

## BONDERITE C-AK 1563

Known as Ridoline 1563

December 2022

### PRODUCT DESCRIPTION

BONDERITE C-AK 1563 provides the following product characteristics:

<b>Technology</b>	Industrial Cleaner
<b>Product Type</b>	Alkaline Cleaner
<b>Application</b>	Metal Pre-Treatment

BONDERITE C-AK 1563 is a liquid alkaline cleaner based on polyacrylate and phosphate for steel, zinc plated steel and aluminium.

#### Application Areas:

BONDERITE C-AK 1563 is used in spray- and spray/immersion processes. It must be combined with a suitable cleaning booster.

### TECHNICAL DATA

Density at 20°C, g/cm <sup>3</sup>	~1.39
pH-value (1% in DI water 20°C)	~11.6

### 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:

Depending on the substrate, make-up will be done with BONDERITE C-AK 1563 or BONDERITE C-AK 1563 A .

Fill the tank with warm water, start pumping and add for a volume of 1,000 L:

#### Zinc plated steel and aluminum:

BONDERITE C-AK 1563 A Cleaning booster	7.7 to 23.1 L = 10 to 30 kg depends on requirements
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#### Steel:

BONDERITE C-AK 1563 Cleaning booster	7.2 to 21.6 L = 10 to 30kg depends on requirements
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### Operating Data:

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

#### Total alkalinity:

BONDERITE C-AK 1563 A , mL	3.8 to 11.4
BONDERITE C-AK 1563, mL	4.8 to 14.4

#### Free alkalinity:

BONDERITE C-AK 1563 A , mL	1.2 to 3.6
BONDERITE C-AK 1563, mL	2.0 to 6.0

Temperature, °C	50 to 80
Duration of treatment, min	1 to 5
Spray pressure, bar	0.8 to 2.0

### Bath Control:

BONDERITE C-AK 1563 solution is controlled by the following analysis:

#### Titration of total alkalinity:

Feed, mL	10
Titrant:	0.1 N hydrochloric or 0.1 N sulfuric acid
End point, pH	3.6
Indicator:	bromecresolgreen (0.1 % alcoholic solution)

1. Cool down bath solution to room temperature and pipette 10 mL bath solution into a clean 300 mL Erlenmeyer-flask.
2. Add 50 mL deionized water.
3. Add 4 to 5 drops of indicator.
4. Titrate the solution with 0.1 N hydrochloric or 0.1 N sulfuric acid.
5. The endpoint will be shown by a colour change from blue to yellow (pH: 3.6).
6. The consumption of 0.1 N hydrochloric or 0.1 N sulfuric acid in mL is equal to the points of total alkalinity

#### Titration of free alkalinity:

Feed, mL	10
Titrant:	0.1 N hydrochloric or 0.1 N sulfuric acid
End point, pH	8.5
Indicator:	phenolphthaleine (0.1% alcoholic solution)

1. Cool down bath solution to room temperature and pipette 10 mL bath solution into a clean 300 mL Erlenmeyer-flask.
2. Add 50 mL deionized water.
3. Add 4 to 5 drops of indicator.
4. Titrate the solution with 0.1 N hydrochloric or 0.1 N sulfuric acid.
5. The endpoint will be shown by a colour change from pink to colourless (pH-value: 8.5).
6. The consumption of 0.1 N hydrochloric or 0.1 N sulfuric acid in mL is equal to the points of free alkalinity

**Replenishing:**

Replenishing is to be done with BONDERITE C-AK 1563, irrespective of the substrates to be treated. For each missing point for a volume of 1,000 L add:

Total alkalinity	1.5 L = 2.1kg
Free alkalinity	3.6 L = 5.0kg
Cleaning booster	depends on requirements

**Classification:**

Please refer to the corresponding **Material Safety Data Sheets** for details on:

**Hazards identification**  
**Transport information**  
**Regulatory information**

**Storage:**

Recommended Storage Temperature, °C	0 to 50
Shelf-life, months (in unopened original packaging)	36

**ADDITIONAL INFORMATION****Disclaimer**

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