

## BONDERITE C-AK 6443

Known as P3-upon 6443  
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### PRODUCT DESCRIPTION

BONDERITE C-AK 6443 provides the following product characteristics:

<b>Technology</b>	Industrial Cleaner
<b>Product Type</b>	Alkaline Cleaner
<b>Application</b>	Parts Cleaning
<b>Concentration</b>	20 to 100 g/L
<b>Operating Temperature</b>	50 to 80°C spray and immersion process 80 to 90°C derusting process

BONDERITE C-AK 6443 is a liquid alkaline cleaner, suitable for cleaning, derusting and dephosphating of steel. It is composed of alkalines and salts of organic acids.

#### Application Areas:

BONDERITE C-AK 6443 can be used to remove pigment residues, thin rust- and phosphate layers from steel and cast iron parts in spray and immersion processes. A good degreasing efficiency is reached by addition of a surfactant, for example BONDERITE C-AD 5003.

### TECHNICAL DATA

Appearance	brown liquid
Density at 20°C, DIN 51757	1.29 g/cm <sup>3</sup>
pH-value (in a solution of 10 g/L)	13

### 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:

Add the required amount carefully to the circulation system. Depending on the process, it may be necessary to add surfactant.

Concentration for degreasing and dephosphating:

in immersion process	30 to 100g/L
in spray process	30 to 80 g/L

Concentration for derusting:

immersion / spray process 200 to 600 g/L

#### Operating Data:

Temperature	
for spray and immersion process	50 to 80 °C
for derusting	80 to 90 °C
Duration of treatment	5 to 60 min

#### Bath Monitoring:

BONDERITE C-AK 6443 solution is controlled by total alkalinity

Feed, mL	50 mL
Titrant:	0.5 N hydrochloric or 0.5 N sulphuric acid
End point:	pH 3.6
Indicator:	Methyl orange
Titration factor (TF):	1.7

- Pipette 50 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 orange to red (pH: 3.6).
- the added mL of 0.5 N hydrochloric or 0.5 N sulphuric acid multiplied by the factor TF 1.7 give the concentration in g/L
- Divide this by 10 to get the value in %.

#### 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	36



## ADDITIONAL INFORMATION

### Disclaimer

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