

BONDERITE C-AK 27205

April 2022

PRODUCT DESCRIPTION

BONDERITE C-AK 27205 provides the following product characteristics:

Technology	Cleaner
Product Type	Liquid alkaline cleaner
Application	Metal Pre-Treatment

BONDERITE C-AK 27205 is a highly efficient no-surfactant liquid alkaline cleaner mainly intended for the cleaning of steel, galvanised steel and aluminium surfaces before phosphating. The product works combined with a suitable detergent additive, which will be recommended by Henkel Technical Service.

Application Areas:

BONDERITE C-AK 27205 is used in aqueous solution, by spray or dip.

TECHNICAL DATA

Operating Conditions:

Concentration, g/L	15 to 60
Additive concentration, g/L	1 to 10
Points	7 to 23
Temperature, °C	30 to 40
Time	
Spray, min	2 to 3
Dip, min	3 to 10

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:

1. Fill the operating tank with water and heat to operating temperature.
2. For the make-up of a 1000 l bath, add 15 to 60 kg of BONDERITE C-AK 27205.

3. Mix to a complete homogeneity by recirculating pump and heat the bath to operating temperature.
4. Add 1 to 6 kg of detergent additive.
5. Our Technical Service will recommend the best detergent additive at the start up according to the type of plant and material to be treated, as well as the treatment parameters and the best work concentration.

Control:

The bath is controlled by determination of Free Alkalinity points, which for a bath prepared at 20 g/l should be about 10.

1. Pipette 10 mL bath solution into a 250 ml beaker
2. Add about 25 ml of distilled water and 3 to 5 drops of Phenolphthalein Indicator (1% hydroalcoholic solution).
3. Titrate with 0.1 N Sulphuric Acid (H₂SO₄) slowly dripped from a graduated burette until the colour changes from red to clear.
4. The number of ml of 0.1 N H₂SO₄ used for the titration correspond to the Free Alkalinity points.

Replenishment:

The bath must be periodically controlled and its concentration kept at the value experimentally agreed at the start up.

To keep the fixed concentration, add about 2 kg BONDERITE C-AK 27205 and 0.1 ÷ 0.2 kg of detergent additive for 1000 l and for each missing point.

General Remarks:

In case oil formation on the surface is remarked, a partial skimming of the bath is recommended in order to keep it free from contaminations.

Our Technical Service ascertain when the bath needs to be totally renewed according to the type and quantity of grease and oil; in this case, it is recommended to remove sludge residues and thoroughly clean the tank.

Slight differences in product appearance do not affect either efficiency or operating performances.

Classification:

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

Hazards identification
Transport information
Regulatory information

Storage:

Recommended Storage Temperature, °C	4 to 35
Shelf-life, months (in unopened original packaging)	36

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