

BONDERITE M-FE 80

Known as Novaphos F 80

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PRODUCT DESCRIPTION

BONDERITE M-FE 80 provides the following product characteristics:

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

BONDERITE M-FE 80 is a liquid product based on acidic phosphates formulated to treat ferrous material.

BONDERITE M-FE 80 forms on the treated surface an amorphous phosphatic coating, mainly composed by iron phosphates, which provides good adhesion for liquid, powder or electrophoretic paints.

BONDERITE M-FE 80 used in combination with surfactant additive provides cleaning and phosphating in the same stage.

Subsequent partial continuous renewal rinse and possibly a final rinse with demineralized water is suggested. A suitable final passivation improves results.

Application Areas

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.).

Composition

- Acid phosphates
- Phosphating accelerants

TECHNICAL DATA

Appearance	clear, colourless up to greenish liquid
Density at 20°C (DIN 51757)	~1.25
pH-value (100%)	~2

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:

BONDERITE M-FE 80 is used in two or more stages spray or immersion treatments with the following indicative working parameters:

	Spray/immersion
Concentration (g/L)	10 to 30 / 30 to 60
Total Acid	3.5 to 10 / 10 to 20
pH-value	4 to 5.5
Temperature, °C	30 to 70
Treatment time, min	1 to 3 / 3 to 6
Pressure, atm.	1 to 2

Bath make-up:

Fill the tank with tap water to 3/4 of the operating volume. Start recirculating pumps and heat up to the working temperature.

Add BONDERITE M-FE 80, surfactant additive suggested by our technical service and BONDERITE M-AD 565 to adjust pH-value (depending on water alkalinity, up to 25 % on BONDERITE M-FE 80).

Fill up the tank to the final level, heat to operating temperature and let recirculate for 15-20'.

Make the controls

Bath monitoring:

The BONDERITE M-FE 80 bath solution is controlled by the following analysis.

Titration of Total Acid:

- Pipette 10 mL of working bath into a 250 mL flask.
- Add about 10 mL DI water and some drops of Phenolphthalein Indicator.
- Titrate with 0.1 N sodium hydroxide (NaOH) until the colour turns to stable pink for at least 20".
- The mL of 0.1 N NaOH used for the titration is the Total Acid value (V).

Titration of pH-value:

- Transfer 100 mL bath in a 250 mL beaker and cool it to 20°C.
- Measure the pH value preferably with a pHmeter previously set at pH 4 and 7.
- If correction are needed act as follows:
BONDERITE M-FE 80 to lower the pH.
BONDERITE M-AD 565 to increase the pH.

Replenishment:

The bath is replenished with BONDERITE M-FE 80 according to the Total Acid value.

To increase Total Acid by 1 point, add about 2.7 kg

BONDERITE M-FE 80 for each 1000 lt of bath.
Automatic dosage/control with Henkel Lineguard against pH is suggested.

Special Remarks:

In case of oil accumulation on the bath surface, a partial overflow is advisable in order to avoid contamination on the treated material. Tanks and other parts of the plant should be made of stainless steel even if the product is compatible with soft steel. The pumps to be installed in single areas have to grant a spray pressure not lower than 1,5 atm in all active phases, except for final passivation, where the required spray pressure can be 0.8÷1.0. Higher pressures can help degreasing

Caution:

BONDERITE M-FE 80 is an acid product! Follow the safety regulations. Shield eyes with tightly fitting safety glasses, wear protection gloves and acid-resistant safety clothes! Avoid contact with skin! Do not inhale vapours!

Classification:

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

Hazards identification
Transport information
Regulatory information

Waste Water Treatment:

Neutralization is required. Disposal must be carried out according to the local directives.

Storage

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

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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Reference 0.1