

BONDERITE C-NE 6765 I

March 2021

PRODUCT DESCRIPTION

BONDERITE C-NE 6765 I provides the following product characteristics:

Technology	Industrial Cleaner
Product Type	Neutral Cleaner
Application	Corrosion protection
Concentration	
in immersion process	20 to 50 g/L
in spray process	10 to 30 g/L
Operating Temperature	30 to 80 °C

BONDERITE C-NE 6765 I is a corrosion protection emulsion, applicable in spray and immersion processes especially in the last zone of multistage plants.

BONDERITE C-NE 6765 I can be also used as a mineral oil based general purpose coolant, suitable for a wide range of operations and water hardness.

Application Areas:

Passivating of steel and cast iron for subsequent storage in closed and heated warehouses.

Also Metal working for steel, cast iron and aluminium.

BONDERITE C-NE 6765 I is composed of organic corrosion protection components, non-ionic surfactants and mineral oil fractions.

TECHNICAL DATA

Appearance	slightly yellow liquid
Density at 20°C, DIN 51757	~0.97 g/cm ³
pH-value (2% solution):	9.0 to 9.6 (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:

Add the required amount carefully to the circulation system.

For passivation:	
in immersion process	20 to 50 g/L
in spray process	10 to 30 g/L

For metal working:	Make-up	Top-up
Drilling, Turning	3 to 5 %	2 to 4 %
Milling	4 to 6 %	3 to 5 %
Grinding	3 to 4 %	1 to 3 %

Operating Data:

Temperature	30 to 80°C
Duration of treatment	0.5 to 3 min

Foam behaviour:

Applicable in the given concentration and temperature range without interfering foam.

An emulsion of 2% is only sprayable in water with more than 10 degree German hardness (specially Calcium hardness).

Bath Control:

BONDERITE C-NE 6765 I solution is controlled by titration of total alkalinity.

Feed, mL	100 mL
Titrant:	0.5 N hydrochloric or 0.5 N sulphuric acid
End point:	pH 3.6
Indicator:	Methyl orange
Titration factor (TF):	2.8

- 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 0.5 N 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 %.

Another control method:

Splitting with acid (DIN51360)

100 mL Emulsion is split with concentrated acid. The measured amount of mL separated oil multiplied with 1.15 corresponds to the concentration in g/L.

Additional Directions:

Corrosion protection is increased, if deionized water instead of tap water is used 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 (in unopened original packaging)	12
Frost-Sensitive	no

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.

In case products are delivered by Henkel Belgium NV, Henkel Electronic Materials NV, Henkel Nederland BV, Henkel Technologies France SAS and Henkel France SA please additionally note the following:

In case Henkel would be nevertheless held liable, on whatever legal ground, Henkel's liability will in no event exceed the amount of the concerned delivery.

In case products are delivered by Henkel Colombiana, S.A.S. the following disclaimer is applicable:

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. 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.

In case products are delivered by Henkel Corporation, or Henkel Canada Corporation, the following disclaimer is applicable:

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

Trademark usage

Except as otherwise noted, all trademarks in this document are trademarks of Henkel Corporation in the U.S. and elsewhere. ® denotes a trademark registered in the U.S. Patent and Trademark Office.

Reference 0.3