CS Production line schema: Chemical liquids + demi water usage / 16.5.2016

MAGALLOY line 1

Production line:	MAGALLOY 1
Operation name:	Odmašění / degreasing
Liquid volume:	200 Litres
Exchange frequency:	1month
Regular refill:	50 Litres/day
Temperature:	60°C
Medium (chemical):	SurTec 198 - ART NR 504218 + demi water
Concentration:	15 ± 5 %
Production line:	MAGALLOY 1
Operation name:	Odmašění / degreasing- oplach / rinsing
Liquid volume:	300 Litres
Exchange frequency:	na
Regular refill:	1584 Litres/day
Temperature:	25°C
Medium (chemical):	demi water
Concentration:	na
Production line:	MAGALLOY 1
Operation name:	Chlapení / cooling č.1
Liquid volume:	800 Litres
Exchange frequency:	1 x weekly
Regular refill:	70 Litres/day
Temperature:	70°C
Medium (chemical):	demi water
Concentration:	na
Production line:	MAGALLOY 1
Operation name:	Chlapení / cooling č.2
Liquid volume:	800 Litres
Exchange frequency:	1 x weekly
Regular refill:	70 Litres/day
Temperature:	70°C
Medium (chemical):	demi water
Concentration:	na
Production line:	MAGALLOY 1
Operation name:	Aktivace / activation
Liquid volume:	800 Litres
Exchange frequency:	1weekly
Regular refill:	30 Litres/day
Temperature:	20-40°C
Medium (chemical):	Bonderite M-AD 4977 + Presalene X + demi water
Concentration:	2%
Production line:	MAGALLOY 1
Operation name:	Fosfátování / phosphatize- nátěr č.1
Liquid volume:	800 Litres
Exchange frequency:	1x3months
Regular refill:	100 Litres/weekly
Temperature:	50°C
Medium (chemical):	Bonderite M-ZN 1421-AR, Bonderite C-AD 565 + demi water
Concentration:	chemicals 148+301 + demi water volume in system 1000 Litres
Production line:	MAGALLOY 1
Operation name:	Fosfátování / phosphatize- nátěr č.2
Liquid volume:	800 Litres
Exchange frequency:	1x3months
Regular refill:	na
Temperature:	50°C
Medium (chemical):	Bonderite M-ZN 1421-AR, Bonderite C-AD 565 + demi water
Concentration:	chemicals 148+301 + demi water volume in system 1000 Litres
Production line:	MAGALLOY 1
Operation name:	Fosfátování / phosphatize- vnitřní nátěr
Liquid volume:	800 Litres
Exchange frequency:	okruží pouze pro odčerpávání
Regular refill:	na
Temperature:	25°C
Medium (chemical):	Bonderite M-ZN 1421-AR, Bonderite C-AD 565 + demi water
Concentration:	chemicals 148+301 + demi water volume in system 1000 Litres
Production line:	MAGALLOY 1
Operation name:	oplach / rinsing č.1
Liquid volume:	700 Litres
Exchange frequency:	1x/daily
Regular refill:	na
Temperature:	20°C
Medium (chemical):	demi water
Concentration:	none
Production line:	MAGALLOY 1
Operation name:	oplach / rinsing č.2
Liquid volume:	800 Litres
Exchange frequency:	1x/daily
Regular refill:	na
Temperature:	20°C
Medium (chemical):	demi water
Concentration:	none
Production line:	MAGALLOY 1
Operation name:	Pasivace / passivation
Liquid volume:	800 Litres
Exchange frequency:	okruží pouze pro odčerpávání
Regular refill:	30 Litres/daily
Temperature:	20-30°C
Medium (chemical):	Gardolene D 6850 + demi water
Concentration:	2%

MAGALLOY line 2

Production line:	MAGALLOY 2
Operation name:	Odmašění / degreasing
Liquid volume:	700 Litres
Exchange frequency:	1month
Regular refill:	50 Litres/day
Temperature:	60°C
Medium (chemical):	SurTec 198 - ART NR 504218 + demi water
Concentration:	15 ± 5 %
Production line:	MAGALLOY 2
Operation name:	Odmašění / degreasing- oplach / rinsing
Liquid volume:	300 Litres
Exchange frequency:	na
Regular refill:	1584 Litres/day
Temperature:	25°C
Medium (chemical):	demi water
Concentration:	na
Production line:	MAGALLOY 2
Operation name:	Chlapení / cooling č.1
Liquid volume:	800 Litres
Exchange frequency:	1 x weekly
Regular refill:	70 Litres/day
Temperature:	70°C
Medium (chemical):	demi water
Concentration:	na
Production line:	MAGALLOY 2
Operation name:	Chlapení / cooling č.2
Liquid volume:	800 Litres
Exchange frequency:	1 x weekly
Regular refill:	70 Litres/day
Temperature:	70°C
Medium (chemical):	demi water
Concentration:	na
Production line:	MAGALLOY 2
Operation name:	Aktivace / activation
Liquid volume:	800 Litres
Exchange frequency:	1weekly
Regular refill:	30 Litres/day
Temperature:	20-40°C
Medium (chemical):	Bonderite M-AD 4977 + Presalene X + demi water
Concentration:	2%
Production line:	MAGALLOY 2
Operation name:	Fosfátování / phosphatize- nátěr č.1
Liquid volume:	800 Litres
Exchange frequency:	1x3months
Regular refill:	100 Litres/weekly
Temperature:	50°C
Medium (chemical):	Bonderite M-ZN 1421-AR, Bonderite C-AD 565 + demi water
Concentration:	chemicals 148+301 + demi water volume in system 1000 Litres
Production line:	MAGALLOY 2
Operation name:	Fosfátování / phosphatize- nátěr č.2
Liquid volume:	800 Litres
Exchange frequency:	1x3months
Regular refill:	na
Temperature:	50°C
Medium (chemical):	Bonderite M-ZN 1421-AR, Bonderite C-AD 565 + demi water
Concentration:	chemicals 148+301 + demi water volume in system 1000 Litres
Production line:	MAGALLOY 2
Operation name:	Fosfátování / phosphatize- vnitřní nátěr
Liquid volume:	800 Litres
Exchange frequency:	okruží pouze pro odčerpávání
Regular refill:	na
Temperature:	25°C
Medium (chemical):	Bonderite M-ZN 1421-AR, Bonderite C-AD 565 + demi water
Concentration:	chemicals 148+301 + demi water volume in system 1000 Litres
Production line:	MAGALLOY 2
Operation name:	oplach / rinsing č.1
Liquid volume:	700 Litres
Exchange frequency:	1x/daily
Regular refill:	na
Temperature:	20°C
Medium (chemical):	demi water
Concentration:	none
Production line:	MAGALLOY 2
Operation name:	oplach / rinsing č.2
Liquid volume:	800 Litres
Exchange frequency:	1x/daily
Regular refill:	na
Temperature:	20°C
Medium (chemical):	demi water
Concentration:	none
Production line:	MAGALLOY 2
Operation name:	Pasivace / passivation
Liquid volume:	800 Litres
Exchange frequency:	okruží pouze pro odčerpávání
Regular refill:	30 Litres/daily
Temperature:	20-30°C
Medium (chemical):	Gardolene D 6850 + demi water
Concentration:	2%

Single wall line

Production line:	SINGLE WALL
Operation name:	Žíhání / annealing
Liquid volume:	380 Litres + 250 Litres v okruhu
Exchange frequency:	1x annually
Regular refill:	10 Litres/weekly
Temperature:	25°C
Medium (chemical):	demi water
Concentration:	none
Production line:	SINGLE WALL
Operation name:	Svařování / welding
Liquid volume:	300 Litres + 300 Litres okruh
Exchange frequency:	1x annually
Regular refill:	10 Litres/day
Temperature:	22°C
Medium (chemical):	demi water
Concentration:	none
Production line:	SINGLE WALL
Operation name:	Čistící lužce - odstraňování / degreasing
Liquid volume:	1000 Litres
Exchange frequency:	1month
Regular refill:	40 Litres/day
Temperature:	60°C
Medium (chemical):	Phosbon VER 10 + demi water
Concentration:	3 litres Phosbon / 1557 Litres demi water
Production line:	SINGLE WALL
Operation name:	Broušení
Liquid volume:	2000 Litres
Exchange frequency:	1x annually
Regular refill:	100 litres/day
Temperature:	25°C
Medium (chemical):	Hakuform 50-80 RBK + demi water
Concentration:	100 litres Hakuform + demi water

CB1 line

Production line:	CB 1
Operation name:	Sušce Chlapení / cooling
Liquid volume:	800 Litres
Exchange frequency:	1x annually
Regular refill:	10 Litres/weekly
Temperature:	25°C
Medium (chemical):	demi water
Concentration:	none
Production line:	CB 1
Operation name:	Sušce indukčního pájení č.1 / brazing
Liquid volume:	190 Litres + 300 Litres v řádu
Exchange frequency:	1x annually
Regular refill:	30 Litres/weekly
Temperature:	25°C
Medium (chemical):	demi water
Concentration:	none
Production line:	CB 1
Operation name:	Sušce indukčního pájení č.2 / brazing
Liquid volume:	190 Litres + 300 Litres v řádu
Exchange frequency:	1x annually
Regular refill:	30 Litres/weekly
Temperature:	25°C
Medium (chemical):	demi water
Concentration:	none
Production line:	CB 1
Operation name:	Sušce indukčního pájení č.3 / brazing
Liquid volume:	190 Litres + 300 Litres v řádu
Exchange frequency:	1x annually
Regular refill:	30 Litres/weekly
Temperature:	25°C
Medium (chemical):	demi water
Concentration:	none

CB2 / 3 line

Production line:	CB 2/3
Operation name:	Celá Production line
Liquid volume:	2500 Litres + 2000 Litres v okruhu
Exchange frequency:	1x annually
Regular refill:	255 Litres/ day
Temperature:	25°C
Medium (chemical):	demi water
Concentration:	none

Vypracoval: Brabec M
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