

**BONDERITE M-PA 6010 PASSIVATE**

Known as Passerite 6010

May 2015

**PRODUCT DESCRIPTION**

BONDERITE M-PA 6010 PASSIVATE provides the following product characteristics:

<b>Technology</b>	Metal Pretreatment
<b>Product Type</b>	Passivation
<b>Application</b>	Roll coater/ spray-squeegee

BONDERITE M-PA 6010 PASSIVATE is a liquid Chromium-VI-free chemical used to produce coatings on galvanized steel and its alloys.

BONDERITE M-PA 6010 PASSIVATE coatings show good corrosion resistance for storage and transportation.

**TECHNICAL DATA**

Density (20°C), g/mL <sup>-1</sup>	1.37
pH (1 % solution)	~1.8
Chrom(III)-content, mL 0.1 Na <sub>2</sub> S <sub>2</sub> O <sub>3</sub> (5 mL sample, 25 Vol.% solution)	~57

**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:**

For application of BONDERITE M-PA 6010 PASSIVATE a rollcoater is required. It could also be done by spray/immersion - squeegee application. No final rinse is required after conversion treatment.

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

BONDERITE M-PA 6010 PASSIVATE                      5 to 50 Vol. %

**Coating Weights:**

15 to 45 mg/m<sup>2</sup> Cr

At a wet film of 6 mL/m<sup>2</sup> a concentration of 7.3 % or 5.7 Vol.% results in a coating weight of 35 mg /m<sup>2</sup> Cr.

**Process Description:**

1. Cleaning
2. Hot water rinsing
3. Drying
4. BONDERITE M-PA 6010 PASSIVATE\*
5. Oven Drying

\*Henkel has developed Lineguard BONDERITE for optimum application of this product.

**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-PA 6010 PASSIVATE:**

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 45 °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-PA 6010 PASSIVATE contains phosphoric acid <20 % 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)	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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