



# EPOMID CHEMICALS & MACHINERY PTE LTD

21, SENANG CRESCENT. SINGAPORE 416594  
TEL : 65-64487093 FAX : 65-64487012  
EMAIL: [sales@epomid.com.sg](mailto:sales@epomid.com.sg)

## TECHNICAL DATA FOR ELECTRO - DEFLASHING ADDITIVE - EDA-21

**PURPOSE:** EDA-21 is an additive for blending the electrodeflash solution, ED-21 which can remove and soften the mold flash under cathodic treatment. The softened mold flash can now be removed more easily by high pressure water jet in reel-to-reel or strip-to-strip plating process.

**FEATURE:** EDA-21 is a mixture of organic solvents and wetting agent, which when added to the solution of KOH, will serve as a mold flash deflasher under cathodic treatment.

**PREPARATION:** To make up 20 litre, simply add in one litre of EDA-21 to 19 litre of 28 % KOH solution and stir, then it become ED-21 Solution and ready to use.  
Or. Directly add the EDA-21 into your present KOH ED tank according to above ratio

**OPERATING CONDITION & PROCEDURE :**

1) Bath temperature	:	60 to 80 °C
2) Cathod current	:	Min 6 V
3) Immesion time	:	10 to 30 sec depending on qauntity of flash.
4) KOH concetration	:	26 to 30 %

Use 316L stainless steel as the anode. Its area must be larger then the parts which makes the cathode. The bath should preferably be covered up with a tank top. Operate under strong exhaust.

The copper parts, after cathodic treatment, is oxidised. These can be cleaned with a copper descaler, such as nitric/sulfuric mixture, or our Epomid descaler - CD-1.

### Operation Process

LOADING >> ED-21 >> WATER RINSE >> HIGH PRESSURE WATER JET >> COPPER DESCALER >> DOUBLE RINSE >> SOLDER PLATING.

Note: It is recommended to observe to mold flash quality after copper descaler stage.

**MAINTENANCE:**

- 1) Heat up the solution to approximately 60°C with a stainle ss steel heater before using. Once heated up, temperature needs to be controlled by a thermocontroller.
- 2) During operation, water evaporates due to the high temperature. Top up with water to reduce the specific gravity or add in the fresh solution to increase the specific gravity. Do this once every shift. Dump bath weekly.