

BONDERITE M-CR 800

Known as Novacoat 800

February 2018

PRODUCT DESCRIPTION

BONDERITE M-CR 800 provides the following product characteristics:

Technology	Metal Pretreatment
Product Type	Conversion Coating
Application	Chromate Coating

BONDERITE M-CR 800 is a liquid product containing chromium, which is used for the formation of conversion layers on steel, galvanized steel, aluminum and other metallic substrates.

Parts treated with BONDERITE M-CR 800 do not need rinsing.

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.

Application:

The conversion layer produced by the BONDERITE M-CR 800 is an especially suitable treatment to increase the adherence of powdered or liquid paint, as well as the corrosion resistance of the painted parts.

BONDERITE M-CR 800 can be used in spray or immersion installations.

BONDERITE M-CR 800 is a suitable process for the continuous treatment of wire and strap.

Operating Parameters:

BONDERITE M-CR 800 is applied according to the following sequence:

Stage 1: Degreasing, to be selected according to the metals to be treated.

Stage 2: Rinsing

Stage 3: Rinsing

Stage 4: BONDERITE M-CR 800

For the preparation of the BONDERITE M-CR 800 coating, the use of deionized water is recommended, with conductivity below 150 µS.

Subsequently, the material is dried, preferably with hot air at approx. 120°C.

To avoid excess of product in the draining areas of the part, it is recommended to install blowers to eliminate excess liquid and drop or draining marks. In the case of wire, tube or strap,

the use of brushes or draining rollers provides very uniform layers.

For the assembly and maintenance of the coating, the same product is used and its working conditions are the same for all metal substrates.

Concentration:	10 to 20 % v/v
Temperature:	ambient - 30 °C
Time:	1.0 to 180 sec.
pH:	2.5 ± 0.5

Control:

The maintenance of the coating is minimal. It is recommended to control the pH and the concentration weekly.

Take 10 mL of the bath and dilute it with approximately 50 mL of water, add 2 to 3 drops of phenolphthalein solution and titrate with 0.1 N sodium hydroxide until it turns into a permanent pink color.

Record the number of mL of sodium hydroxide solution consumed as the V value.

V mL = Concentration % v/v of BONDERITE M-CR 800

To increase the concentration by 1 point, add 1% v/v of the product.

Equipment:

The tank and its equipment must be that of stainless steel, preferably the 316 type, or acid-resistant plastics.

General Information:

BONDERITE M-CR 800 is an acid product that contains hexavalent chromium; therefore, the concentration and its solutions must be handled with caution.

The use of glasses, gloves and protective clothing is recommended.

In case of direct contact with the skin, wash with water and soap. If it comes in contact with the eyes, wash thoroughly with water for several minutes and seek medical assistance.

Concentrated solutions or accidental spills should be treated before they are spilled, to reduce and precipitate chromium, and neutralize them until they reach the values permitted by law.

Storage:

Recommended Storage Temperature, °C	5 to 50
Shelf life, months (in unopened original packaging)	24

BONDERITE M-CR 800 must be stored in its original containers and in a cool place.

Classification:

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

Sheets for details on:

Hazards identification

Transport information

Regulatory information

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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