

## BONDERITE C-AK 7163 CF/4

Known as Ridoline 7163 CF/4  
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### PRODUCT DESCRIPTION

BONDERITE C-AK 7163 CF/4 provides the following product characteristics:

<b>Technology</b>	Industrial Cleaner
<b>Product Type</b>	Alkaline Cleaner
<b>Application</b>	Parts Cleaning

BONDERITE C-AK 7163 CF/4 is an alkaline, two pack, cleaner for application by spray or dip. It is especially recommended where cleaning is followed by phosphate treatment. The formulation minimises alkaline passivation of steel surfaces and ensures that phosphate coatings are smooth and even. All detergents used in this product are classed as Biodegradable. The liquid formulation eliminates any risk of airborne dust problems sometimes found with powdered cleaners.

#### Application Areas:

BONDERITE C-AK 7163 CF/4 is suitable for use with automatic control equipment.

BONDERITE C-AK 7163 CF/4 is suitable for mixed metal production, for example where galvanised steel, electro-deposited zinc, zinc die castings or aluminum are present along with the steel.

### 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:

Chemicals required: BONDERITE C-AK 7163 CF/4

RIDOSOL 500CF

The normal working strength is 5 to 20 L/1,000 L for spray applications and 5.3 L/1,000 L for dip use. Add 0.5 to 1.5 L of RIDOSOL 500CF for every 10 L of BONDERITE C-AK 7163 CF/4 used.

First add the BONDERITE C-AK 7163 CF/4 to the water with the pump(s) on. Raise to operating temperature while circulating, then add RIDOSOL 500CF slowly with mixing to

the working bath.

#### Bath Control:

##### **BONDERITE C-AK 7163 CF/4 control points:**

Temperature	45 to 70 °C
Time spray	60 to 90 secs
Dip	90 to 600 secs
Spray pressure	1 to 2 bars (14 to 30 psi)

#### Concentration titration:

BONDERITE C-AK 7163 CF/4	Value
5 L/1,000	2 cm <sup>3</sup>
10 L/1,000	4 cm <sup>3</sup>
20 L/1,000	8 cm <sup>3</sup>
30 L/1,000	12 cm <sup>3</sup>

Local conditions may dictate you operate outside these parameters. Your Henkel Technical Service Representative will advise.

Measure 10 cm<sup>3</sup> of the bath solution into a flask, add 2 to 3 drops of phenolphthalein indicator solution and titrate with 0.1N hydrochloric acid until the pink color disappears.

The number of cm<sup>3</sup> of 0.1N hydrochloric acid added indicates the strength of the BONDERITE C-AK 7163 CF/4.

To replenish, add BONDERITE C-AK 7163 CF/4 at the rate of 2.5 L per 1,000 L of bath and RIDOSOL 500CF at the rate of 0.25 L per 1,000 L of bath for each cm<sup>3</sup> below the desired value.

#### Water Rinse:

Two water rinses are desirable after BONDERITE cleaning if phosphating is to follow. Flow sufficient water into each to keep them clean.

#### Equipment:

Mild steel equipment is satisfactory for the cleaner and rinse stages.

BONDERITE C-AK 7163 CF/4 in a dip application, performs most satisfactorily in a tank fitted with a means of agitation. Air agitation may also be used.



**Precautions:**

Full information on the hazards and safe handling of the chemicals supplied are given in the corresponding Material Health&Safety Data Sheet which must be read and understood by everyone handling or using this product.

**Classification:**

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

**Hazards identification**  
**Transport information**  
**Regulatory information**

**Storage:**

Recommended Storage Temperature	-5 to 40°C
Shelf-life, months	24

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