

BONDERITE M-FE 7760

Known as Duridine 7760
August 2022

PRODUCT DESCRIPTION

BONDERITE M-FE 7760 provides the following product characteristics:

Technology	Cleaner - coater
Product Type	Acid 1-2-components
Application	Spray
Concentration	10 to 30 g/L
Temperature	45 to 60°C

Application Areas:

BONDERITE M-FE 7760 is used in spray- and spray/immersion processes. It must be combined with a suitable cleaning booster.

Pre-painting treatment of spare parts in automotive, appliances, metal furniture industries and, in general, on all plate pieces which are not much exposed to corrosive agent aggression (humidity, atmospheric conditions, etc.). Modification of the following data may be necessary due to specific needs of the phosphating line.

Process components

BONDERITE M-FE 7760
BONDERITE M-AD 565
BONDERITE M-AD 338 or BONDERITE M-AD 339 L, if needed.

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.

Operation:

Total Acid	3.1 to 9.3
pH-value	4.5 to 5.5
Temperature, °C	45 to 60
Time for the spray process, min	2 to 3
Spray pressure, bar	1 to 2

Bath make-up:

Fill the bath with water and heat it to operating temperature. Add with running circulating pump the correct amount of BONDERITE M-FE 7760. Please note that BONDERITE M-FE 7760 generates foam when the spray equipment starts working at temperatures below 45 °C.

Build-up for 1,000 L solution:

BONDERITE M-FE 7760 10 to 30 kg = 7.7 to 23.1 L
BONDERITE M-AD 565 to
adjust the pH-value

Remarks:

A BONDERITE M-FE 7760 bath with a concentration of 10 g/L in deionized water has a pH-value of 3.2. The pH-value depends on the concentration and the hardness of the water. With addition of BONDERITE M-AD 565 the pH-value increases. At the same time, the "total acid" pointage decreases.

The correct amount of BONDERITE M-AD 565 has to be determined on site. A start pH-value of 4.5 to 4.8 is recommended.

Bath Monitoring:

The BONDERITE M-FE 7760 bath can be checked by titration of "total acid" or by pH-measurement.

Titration of Total Acid:

- Pipette a 10 mL sample into a 150 mL beaker and dilute with about 50 mL deionized water.
- Add 3 to 5 drops of indicator phenolphthalein. .
- Titrate with 0.1 N sodium hydroxide from colorless to the development of a permanent pink color.
- The mL of 0.1 N sodium hydroxide required indicates the "total acid" value in points.

It is also possible to titrate the "total acid" with a pH-electrode. The consumption of mL 0.1 N sodium hydroxide until a pH-value of 8.5 is the "total acid" pointage.

Replenishing of the bath:

To increase 1 point of "Total Acid" add per 1,000 L bath:
BONDERITE M-FE 7760 3.2 kg = 2.5 L

Classification:

Please refer to the corresponding **Safety Data Sheets** for details on:

Hazards identification
Transport information
Regulatory information



Storage:

Recommended Storage Temperature, °C -5 to 40
 Shelf-life, months 36

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