

## BONDERITE C-AK 27205

April 2022

### PRODUCT DESCRIPTION

BONDERITE C-AK 27205 provides the following product characteristics:

<b>Technology</b>	Cleaner
<b>Product Type</b>	Liquid alkaline cleaner
<b>Application</b>	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 80
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 (H<sub>2</sub>SO<sub>4</sub>) slowly dripped from a graduated burette until the colour changes from red to clear.
4. The number of ml of 0.1 N H<sub>2</sub>SO<sub>4</sub> 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

**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 0.0