



## GRAMOS 67A and 67B Ref: 1005 / 1006 TECHNICAL DATA SHEET

For the Chemical Treatment of oversprayed paint

### **Introduction:**

In keeping with our policy of continued research and development, M/s. GRAMOS SURFACE TREATMENT, U. K. has developed a paint denaturant system for mixed paint consumption based on Organic Compounds that results in a formulation as environmentally acceptable as it is effective. The system is relatively safe to handle as it neither contains nor utilizes caustic alkalis. As a further safety feature, an effective biocide is incorporated in the GRAMOS 67B component to eliminate bacteria build up that can cause unpleasant odours in the booths.

Gramos 67A & B denaturing system was formulated and developed in our own laboratories based on technology given by Gramos U.K. and is manufactured at our production facility in India.

### **Operation:**

The system consists of only 2 components liquid formulations, which are dosed into the water system of the spray booth. In the water, a reaction takes place yielding a finely divided precipitate that gathers paint particles as it moves with the water flow until it reaches the booth lagoon, pit or similar paint solids collection point. The precipitate, with the paint adhered to it, has a strong tendency to rise to the surface enabling paddle bars, a weir over, or manual skimming of the surface to remove the solids and deposit them in bins etc. The condition of the paint solids at this point is such that they are completely denatured, with no residual tackiness or tendency to stick to surface with which they come into contact.

### **Initial charge:**

For introduction of GRAMOS 67 A & B it will be advisable to clean the booth and sludge pit. Replace the booth water with fresh industrial water. Start the water circulation. This operation is extremely economical. Depending on the system as little as GRAMOS 67 A @ 0.2-0.3 Liter / KL & GRAMOS 67 B @ 0.26-0.29 Liter / KL, this can be added by hand or by automatic dosing pumps prior to the start of production. The GRAMOS 67A component is added first, usually to the booths main reservoir. When this is fully dispersed, the pH is adjusted to between 7.5 and 8.5 with the GRAMOS 67B component.

The rate of charge varies according to many factors, for example water condition. However, the volume ratio remains constant at 1:1.3 GRAMOS 67A to GRAMOS 67B. An example - the initial charge volume is calculated at 11.5 liters. This would be 5 liters GRAMOS 67A and 6.5 liters GRAMOS 67B

Some foaming may occur after the initial charge, but this is easily controlled by adjusting doses. Foaming during production is not a problem normally associated with the GRAMOS 67A/B denaturing system.

### **Dosing:**

Replenishment will depend on the paint consumption, assuming 40% overspray paint contamination in the booth water. The Gramos 67A / B system runs very close to a neutral pH, therefore it is undesirable to adjust dosing on the basis of pH measurement. The system is best-adjusted dependent on the condition of the denatured paint solids, the degree of floatation and the general running condition in the spray booths.

These conditions vary enormously between plants, in the type of paint used, the transfer efficiency and general state of the water and system. Due to these variations, our Technical Sales & Service staff will set up an operating regime on an individual plant basis, constantly monitoring all factors which influence the efficient management of the system, until both the Customer and we are satisfied with the systems operation. Regular checks will then be carried out by trained technical staff to ensure optimum performance.

Recommended doses for GRAMOS 67A @ 3-4 % of sprayable paint consumed and GRAMOS 67B @ 3.9-5.2 % will require. It will be also advisable to remove denatured paint collected into the sludge pit at regular interval for better performance. Final dosing and recommendation will be decided after one-month trials of individual sludge pit.

**Conclusion:**

In developing the system, M/s. GRAMOS CHEMICALS INDIA PRIVATE LIMITED has been able to draw from the wealth of expertise and knowledge from our parent company over 30 years experience as manufacturing denaturant systems for all types of United Kingdom industries & 10 years Indian Industries that incorporate paint in their process.

The ability to call on this expertise and knowledge has resulted in the development of the Gramos 67A/B denaturing system, which has the following benefits:

- An environment friendly product with no harmful or notifiable waste residue.
  - Safer to handle - Non caustic alkali formulation helps to protect painting structure.
  - Effective bacteria and odour control.
  - Very effective denaturing - waste paint solids have low water retention.
  - Potential cost savings over other systems using more than two components.
- Dosing and recommendation are given by Gramos own Technical Service and Sales Team while conducting initial trials, leaving the users only to monitor systems.

**Packing:**

20 Liters plastic container

Note: Standard specification may be supplied on request, which needs to confirm by customer before release of order.

**Warranty:**

It should be appreciated that the information given here is to the best of our knowledge, true and accurate. Since the conditions under which our products are used are beyond our control, recommendations are made without warranty or guarantee.

Ref: 1005 / 1006      Revision dated 1/5/2001

**M/S Gramos India Chemicals Pvt. Ltd.**

W-268, TTC Industrial Area, Rabale Village, Thane Belapur Road, Navi Mumbai – 400701,  
Maharashtra, India

Tel No – 91 22 27692084 / 27698555 Fax – 91 22 27695911 Email – gramosiw@vsnl.com