b>	50° F to Room	(10 – 21° C)

**pH:** 10.0 to 10.5 of the concentrate

For additional information such as physical characteristics, safety precautions, disposal, etc., see corresponding MSDS.