

BONDERITE C-AK 5668

Known as P3-emalan 5668
May 2017

PRODUCT DESCRIPTION

BONDERITE C-AK 5668 provides the following product characteristics:

Technology	Industrial Cleaner
Product Type	Alkaline Cleaner
Application	Parts Cleaning
Concentration	30 to 70 g/L
Operating Temperature	45 to 80°C

It is composed of alkalis, silicates, phosphates and salts of organic acid.

Application Areas:

BONDERITE C-AK 5668 is mainly used for the cleaning by immersion / flooding or spraying of chipless shaped steel parts. It does not contain any tensides which have to be added separately if necessary.

TECHNICAL DATA

Appearance	clear, colourless liquid
Density at 20°C, DIN 51757	~1.47 g/cm ³
pH-value (in a solution of 10 g/L)	~12.7

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:

The make-up quantity is added to the preheated water manually or by means of a conductivity driven dosing unit. When using the flooding process, the circulation pumps should have the capacity of moving about 15 bath volumina per hour. When using the spraying process with addition of tensides, the nozzles should be idle until working temperature has been reached.

Immersion (50 to 60°C):

BONDERITE C-AK 5668	50 to 70 g/L
BONDERITE C-AD 0470 or 0469	4 to 8 g/L

Immersion (70 to 80°C):

BONDERITE C-AK 5668	50 to 70 g/L
BONDERITE C-AD 0470 or 0469	2 to 4 g/L

Spray lines (45 to 60°C):

BONDERITE C-AK 5668	30 to 40 g/L
BONDERITE C-AD 0570	2 to 3 g/L

Spray lines (60 to 80°C):

BONDERITE C-AK 5668	20 to 30 g/L
BONDERITE C-AD 0570	1 to 2 g/L

Bath Control:

BONDERITE C-AK 5668 solution is controlled by total alkalinity.

Feed, mL	25 mL
Titrant:	0.5 N hydrochloric acid
Indicator:	Methylorange
Titration factor (TF):	3.3

- Pipette 25 mL bath solution into a clean 300 mL Erlenmeyer-flask.
- Add 3 to 5 drops of indicator.
- Titrate the solution with 0.5 N hydrochloric or 0.5 N sulphuric acid.
- The endpoint will be shown by a colour change from yellow to reddish (pH: 3.6).
- The added mL of 0.5 N hydrochloric or 0.5 N sulphuric acid multiplied by the factor TF 3.3 gives the concentration in g/L.
- Divide this by 10 to get the value in %.

Conductivity at 20 °C:	22 mS/cm (20 g/l)
	64 mS/cm (70 g/l)

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 40°C
Shelf-life, months	30

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Reference 0.2