

BONDERITE C-AK 336

Known as Ridoline 336
May 2022

PRODUCT DESCRIPTION

BONDERITE C-AK 336 provides the following product characteristics:

Technology	Industrial Cleaner
Product Type	Alkaline Cleaner
Application	Parts Cleaning

BONDERITE C-AK 336 is a powdered, silicate-free, mildly alkaline cleaner designed to remove oils and light oxide films from aluminum and its alloys in either immersion or spray application. It is a low etching product that will remove polishing compounds without adversely affecting the appearance of the polished aluminum surface. BONDERITE C-AK 336 cleaner contains wetting agents that are easily rinsed from the metal surface and that will not emulsify oils unless the oils themselves contain emulsifiers. The wetting agents contained in the BONDERITE C-AK 336 cleaner have been selected to produce a minimum amount of foam when operated above 40°C.

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:

- Fill about $\frac{3}{4}$ of the tank with clean tap water.
- Heat the water to above 40°C For each 1,000 L of final solution volume add 10 to 30 kg of BONDERITE C-AK 336 chemical, (The specific amount to be added is dependent upon bath strength desired), and circulate until thoroughly mixed.
- Finally, add sufficient water to bring solution up to working level and then heat to the operating temperature.

Operation:	
Time Spray :	30 sec to 5 min
Time Immersion :	1 to 5 min
Temperature:	40 to 85 °C

Operating Data:

BONDERITE C-AK 336 cleaner bath preparation per 1,000 L 10 to 30 kg.

BONDERITE C-AK 336	10 to 30 kg
Cleaner Titration:	3.4 to 10.2 mL
Immersion Time:	1 to 5 min
Spray Time:	30 sec to 5 min
Temperature:	40 to 85 °C

Materials:

BONDERITE C-AK 336 Chemical Testing Reagents and Apparatus

Equipment:

The process tank, housings, pumps and piping for use with this solution may be constructed of mild steel. In spray applications, maintenance will be simplified if nozzles are constructed of 300 series 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, valves and other elastomers that come into contact with the working solution should be Teflon, Polypropylene, Nitrile and to a lesser extent, owing to its shorter lifetime, Viton. EPDM elastomers should be avoided. All process circulating pump seals, valve seats, door seals, and other elastomers which come in contact with the working process solution should be Buna-N, Teflon™. 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 should be Teflon or Hypalon™.

Bath Control:

Never pipet by mouth, use a pipet filler.

Titration

- Pipet a 10 mL sample into a 250-mL flask.
- Add approximately 50 mL of distilled water and 6 to 8 drops of Phenolphthaleine.
- Titrate with 0.1 N Hydrochloric acid until the sample changes from pink to clear.
- The ml of 0.1 N HCl solution used is the BONDERITE C-AK 336 cleaner bath titration.

BONDERITE C-AK 336 cleaner bath titration range: 3.4 to 10.2 mL

To increase value 1.0 mL: 3.0 kg of BONDERITE C-AK 336 chemical per 1,000 L.

Mechanical Loss:

Replace any drop in bath strength due to mechanical loss (cleanout, leaks, etc.) by adding 3.0 kg of BONDERITE C-AK 336 chemical for each 1,000 L of working volume solution for each ml of titration required.

After Treatment:

After the work has been treated with BONDERITE C-AK 336, it should be thoroughly rinsed in cold water. The rinse should be continuously overflowed, and the flow should be regulated with the rate of production so that the main body of the rinse never becomes excessively contaminated.

Waste Water Treatment:

The processing bath is alkaline and contains phosphate. Waste treatment and neutralization may be required prior to discharge to the sewer. Disposal information for BONDERITE C-AK 336 is given on the Material Safety Data Sheet for each product.

Precautions:

The processing bath is alkaline and may cause irritation of the skin and eyes and may be corrosive to eyes. Do not get in eyes, on skin or on clothing. Do not take internally. Wear face shield, rubber gloves and protective clothing when handling. In case of contact, follow the recommendations on the Material Safety Data Sheet.

Classification:

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

Hazards identification
Transport information
Regulatory information

Storage:

Recommended Storage Temperature	0 to 32°C
Shelf-life, months	24

BONDERITE C-AK 336 is a powdered product that is not affected by freezing temperatures. It is recommended that it be stored in a dry place at room temperature.

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.

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