BONDERITE

Technical Data Sheet

BONDERITE C-AK C 72

Known as Ridoline C-72
October 2015

PRODUCT DESCRIPTION

BONDERITE C-AK C 72 provides the following product characteristics:

Technology	Industrial Cleaner
Product Type	Alkaline Cleaner
Application	Metal Pre-Treatment

BONDERITE C-AK C 72 is a powdered, non silicated, strongly alkaline cleaner for use in continuous strip lines. It is preferably used in spray application.
BONDERITE C-AK C 72 is effective on most metals and especially suitable on cold rolled steel coil stock, galvanized steel and aluminium.

Application Areas:

BONDERITE C-AK C 72 is used for cleaning prior to a conversion coating treatment (chromating, phosphating).

TECHNICAL DATA

Density, g/L	~900
pH-value (1% in DI water 20°C)	~12.8

DIRECTIONS FOR USE

Preliminary Statement:

Prior to use it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

Bath Make-up:

For each 1,000 L of bath, add to the water with stirring/circulating pump:

BONDERITE C-AK C 72	7 to 15 kg

Operating Data:

Adjusting the following parameters could be necessary depending on the line conditions.

BONDERITE C-AK C 72 Titration, mL:	8 to 16
pH-value (1 %):	12.8
Temperature °C:	40 to 80
Treatment time (Spray), sec:	5 to 120
Nozzle Pressure, bar:	1 to 2
Aluminium Titration (if aluminium processed), mL max. (= 10 g/L)	is 12

Bath Control:

The BONDERITE C-AK C 72 cleaner bath is manually controlled in the plant by a BONDERITE cleaner titration and an aluminium titration.

BONDERITE Cleaner Titration:

- Pipette a 10 mL sample of the BONDERITE C-AK C 72 cleaner bath into an Erlenmeyer flask and dilute with 50 mL of distilled water.
- Add 4 to 5 drops of Phenolphthalein indicator.
- While swirling the sample slowly run in from a 25 mL burette 0.1 N sulfuric acid. The endpoint of the titration is indicated by a colour change from red to colourless (pH 8.5).
- Record the milliliters of 0.1 N sulfuric acid used as BONDERITE cleaner titration.

Aluminium Titration:

- Add to the solution of the BONDERITE cleaner titration 0.5 teaspoonful (1g) of sodium fluoride with stirring.
- Refill the automatic burette to the zero mark.
- If the pink colour reappears, slowly run in 0.1 N sulfuric acid until the pink colour just disappears.
- Wait 1 minute and titrate, if necessary again to a colourless solution.
- Record the milliliters of 0.1 N sulfuric acid used as aluminium titration.

Aluminium titration shall not exceed 12 mL. Content of aluminium in the bath can be calculated by multiplying mL of 0.1 N sulfuric acid by factor 0.9.

Example:

Aluminium titration showed 9.6 mL of 0.1 N sulfuric acid. This is an aluminium content of 9.6 x 0.9 = 8.64 g/L.

Replenishing:

For each mL of 0.1 N sulfuric acid lacking add per 1000 l of cleaner bath solution:

BONDERITE C-AK C 72	0.9 kg

Classification:

Please refer to the corresponding **Material Safety Data Sheets** for details on:
Hazards identification
Transport information
Regulatory information

Henkel

Storage:

Temperature, °C	-5 to 50
Shelf-life, months (in unopened original packaging)	36

ADDITIONAL INFORMATION

Disclaimer

Note:

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.
Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

In case products are delivered by Henkel Belgium NV, Henkel Electronic Materials NV, Henkel Nederland BV, Henkel Technologies France SAS and Henkel France SA please additionally note the following:
In case Henkel would be nevertheless held liable, on whatever legal ground, Henkel's liability will in no event exceed the amount of the concerned delivery.

In case products are delivered by Henkel Colombiana, S.A.S. the following disclaimer is applicable:
The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.
Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

In case products are delivered by Henkel Corporation, Resin Technology Group, Inc., or Henkel Canada Corporation, the following disclaimer is applicable:
The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

Reference 0.1