

BONDERITE® C-AK 1208X

Known as PARCO CLEANER 1208X
January 2024

Product description

BONDERITE® C-AK 1208X provides the following product characteristics:

Technology	Alkaline cleaner
Product type	Liquid alkaline cleaner
Application	Metal pretreatment

BONDERITE® C-AK 1208X is a single package, liquid alkaline cleaner formulated for the removal of BONDERITE L-FM (known as BONDERLUBE) lubricants, BONDERITE M-ZN conversion coatings and other drawing compounds or oils from aluminum & stainless steel parts, baskets, racks and tumbling barrels. The cleaner may be applied by either spray or immersion.

Direction 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.

Equipment:

The process tank, housing, pumps and piping for use with this solution may be constructed of mild steel. In spray applications, maintenance will be simplified if nozzles are fabricated from 300 series stainless steel. The heat exchanger plates should be polished 316 stainless steel. If gas fired burner tubes are used, they should be made of schedule 80 mild steel pipe or equivalent. All process circulating pump seals, valve seats, door seals, and other elastomers which come in contact with the working process solution should be PTFE or CSPE. EPDM elastomers should be avoided.

Automatic process control equipment, which promotes consistent quality and controlled costs, is available for automatically controlling this process. Auxiliary equipment, which is engineered and specified for this process, include air operated chemical transfer pumps, chemical metering pumps, reliable level controls, solenoid valve assemblies and bulk storage tanks. All chemical pump seals, valve seats and other elastomers which come in contact with the concentrated solution can be PTFE or CSPE.

Our sales representative should be consulted for information on Henkel Surface Technologies automatic process control equipment for this process and any additional questions. For additional information on equipment, please consult your local sales representative.

Operating data:

Total concentration, %	10 - 12
Total alkalinity	7.8 - 9.4
Time, minutes	3 to 10
Temperature, °F	175 to 190

Bath make-up per 100 gallons:

BONDERITE® C-AK 1208X	132 to 158 pounds, 10 to 12 gallons
-----------------------	-------------------------------------

1. Fill the tank 3/4 full with cool water and add required amount of BONDERITE® C-AK 1208X per 100 gallons of solution.
2. BONDERITE® C-AK 1208X : 132 to 158 pounds (10 to 12 gallons). Typical start-up build is 10% (v/v).
3. The correct amount is best determined by the cleaning application and types of soils to be removed.
4. Fill the tank and heat to the operating temperature.

Water rinsing

After cleaning, the parts are thoroughly rinsed with hot water. The rinse should be overflowed continuously at a rate which will keep it clean and free from scum and contamination. The cleaner will gradually accumulate lubricant and other soils, and should be discarded when contamination interferes with cleaning. If excessive lubricant and/or scum floats on the surface, it should be skimmed to eliminate re-deposition.

Bath control:

As the bath is used, active ingredients are consumed and require replenishing. Bonderite®, Bonderlube®, aluminum and other soils (contamination) also build up in the bath. As the amount of contamination increases, the concentration of the BONDERITE® C-AK 1208X must also be increased to assure cleanability. The following testing procedures will help to maintain proper cleaning performance. Use the Free Alkalinity for aluminum cleaning applications and the Total Alkalinity for stainless steel applications.

Free alkalinity:

Use when BONDERITE® C-AK 1208X is used to clean aluminum parts. Never pipet by mouth, use a pipet filler.

Titration A & B:

1. Pipette 25 mL bath solution into a clean 250 mL Erlenmeyer flask.
2. Add 25 mL deionised water.
3. Add 5 drops of Indicator 3.
4. Titrate with Titrating Solution 60 until one drop discharges the last of the pink color.
5. Record the ml of Titration Solution 60 used as the titration A, and substitute for "A" in the equation below.

1. To the same sample, add 10 mL Reagent Solution 37.
2. With an aged bath, the pink color will reappear.
3. Without re-zeroing burette, again titrate with Titrating Solution 60 until one drop discharges the last of the pink color.
4. Record the total ml used as Titration B and substitute for "B" in the equation below.

Titration B - Titration A = Contamination Level

This contamination level will be used in the following chart to determine BONDERITE® C-AK 1208X concentrations and additions.

F Factor

mls Contamination (B-A)	F Factor
0.0	3.3
0.1	2.8
0.2	2.4
0.3	2.1
0.4	1.9
0.5	1.7
0.6	1.6
0.7	1.5
0.8	1.4
0.9 to 1.0	1.3
1.1 to 1.2	1.2
1.3 to 1.5	1.1
1.6 to 2.0	1.0
2.1 to 2.9	0.9
>3.0	0.8

Calculation:

"Total" Concentration is considered active concentration plus contamination. Once the F Factor is determined, the "Total" concentration can be calculated as follows:

"Total" Concentration % = Titration A x F Factor

The "Total" concentration should be maintained at 10-12% minimum.

To increase "Total" Concentration by 1%, add 1 gallon of BONDERITE® C-AK 1208X per 100 gallons bath.

Total alkalinity:

Use when BONDERITE® C-AK 1208X is used to clean stainless steel parts. Never pipet by mouth, use a pipet filler.

1. Pipette 25 mL bath solution into a clean 250 mL Erlenmeyer-flask.
2. Add 25 ml deionised water.
3. Add 5 drops of Indicator 11.
4. Titrate with Titrating Solution 60 until one drop causes the redish - blue color to disappear.
5. Record the volume of Titration Solution 60 used.
6. The volume is equal to the Total Alkalinity Points.

To increase the Total Alkalinity by 1 point, add 10.6 pounds of BONDERITE® C-AK 1208X per 100 gallons or 0.8 gallons BONDERITE® C-AK 1208X / 100 gallons.

Waste disposal information:

Applicable regulations covering disposal and discharge of chemicals should be consulted and followed. Disposal information for the chemical, in the form as supplied, is given on the Material Safety Data Sheet for the chemical. The processing bath is alkaline.

Neutralization may be required prior to discharge to the sewer. (Refer to Waste Treatment Information Bulletin WT1007, available on request.) The processing bath and sludge which accumulates in the bath can contain ingredients other than those present in the chemical as supplied and analysis of the solution and/or sludge may be required prior to disposal.

Precautions:

When handling the chemical product used in this process, the first aid and handling recommendations on the Material Safety Data Sheet for the product should be read, understood and followed. The processing bath is alkaline and can cause irritation of the skin and eyes.

Do not get in eyes, on skin or on clothing. In case of contact, follow the recommendations on the Material Safety Data Sheet for BONDERITE® C-AK 1208X .

Classification:

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

Transport Regulations
Hazardous Information
Safety Regulations

Storage:

Recommended storage temperature, °F 60 to 90

BONDERITE® C-AK 1208X is a very concentrated liquid and may separate slightly at temperatures below 40°F. If the concentrate is subjected to these extreme temperatures during storage, bringing its temperature up to 90°F and mixing prior to usage will restore the uniformity of the product.



Additional information

Disclaimer

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, 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.

Trademark usage

Except as otherwise noted, all trademarks in this document are trademarks of Henkel Corporation in the U.S. and elsewhere. ® denotes a trademark registered in the U.S. Patent and Trademark Office.

Reference 1