

BONDERITE C-IC 4955

Known as Deoxidizer 4955

November 2015

PRODUCT DESCRIPTION

BONDERITE C-IC 4955 provides the following product characteristics:

Technology	Metal Pretreatment
Product Type	Aluminum etching agent
Application	Concentration 3 to 5 %

BONDERITE C-IC 4955 is a liquid acidic product used diluted with water as a dip or spray deoxidising/desmutting treatment for aluminium, especially after alkaline etching.

At ambient temperature, BONDERITE C-IC 4955 removes smut, brightens the aluminium and improves the overall appearance prior to further treatment.

BONDERITE C-IC 4955 is especially recommended for use prior to chrome free conversion coatings for aluminium.

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.

Process Description:

A typical dip process for aluminium extrusions consists of the following steps :

- Clean in suitable BONDERITE cleaner
- Etch using BONDERITE etching product
- Water rinse
- BONDERITE C-IC 4955 treatment
- Water rinse
- D.I. water rinse
- BONDERITE chrome free conversion coating
- D.I. water rinse (optional)
- Dry off

Control Points:

Temperature	Shop temperature (unheated tank)
Treating time, min	1 to 5
Suggested bath strength, % (by volume)	3 to 5
Strength titration, mL	10.5 to 17.5

Bath Make-up:

Fill the tank with clean water up to $\frac{3}{4}$ of its volume.

For each 1,000 L of bath volume add:

BONDERITE C-IC 4955 30 to 50 L

Stir thoroughly, while making up the tank to operating level with water.

Your Henkel Representative will recommend the most suitable working strength for a particular application.

Bath Control:

This product contains hydrofluoric acid.

Measure 5 mL of the bath solution into a 250 mL flask, dilute with 100 cm³ of demineralised water and add a few drops of bromo phenol blue indicator.

Titrate with 0.1 N sodium hydroxide until the colour changes from yellow to blue.

The titration figure indicates the strength of the bath.

An addition of 2.8 litres of BONDERITE C-IC 4955 per 1,000 litres of bath will increase the strength titration by 1.0 mL.

Water Rinse:

At least one rinse is required after the BONDERITE C-IC 4955 treatment and this should be followed by a deionised water rinse before subsequent BONDERITE chrome free conversion coating. The rinses should be overflowed sufficiently to keep them clean.

Equipment:

The tank must be constructed of 316 stainless steel, polypropylene lined, fibre-glass, or other acid resistant material.

The working bath contains a low concentration of hydrofluoric acid.

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 40
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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Reference 0.1