

## BONDERITE S-FN 6300

November 2017

### PRODUCT DESCRIPTION

BONDERITE S-FN 6300 provides the following product characteristics:

<b>Technology</b>	Industrial Cleaner
<b>Product Type</b>	Corrosion protection, oil-free
<b>Application</b>	Passivating Agent

BONDERITE S-FN 6300 is a liquid alkaline product that provides high corrosion inhibition, in particular for neutralizing stages of ferrous materials after acid pickling.

BONDERITE S-FN 6300 can be easily dissolved in cold water and, in case no further rinse follows, it represents an effective anti-oxidizing treatment for pieces destined to internal storage before subsequent operations.

BONDERITE S-FN 6300 can also be profitably used as anti-oxidizing additive for pressure test tanks and for final passivation tanks after alkaline cleaning.

### 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:

BONDERITE S-FN 6300 is used as aqueous solution in both spray and dip applications with the following indicative working parameters:

<b>Working parameters</b>	<b>Spray</b>	<b>Dip</b>
Concentration, g/L:		
passivation after pickling:	40 to 50	40 to 50
passivation after cleaning:	20 to 30	20 to 30
for pressure test:	5 to 10	8 to 12
as passivating:	2 to 5	3 to 6
Temperature, °C:	20 to 50	20 to 50
Time, sec:	≥40	≥60

Higher temperatures are recommended when quick drying of the pieces is required.

Best working parameters can be defined with Our Technical Department case by case.

#### Bath Make-up:

- Fill the tank with clean tap water.
- Activate the recirculating pumps and heat to the working temperature.
- Add 2 to 50 kg of BONDERITE S-FN 6300 for each 1,000 L of bath according to the working conditions.
- Let the bath homogenise for approx. 10 to 12 minutes.

Check the pH value before use.

#### Bath Control:

##### pH determination:

Transfer 100 mL of bath into a 250 mL beaker and cool it down to 20°C. Determine the pH value using a pHmeter previously calibrated at pH values of 4 and 7 (when a pHmeter is not available use pH paper indicators).

A treatment tank prepared as indicated above should have the following values:

<b>Use</b>	<b>Conc.</b>	<b>pH</b>
after pickling:	40 to 50	~11.5 to 12
after cleaning:	20 to 30	~11.0 to 11.5
for pressure test:	5 to 10	~10.5 to 11
as passivating:	2 to 5	10 to 10.5

#### Replenishing:

During the process feed the bath with BONDERITE S-FN 6300 according to pH value obtained by the periodical check. The maintain the pH in the range fixed by Our Technical Department replenish the bath with periodical additions of BONDERITE S-FN 6300 experimentally determined. In post-pickling neutralizing processes it is possible to set a lower pH range in case keeping initial pH value results too difficult due to remarkable acid drag-in. In any case the pH value must not be lower than 10 to 10.5.

#### Caution:

Tanks and all relevant parts of plant can be made of mild steel. The pressure of spray pumps, where installed, must be adequate for a good wetting of the specimens (P = 0.8 – 1.2 ATE).

#### Waste Water Treatment:

The bath must be treated in a waste water plant before discharge.

#### Storage:

Recommended Storage Temperature, °C	5 to 35
Shelf-life, months	36
(in original packaging, in a recovered area)	

**Classification:**

Please refer to the corresponding **Material Safety Data**

**Sheets** for details on:

- Hazards identification**
- Transport information**
- Regulatory information**

**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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