































































ALUMINIUM FINISHING **SANODAL® , SANODURE® AND SANODYE® DYES**

For the dyeing of anodized aluminum

PRODUCT NAME		Dark shade	Light shade	Recommended dye bath pH range	Dye bath buffer*	Light fastness ¹	Outdoor application	Indoor application	Heavy metal free structure	Supply form	Single dye (s) Mixture (m)
Dark shade	Light shade	g/l	g/l								
		SANODYE YELLOW 3GL									
		3.0	0.1	5–6	S	> 9	●	●	●	Granules	s
		SANODAL GOLD 4N									
		30 (24 min)	30 (30 s)	4.5	–	> 9 ²	●	●		Powder	s
		SANODURE FAST GOLD L									
		3.0	0.2	5–6	S	7–8		●		Granules	s
		SANODURE ORANGE G									
		3.0	0.2	5.5–6.5	–	5–6		●		Granules	s
		SANODYE ORANGE 2B									
		5.0	0.5	5.5–6	S	5–6		●	●	Powder	s
		SANODYE GOLDEN ORANGE RLW									
		3.0	0.5	5.5–6.5	–	5–6		●	●	Granules	s
		SANODURE ORANGE RL									
		3.0	0.3	5.5–6.5	–	5–6		●	●	Granules	s
		SANODURE FAST BRONZE L									
		0.5	0.2	5–6	S	7–8		●		Granules	s
		SANODYE BROWN R									
		3.0	0.5	5–6	S	5–6		●	●	Granules	s
		SANODAL ORANGE 3LW LIQ.									
		5.0	0.2	5–6	S	> 9	●	●		Liquid	s

		PRODUCT NAME	Dark shade	Light shade	Recommended dye bath pH range	Dye bath buffer*	Light fastness¹	Outdoor application	Indoor application	Heavy metal free structure	Supply form	Single dye (s) Mixture (m)
Dark shade	Light shade		g/l	g/l								
		SANODAL RED B3LW	5.0	0.2	5–6	S	> 9	●	●		Granules	s
		SANODYE RED GLW	4.0	0.1	5–6	S	7		●	●	Granules	s
		SANODYE RED RLW	2.0	0.2	5–6	S	7		●	●	Granules	s
		SANODURE FIERY RED ML	5.0	0.2	5–6	S	6–7		●		Granules	m
		SANODURE BORDEAUX RL	5.0	0.5	5–6	S	6–7		●		Granules	s
		SANODURE VIOLET CLW	0.3	0.1	5–6	S	6–7		●		Granules	s
		SANODYE BLUE 2LW	3.0	0.1	5–6	A	> 9	●	●	●	Granules	s
		SANODYE BLUE G	3.0	0.1	5–6	A	> 9	●	●	●	Granules	s
		SANODAL TURQUOISE PLW LIQ.	5.0	0.1	5–6	S	> 9	●	●		Liquid	s
		SANODAL GREEN 3LW	3.0	0.2	5–6	S	> 9	●	●		Granules	s

PRODUCT NAME		Dark shade	Light shade	Recommended dye bath pH range	Dye bath buffer*	Light fastness ¹	Outdoor application	Indoor application	Heavy metal free structure	Supply form	Single dye (s) Mixture (m)
Dark shade	Light shade	g/l	g/l								
		SANODURE GREEN LWN									
		1.0	0.2	5–6	S	7–8		●		Granules	s
		SANODURE BROWN GSL									
		1.0	0.2	5–6	S	6–7		●		Granules	m
		SANODURE BRONZE 2LW									
		1.0	0.1	5–6	S	7		●		Granules	s
		SANODURE BRONZE G									
		1.0	0.2	5–6	S	6–7		●		Granules	s
		SANODURE YELLOW BROWN 2G									
		1.5	0.4	5–6	S	5–6		●		Granules	m
		SANODURE OLIVE BROWN 2R									
		1.0	0.1	5–6	S	6		●		Granules	s
		SANODURE GREY NL LIQ.									
		1.5	0.1	5–6	S	7–8		●		Liquid	s
		SANODURE GREY HLN LIQ.									
		0.3	0.1	5–6	S	7–8		●		Liquid	s
		SANODAL BLACK 2LW									
		10.0	1.0	4.5	-	> 9	●	●		Granules	s
		SANODAL DEEP BLACK HBL LIQ.									
		10.0	0.2	5–6	S	> 8 (12 μm) > 10 (25 μm)	●	●		Liquid	s

PRODUCT NAME		Dark shade	Light shade	Recommended dye bath pH range	Dye bath buffer*	Light fastness ¹	Outdoor application	Indoor application	Heavy metal free structure	Supply form	Single dye (s) Mixture (m)
Dark shade	Light shade	g/l	g/l								
		10.0	0.2	5–6	S	> 8 (12 μm) > 10 (25 μm)	●	●		Paste	s
		10.0	0.2	6.5–7.5	-	3–4 (12 μm) 7–8 (20 μm)		●	●	Powder	s
		10.0	0.6	5–6	S	> 8	●	●	●	Granules	s
		10.0	-	4.5	-	> 9	●	●		Granules Powder	m

QUALITY PRODUCTS FOR ANODIZED ALUMINUM

Sudarshan manufactures a full range of dyes and chemicals, many of which had been patented. In 2009 Sudarshan introduced Sanodye grades, which do not contain heavy metals as structure element. Sudarshan has initiated the development of an improved sealing process with the target to cover a wide spectrum of economic (e.g. energy efficiency) and environmental (e.g. heavy metal free structures) aspects. The manufacturing of Sudarshan’s dyes involves multi-step syntheses and utilizes many different process technologies. Precision, cleanliness and attention to the detail are key components to offer the finest products on the market. Sudarshan offers its customers technical service (e.g. color matching support), assistance to improve their production processes and guidance to reduce waste in production.

FOR THE DYEING OF ANODIZED ALUMINUM SUDARSHAN OFFERS THREE DYE RANGES:

SANODAL

- Excellent light- and weather fastness properties
- Suitable for outdoor and indoor applications
- Applicable alone or in combination with an electrolytic dyeing process
- Broad shade range accessible
- Designed for many architectural needs

SANODURE

- Comprehensive range of different colors, covering virtually all coloristic needs
- Good fade resistance properties
- Designed for indoor applications

SANODYE

- Organic dyes with heavy metal free structures
- Good to excellent fade resistance properties
- Designed for interior or outdoor applications as indicated in our technical data sheets
- Organic dyes with heavy metal free structures for more environmentally conscious applications

PRODUCTION CONDITIONS FOR THE ILLUSTRATIONS		
ANODIZING	Current Density	1.2–1.8 A/dm ²
	Voltage	12–20 V
	Electrolyte	180–200 g/l free H ₂ SO ₄ 5–15 g/l Al
	Temperature	18–20 °C
	Time	25–75 min
	Oxide Layer	18–20 µm
DYEING	Temperature	25–60 °C
	Concentrations	See illustrations
	pH	Mainly 5.0–6.0 acetate buffered, exceptions see technical literature
	Time	10–35 min
SEALING	Temperature	> 96 °C
	Time	40–60 min
	Medium	Deionized water, pH 5.5–6.0 plus: 20 ml/l Anodal ASL (liq.) (Nickel sealing) or 3 g/l Anodal SH-1

For detailed information on pretreatment, anodizing, dyeing and sealing conditions, please check our technical brochure:
Variations in Color: The dying of anodized aluminium.

IMPORTANT NOTES

- Pretesting in the customer specific material following the customer specific production process is absolutely necessary, especially with respect to compatibility and achievable shade
- The colored aluminum plaques cannot be used for tests of dye properties and coloristic comparisons

ABBREVIATIONS AND EXPLANATIONS

- 1 The light fastness ratings relate to ISO 2135 and ISO 105B02 and were done with deep shades at 12 μm anodized oxide layer thickness as described in our technical literature and do not necessarily refer to the illustrated plates in this shade card. With paler shades or lower oxide layer thicknesses, lower seal quality or softer layers, light fastness tends to be generally lower.
- 2 A first break phenomenon for ferrioxalate containing dyes is well known and documented in the literature: Those kind of compounds show a fading after a short radiation time (approximately 100 h) which then does not further degrade.

* S SODIUM ACETATE BUFFERING:

Add 8.0 g/l sodium acetate trihydrate ($\text{NaCOOH} \cdot 3\text{H}_2\text{O}$) into the dyeing tank; then slowly add approximately 0.4 ml/l acetic acid 100 % (conc. CH_3COOH) until the pH 5–6 is achieved.

* A AMMONIUM ACETATE BUFFERING:

Add 5.0 g/l ammonium acetate (NH_4COOH) into the dyeing tank; then slowly add approximately 0.5 ml/l acetic acid 100 % (conc. CH_3COOH) until the pH range 5–6 is achieved.



PRODUCT NAME	Solubility 20 °C / 60 °F
	g/l
SANODYE YELLOW 3GL	100
SANODAL GOLD 4N	> 300
SANODURE FAST GOLD L	60
SANODURE ORANGE G	40
SANODYE ORANGE 2B	7
SANODYE GOLDEN ORANGE RLW	100
SANODURE ORANGE RL	40
SANODURE FAST BRONZE L	100
SANODYE BROWN R	> 300
SANODAL ORANGE 3LW LIQ.	misc.
SANODAL RED B3LW	150
SANODYE RED GLW	50
SANODYE RED RLW	100
SANODURE FIERY RED ML	75
SANODURE BORDEAUX RL	50
SANODURE VIOLET CLW	20
SANODYE BLUE 2LW	5

PRODUCT NAME	Solubility 20 °C / 60 °F
	g/l
SANODYE BLUE G	3
SANODAL TURQUOISE PLW LIQ.	misc.
SANODAL GREEN 3LW	100
SANODURE GREEN LWN	40
SANODURE BROWN GSL	10
SANODURE BRONZE 2LW	5
SANODURE BRONZE G	15
SANODURE YELLOW BROWN 2G	20
SANODURE OLIVE BROWN 2R	30
SANODURE GREY NL LIQ.	misc.
SANODURE GREY HLN LIQ.	misc.
SANODAL BLACK 2LW	50
SANODAL DEEP BLACK HBL LIQ.	misc.
SANODAL DEEP BLACK H3LW	misc.
SANODURE BLACK CRO	40
SANODYE BLACK OA	20
SANODAL DEEP BLACK MLW GRAN.	50
SANODAL DEEP BLACK MLW	50



This information corresponds to the present state of our knowledge and is intended as a general description of our products and their possible applications. We make no warranties, express or implied, as to the information's accuracy, adequacy, sufficiency, or freedom from defect and assumes no liability in connection with any use of this information. Any user of this product is responsible for determining the suitability of our products for its particular application. *Nothing included in this information waives any of our General Terms and Conditions of Sale, which control unless it agrees otherwise in writing. Any existing intellectual/industrial property rights must be observed. Due to possible changes in our products and applicable national and international regulations and laws, the status of our products could change. Material Safety Data Sheets providing safety precautions, that should be observed when handling or storing our products, are available upon request and are provided in compliance with applicable law. You should obtain and review the applicable Material Safety Data Sheet information before handling any of these products. For additional information, please contact us.

*For sales to customers located within the United States and Canada the following applies in addition
NO EXPRESS OR IMPLIED WARRANTY IS MADE OF THE MERCHANTABILITY, SUITABILITY, FITNESS FOR
A PARTICULAR PURPOSE OR OTHERWISE OF ANY PRODUCT OR
SERVICE. 02/2022

™ Trademark

© Trademark registered in many countries

SPA 3001 EN | 07.2025

Sudarshan Chemical Industries Limited

Registered Office: Eleven West Panchshil, 7th Floor, Survey No 25,
Near PAN Card Club Road, Baner, Pune 411 045, India

T: +91 20 6829 7610 | E: contact@sudarshan.com

www.sudarshan.com | CIN.: L24119PN1951PLC008409