



TECHNICAL BULLETIN

GREENSOLV 294WL

HIGH PERFORMANCE HOT PAINT REMOVER - AEROSPACE

1) PRODUCT DESCRIPTION

GREENSOLV 294WL is an extremely effective biodegradable liquid paint remover for industrial and aerospace coatings. It has a very low toxicity and does not contain any dichloromethane or NMP. **It will not corrode metals; it is safe to be used on aluminum, steel, stainless steel, cadmium, titanium and magnesium (see aerospace specifications).** The stripping time is usually between 15 and 60 minutes for most coatings (could be longer for some aerospace coatings), when the stripping solution is kept at a temperature between 60 and 80°C (140 – 176°F). In regards to the corrosion test SAE ARP17 55B Cat.7, longest immersion time in the Greensolv 294WL is 8 hours for all aerospace parts.

Typical applications:

- Aerospace stripping tank;
- Industrial stripping tank;

Typical coatings:

- Catalyzed paints (epoxies, polyurethanes, fuel tank coatings);
- Powder coatings (polyester & polyurethane) & E/Coat;
- Silicone polysulfide.

GREENSOLV 294WL is designed for use in a heated soaking tank. However, it can be used for cold stripping applications with a longer dwell time. The recommended operating temperature is 40 to 80 °C (104 to 140°F).



Greensolv 294WL soaking tank with ventilation system



Magnesium parts stripped with Greensolv 294WL

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Greensolv 294WL – High Performance Hot Paint Remover
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2) BENEFITS

While biodegradable and safe for the end user, **GREENSOLV 294WL** will allow you to strip the toughest coating systems within a very short period of time.

Its main benefits are:

- Extremely effective, *better than NMP based formulations*;
- Will keep its stripping efficiency for 12 to 36 months
- No NMP, No dichloromethane, Biodegradable, No HAP (*Hazardous Air Pollutant, U.S. EPA*);
- Non corrosive to any metals;
- Low evaporation rate;
- Can be cleaned and reused;
- Non flammable.

AEROSPACE SPECIFICATIONS

Tests performed by an independent laboratory: SMI, Florida, USA

Stock Loss performed at 80°C/ 176°F for 8 hours on :

Effect of cleaning agents on aircraft engine materials

aluminum, magnesium, copper, nickel, titanium, steel, cobalt, corrosion resistant steel, plus various electroplated and plasma coated panels.

ARP 1755B cat.7

Stress Corrosion (titanium alloys)

ASTM F-945-12

3) PHYSICAL PROPERTIES

Physical appearance.....two-phases, transparent yellow liquid
 Odor.....Ammonia
 BiodegradabilityGood
 Flash point (close cup) with oil blanket..... 149°C (300°F)
 Specific Gravity (Water = 1) 1.05 – 1.10
 pH (1 % in water) 10.5 – 11.5

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4) APPLICATION PROCEDURE

Before immersion:

- Clean any excessive grim from the surface to be stripped.

Immersion:

- Completely submerge the parts to be stripped in a solution of **GREENSOLV 294WL** pure at a temperature varying from 40 to 80°C (68 to 176°F) ; the higher the temperature, the lower the stripping time will be;
- Wait until the parts are completely stripped before taking them out of the solution;

Oil Blanket:

- An oil blanket – a light synthetic oil – is included in the **GREENSOLV 294WL** to cover the stripping solution. It substantially reduces evaporation losses and contributes to lower heating costs. A good oil blanket should have a thickness of 1 to 3 inches (2.5 à 7.5 cm) in order to be effective.

Agitation (optional):

- Agitation of the solution during the stripping process is not necessary but it will reduce stripping time by 20 to 30%. Use a slow air driven electric mixer) to avoid mixing the oil blanket with the paint stripper;
- Do not use an electric mixer or air to agitate the solution

Efficiency:

- Two variables will greatly influence stripping efficiency: agitation and temperature. On the other hand, increasing the temperature by 10°C (18° F) will also reduce the stripping time by 20 to 50%.

Keeping a clean stripping solution:

- **GREENSOLV 294WL** will dissolve the paint into small particles that will settle in the bottom of the tank. Cleaning the immersion tank every 4 to 8 months is recommended. To do so efficiently, let the tank settle for 48 hours at room temperature. Transfer the paint stripper into a temporary tank then clean the sludge at the bottom of the tank. Transfer back the “good” paint stripper into the immersion tank.

Performance:

- **GREENSOLV 294WL**'s life will depend on its use and the number of parts stripped. As a rule of thumb, the solution will be effective for a period of 12 to 36 months.

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Rinsing :

- Clean and rinse the parts with water if needed (preferably with warm water); add detergent if needed.
- For metals that oxidize rapidly when in contact with moisture, dip the parts in a corrosion inhibitor or dry them rapidly.

Before painting :

- Make sure that the parts are dry and free of any contaminants before painting the surface;

Compatible materials:

- Soaking tank: any metal;
- Pump: any metal and Teflon;
- Piping: Any metal;
- Seals and tape: Teflon

Precautions:

- Avoid contact with rubber and plastic surfaces as they may degrade. In case of contact, dry as soon as possible.

Disposal of the stripping solution :

- Dispose of the stripping solution according to local regulations. The solution will be contaminated with paint components after several months of service and therefore, it should be disposed of as a hazardous material.

5) PERSONAL PROTECTION

Engineering Controls :

Provide exhaust ventilation or other engineering controls to keep the airborne concentrations of vapors below their respective threshold limit value. Ensure that eyewash stations and safety showers are in proximity of workstation location.

Safety equipment:

- Wear appropriate respirator device with VOC (Volatile Organic Compound) cartridges when ventilation is inadequate;
- Splash goggles, safety glasses or face shield;
- Rubber apron and/or long sleeves;
- Chemical resistant gloves;
- Boots;

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6) STORAGE

Store **GREENSOLV 294WL** at a controlled temperature between 0°C and 30°C. (32° F to 86° F). in a closed container when not in use. Keep in a closed and dry container. The shelf life of the product has been determined to be three (3) years.

7) PACKAGING

GREENSOLV 294WL is available in :

- Pails (18.9 L – 5 U.S. Gal.).
- Drums (205 L – 55 U.S. Gal.).

Last Update : **May 2014**
Version : **3**