

## BONDERITE M-CR NR-6022

Known as Alocrom NR 6022

August 2015

### PRODUCT DESCRIPTION

BONDERITE M-CR NR-6022 provides the following product characteristics:

<b>Technology</b>	Metal Pretreatment
<b>Product Type</b>	Chromating
<b>Application</b>	Chromating of Aluminium

BONDERITE M-CR NR-6022 is a dry-in-place Chromate treatment for aluminium, zinc, zinc alloy and cold rolled steel surfaces for continuous strip lines.

It produces a uniform, non-metallic coating which improves the adhesion, inhibits corrosion and increases the durability of paint finishes.

### TECHNICAL DATA

Density (20°C), g/mL <sup>-1</sup>	1.18 to 1.22
pH ( % solution)	3.2 to 3.6
Chrom(VI)-content, mL 0.1 Na <sub>2</sub> S <sub>2</sub> O <sub>3</sub> (10 mL sample, 2 Vol.% solution)	8.0 to 8.5

### 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 concentration depends on the wet-film thickness and the desired coating weight:

BONDERITE M-CR NR-6022	2 to 20 Vol. %
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#### Coating Weights:

on all substrates	20 to 40 mgm <sup>2</sup> Cr
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A wet film of 6 mL/m<sup>2</sup> gives the following coating weights:

Vol.-%	mg Cr/m <sup>2</sup>
4	24
6	36
8	49

#### Process Description:

1. Cleaning
2. Hot water rinsing
3. Drying
4. BONDERITE M-CR NR-6022
5. Oven Drying

#### 1. Cleaning:

All metal must be free of grease, oil, rust, scale and other foreign matter before the coating solution is applied. A complete line of BONDERITE cleaners is available. Details for the proper one can be taken from the technical data sheets.

#### 2. Hot water rinsing:

After cleaning, the metal must be rinsed thoroughly with hot water. The overflow rate should be high enough to keep the rinse clean and free from scum and contamination.

#### 3. Drying:

The strip must be dried prior to the application of the treatment solution.

#### 4. BONDERITE M-CR NR-6022:

The coating solution is applied at temperatures from 20 to 25 °C, in a uniform film to the properly cleaned strip. The coated strip should not be rinsed.

#### 5. Oven drying:

The treated strip is passed through a dry-off oven. The PMT has to be at least 65 °C.

#### Equipment:

The holding tank, pump, piping and solution trays should be constructed of stainless steel.

The holding tank and piping may be constructed of, or lined with plastic (PVC etc.).

The applicator rolls should be constructed of polyurethane or Hypalon, shore hardness 50 to 70.

The pick-up rolls should be engraved and chromium plated.

#### Caution:

BONDERITE M-CR NR-6022 contains chromic acid <10 % in solution.

#### 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 50
Shelf life, months (in unopened original packaging)	12

**ADDITIONAL INFORMATION****Disclaimer****Note:**

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Reference 0.1