

**BONDERITE C-NE 10640**

February 2021

**PRODUCT DESCRIPTION**

BONDERITE C-NE 10640 provides the following product characteristics:

<b>Technology</b>	Industrial Cleaner / Lubricants
<b>Product Type</b>	Neutral Cleaner / Industrial Metal Working Agents
<b>Application</b>	Parts Cleaning / Service product
Concentration	7 to 30 g/L
Operating Temperature	30 to 60 °C

BONDERITE C-NE 10640 is a neutral cleaner. It is composed of organic corrosion protection components, surfactants and inhibitors. Change of colour is caused by raw material and has no impact on performance. Passivation of steel and cast iron for following storage in closed and heated warehouses.

Additionally BONDERITE C-NE 10640 is a system cleaner designed to be used in emulsions. BONDERITE C-NE 10640 circulates with the coolant while production continues to operate and cleans the machine. This helps to spare a separate cleaning procedure. Due to the cleaning properties of BONDERITE C-NE 10640 the lifetime of the emulsion will be extended.

**Application Areas (Neutral cleaner):**

Cleaning with temporary corrosion protection after cutting, stamping or pressing and simultaneous passivation of steel, cast iron and aluminium, e.g. in the metal-working industry as well as in the manufacture of engines and transmissions. BONDERITE C-NE 10640 is used in spray processes, suitable for high pressure operations.

**TECHNICAL DATA**

Appearance	clear, bright yellowish liquid
Density at 20°C, DIN 51757	~1.01 g/cm <sup>3</sup>
pH-value (2% solution)	~8.6 (20 g/l)

**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 for 1,000 L (spray process):**

Add the required amount carefully to the circulation system.

Concentration on steel and nonferrous metals	5 to 20 g/L
Concentration on cast iron	7 to 30 g/L

**Operating Data:**

Temperature	30 to 60°C
Duration of treatment	0.5 to 3 min

**Bath Control (Neutral cleaner):**

BONDERITE C-NE 10640 solution is controlled by the titration of total alkalinity. .

Sample, mL	100
Titrant	0.5 N hydrochloric or 0.5 N sulphuric acid
End-point	pH 3.6
Indicator	methylorange
Titration factor (TF)	3.36

- With a pipette transfer 100 mL bath solution into a clean 300 mL Erlenmeyer-flask.
- Add 4 to 5 drops of indicator.
- Titrate the solution with 0.5 N hydrochloric or sulphuric acid.
- The endpoint will be shown by a colour change from orange to red (pH: 3.6).
- Multiply the consumption of the acid solution with the titration factor (TF), to get the concentration in g/L
- Divide this by 10 to get the value in %.

**Bath Control (System cleaner):**

BONDERITE C-NE 10640 is designed to be used at 1% concentration in the emulsion, 48 hours before the machine is drained.

After the old emulsion has been dumped, the initial charge can follow directly.

**Special Remarks:**

Corrosion protection is increased,- if deionized water is used instead of tap water and the work-pieces are stored at low relative air humidity and shielded against weather exposure.

**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	24
Frost-sensitive	yes

**ADDITIONAL INFORMATION****Disclaimer**

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Reference 0.6