

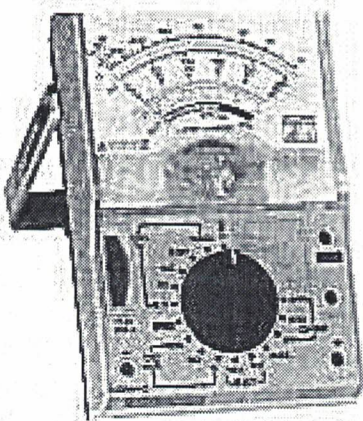
## Stripping The Anodize Film

Mix up a solution of 4-6oz of Anodize & Chrome Stripper with 1 gal of water. Add the powder slowly to the water.

Ideally, the solution should be at approx 70 deg F plus. The hotter the solution, the more rapidly the anodize film will be stripped. Solution temperature range is 70-150 deg f.

Use only plastic vessels, not aluminum, as this material is extremely corrosive to this metal. Dip the anodized part into the solution for between 20 seconds and 10 minutes, depending on the thickness of the existing anodize film.

Rinse off the part thoroughly in fresh water.



With a multimeter, test for conductivity. Put the multimeter in MegaOhm mode (mΩ). If no reading registers, then the part still has an anodized layer and should be re-immersed in the stripper. The piece must be perfectly dry.

### Some Interesting Points about Anodized Aluminum

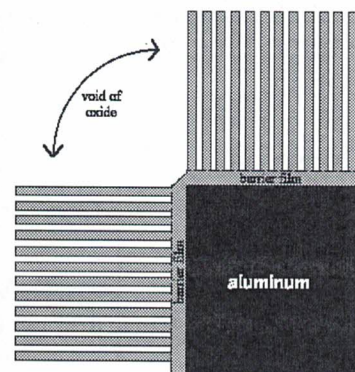
Anodized aluminum has a very durable surface that is unaffected by weather and many chemicals

The surface will resist high temperatures, even a blowtorch, for short periods. Many other types of dye may be used with varying effects, fabric dye, leather dye, water-based ink, felt tip pens etc.

Anodized films are usually measured by their intended operation:

Interior or unexposed articles	0.1 - 0.2 mil (mil = 1/1000")
Auto Trim	0.2 - 0.4 mil
Architectural or construction	0.8 -1.0 mil

Once a part has been anodized, it cannot be reshaped, and any great degree of flexing will cause the anodize film to crack.



Sharp edges can create problems, because the anodize pores grow out at right angles to the metal. On the example here, the corner area is almost completely void of pores. This will show up when dyeing.

MIL SPEC A-8625F calls for a 1/32" minimum radius on corners, when applying a 1 mil anodize film.

Consideration needs to be given to this phenomenon, and sharp edges should be rounded over.

Pore diameter and barrier film thickness will vary depending on the voltage and the electrolyte temperature. Different alloys will also have different effects. Pore size is related to current density, higher volts means smaller pores. Generally speaking, the larger the pore, the easier the dye will take.