

BONDERITE C-AK G 34 A

Known as Ridoline G 34 A

February 2016

PRODUCT DESCRIPTION

BONDERITE C-AK G 34 A provides the following product characteristics:

Technology	Industrial Cleaner
Product Type	Alkaline Cleaner
Application	Metal Pretreatment

BONDERITE C-AK G 34 A is a strongly alkaline liquid cleaner normally used both in dip and spray equipment for etching Aluminium and Aluminium alloy. Due to its specific formulation BONDERITE C-AK G 34 A do not produce scales or sludge and therefore greatly reduces plant's maintenance costs.

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 the operating tank with clean tap water to $\frac{3}{4}$ of the final volume.
- Turn-on the recycling pump and heat up to working temperature.
- For 1,000 L bath add slowly 20 to 60 kg BONDERITE C-AK G 34 A.
- Make the final controls.

Operating Data:

BONDERITE C-AK G 34 A is generally used according the following application parameters:

	Spray	Dip
Concentration, %	2 to 5	3 to 6
Point B (for AL treatment)	max 50 mL	max 50 mL
Temperature, °C	45 to 60	45 to 60
Time, min	1 to 3	3 to 7
Pressure, kg/cm ²	1 to 2	-----

Bath Control:

Concentration:

- Place 5 mL of bath sample into a 250 mL Erlenmeyer-flask.
- Add 50 mL deionized water and 4 to 6 drops of Phenolphthalein indicator (0.3% hydro-alcoholic solution).
- Titrate with 0.1 N HCl solution until the colour turns from red to colourless.
- The number of mL 0.1 N Hydrochloric Acid used for the titration is the "Points A".
- Add to the same flask 2.5 to 3 g of Sodium Fluoride (NaF) or Potassium Fluoride (KF).
- If the solution turns again to red, keep on titrating with 0.1 N Hydrochloric Acid until the solution turns back to colourless.
- The number of 0.1 N Hydrochloric Acid used for this second titration is "Points B".
- Note: In case that after Sodium Fluoride addition no red colour does appear the "Points B" value is = 0.

Calculation:

BONDERITE C-AK G 34 A concentration is:

$$\text{Concentration} = (\text{Points A} - \frac{\text{Points B}}{3}) \times 0.37$$

Aluminium Concentration (Points B):

The amount of dissolved Aluminium into the bath keeps on growing as long as the bath ages and is requested by Points B.

The maximum "Points B" value accepted is 50 points, after this limit BONDERITE C-AK G 34 A has to be renewed.

General Remarks:

The replenishment has to be frequently made after each control in order to keep BONDERITE C-AK G 34 A concentration at the initial value.

Slight differences in the product appearance do not affect either its efficiency or performances.

The complete process equipment (tank, pumps, pipes, etc.) can be made of mild steel.

Avoid the use of aluminium or other light alloys.

The degreasing solution must remain clear: any floating impurities such as oil and foam must be removed by skimming or overflow.

Classification:

Please refer to the corresponding **Material Safety Data**

Sheets for details on:

Hazards identification

Transport information

Regulatory information

Storage:

Recommended Storage Temperature, °C 0 to 35

Shelf-life, months 24

(in unopened original packaging)

ADDITIONAL INFORMATION**Disclaimer****Note:**

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.

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