

## BONDERITE® C-IC 2635

Known as POLYPREP CLEANER 2635  
January 2024

### Product description

BONDERITE® C-IC 2635 provides the following product characteristics:

<b>Technology</b>	Acid cleaner
<b>Product type</b>	Acid cleaner
<b>Application</b>	Metal pretreatment

BONDERITE® C-IC 2635 (known as POLYPREP CLEANER 2635) is a phosphate-free acidic cleaner formulated primarily for cleaning of plastic surfaces. The cleaning solution is used in spray wash systems prior to the application of paint films or other surface treatments. It is suitable for a wide range of plastics including primed and raw SMC, polyurethane and polyurea RIM, ABS, TPO, TPE, PVC and polyethylene.

### Direction 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.

#### Equipment:

The process tank, housing, pumps and piping for use with process solution should be constructed of type 316L or 304L stainless steel. A secondary choice is 316 or 304 stainless steel fabricated with approved welding techniques. Nozzles should be fabricated from 316 stainless steel. The heat exchanger should be of polished 316 stainless steel when using steam or hot water heat. If gas fired burner tubes are used, they should also be made of stainless steel. All process circulating pump seals, valve seats, door seals, and other elastomers which come in contact with the working process solution should be EPDM, PTFE or FKM.

All chemical pump seals, valve seats and other elastomers which come in contact with the concentrated solution should be EPDM, PTFE or FKM.

Support equipment available from Henkel for this process includes: chemical feed pumps, level controls, transfer pumps and bulk storage tanks.

Your local sales representative should be consulted for information on Henkel's automatic process control equipment for this process and any additional questions.

### Operating data:

Total acid, points	12.8 ± 1.5
Time, seconds	30 - 180
Temperature, °F (°C)	120 - 150 (49 - 66)

### Process description:

The process for cleaning soiled plastics or plastics containing a slight amount of mold release normally consists of the following steps:

1. Preclean (optional)
2. Cleaning with BONDERITE® C-IC 2635 solution
3. Recirculated deionized water rinse
4. DI water rinse containing Bonderite rinse aid. Consult your Henkel representative to select the appropriate Bonderite rinse aid to use with your process.
5. Drying

### Bath make-up:

1. Fill the tank about 3/4 full with cold water and heat to 135°F.
2. Add 17.5 pounds (2.0 gallons) of BONDERITE® C-IC 2635 per 100 gallons (U.S.) of operating volume.
3. Add additional water to the operating level, stir to mix the solution thoroughly and heat to the operating temperature.

The chemical concentration in the cleaning solution may be increased or reduced depending upon the type of soil to be removed and the characteristics of the equipment used. The time and temperature are dependent upon solution concentration and cleaning requirements.

### Bath control:

Never pipet by mouth, use a pipet filler.

### Total acid:

1. Pipet a 100 ml sample into a 250-ml beaker.
2. Add 3 drops of Indicator 3 and titrate slowly with Titrating Solution 11 until 1 drop changes the solution from clear to a pink color which lasts as least 10 seconds.
3. The ml of Titrating Solution 11 used is the total acid value in points.

To increase total acid, add BONDERITE® C-IC 2635. With clean tap water only, 100 gallons of BONDERITE® C-IC 2635 per 100 gallons of bath will increase total acid about 6.5 points.

### After treatment:

#### Water rinsing

Water rinsing is recommended following the cleaning operation. Adequate rinsing is important. Suggested operation for each rinse is:

Time, seconds	30 - 60
Temperature, °F (°C)	80 - 100 (27 - 38)

Treating with BONDERITE M-PT POST TREATMENT:

BONDERITE M-PT POST TREATMENT rinses are strongly recommended after initial water rinsing. The rinse aid creates water break-free rinsing for plastics. It dramatically reduces or eliminates water spotting. Our representative should be consulted on the proper selection and use of these products.

Deionized Water Rinsing:

Final rinsing with deionized water is required to minimize water spotting. Design of the equipment is important to obtain the desired result with a minimum amount of deionized water.

Drying:

Drying to remove surface moisture is required. Oven drying or oven drying following air blow-off are acceptable techniques. Temperature of the oven should be compatible with the plastic substrate.

**Waste disposal information:**

Applicable regulations covering disposal and discharge of chemicals should be consulted and followed. Disposal information for the chemical, in the form as supplied, is given on the Material Safety Data Sheet for the chemical. The bath is acidic. Neutralization of rinse water or processing solution may be required prior to discharge to the sewer. The processing bath and sludge which accumulates in the bath can contain ingredients other than those present in the chemical as supplied and analysis of the solution and/or sludge may be required prior to disposal.

**Precautions:**

When handling the chemical product used in this process, the first aid and handling recommendations on the Material Safety Data Sheet for the product should be read, understood and followed.

The cleaner bath is acidic and can cause burns to skin and 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 for BONDERITE® C-IC 2635 .

**Classification:**

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

**Hazardous Information**  
**Transport Regulations**  
**Safety Regulations**

**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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