



BONDERITE S-MA 527 HT

Known as TURCO Form Mask 527 HT
September 2013

PRODUCT DESCRIPTION

BONDERITE S-MA 527 HT provides the following product characteristics:

Technology	Temporary protective coating
Product Type	Temporary protective coating
Application	Immersion and Manual

BONDERITE S-MA 527 HT is a one package, hand strippable, air-drying and curing protective coating that can be applied by dip, or brush. Its intended use is to protect metal surfaces during successive fabrication operations such as chemical cleaning, pickling, etching chromic acid and phosphoric acid anodizing and electro depositing of metal coatings. It will also withstand abrasion, bending, forming, heat treatment up to 180°C etc.

Application Areas

BONDERITE S-MA 527 HT is used as protective coating.

TECHNICAL DATA

Appearance	Viscous blue liquid
Density, kg/l	1.026
Soild content (120°C), %	40 to 50
Viscosity (Zahncup 25 °C)	140 to 160

DIRECTION OF 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.

Use instructions

Dip Applications

1. BONDERITE S-MA 527 HT is supplied in ready to use consistency.
2. Slowly immerse clean part into the solution.
3. Remove part from the dip-tank and avoid direct drainage

of excess coating into the diptank as this may introduce air bubbles into the mask.

4. The coated part is left to dry to a tack free surface condition, rotated 180° in vertical position and dipped again to apply a second coat is necessary.

Brush or roller coat

1. Apply BONDERITE S-MA 527 HT to the clean part with soft bristle brush or roller as described.
2. Allow the part to dry to a tack free condition. Atmospheric conditions may vary the time required to reach the tack free condition.
3. Apply subsequent coats to reach the needed film thickness for the specific job. Recommended coating thickness is from 250-400 micrometer depending on the process time and aggressivity of the medium used.

For air cure schedule: after final coat of mask is tack free, allow coating to cure at ambient temperature overnight.

The coating may also be oven-cured after its tack free condition has been reached for 60 minutes at 110°C.

Storage

Temperature, °C	0 to 40
Shelf-life (in unopened original packaging), months	24

Classification

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

Hazardous Information
Transport Regulations
Safety Regulations



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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