

# BONDERITE M-CR NR-6207 RT

Known as Alodine NR 6207 RT

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## PRODUCT DESCRIPTION

BONDERITE M-CR NR-6207 RT 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-6207 RT is a liquid Chromium-VI-free pretreatment designed for use on aluminium and its alloys.

BONDERITE M-CR NR-6207 RT coatings show good corrosion resistance and paint bonding characteristics.

## Application Areas

For food grade applications with organic coating systems pasteurising and sterilising tests give good results.

In connection with these tests, very good feathering-test results with AlMg<sub>5</sub> alloys can be achieved.

Since only fresh solution is used, there are no bath control or replenishment operations.

When using BONDERITE M-CR NR-6207 RT, a rollcoater or chemcoater is necessary.

No final rinse is required after conversion treatment.

## TECHNICAL DATA

Density (20°C), g/mL <sup>-1</sup>	1.07 to 1.11
pH (1 % solution)	2.7
Chrom(III)-content, mL 0.1 Na <sub>2</sub> S <sub>2</sub> O <sub>3</sub> (5 mL sample, 25 Vol.% solution)	~23.7

## 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-6207 RT            5 to 50 Vol. %

### Coating Weights:

20 to 50 mg/m<sup>2</sup> Cr

At a wet film of 6 ml/m<sup>2</sup> a concentration of 12.5 Vol.% results in a coating weight of 25 mg/m<sup>2</sup> Cr.

## Process Description:

1. Cleaning
2. Hot water rinsing
3. Drying
4. BONDERITE M-CR NR-6207 RT
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-6207 RT:

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-6207 RT contains chromium-III-fluoride <10 % and phosphoric 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    15 to 30

Shelf life, months                                12

(in unopened original packaging)

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

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