

BONDERITE C-AK 2795 IT

Known as P3 Galvaclean 2795 IT

January 2016

PRODUCT DESCRIPTION

BONDERITE C-AK 2795 IT provides the following product characteristics:

| | |
|--------------------------|--------------------|
| Technology | Industrial Cleaner |
| Product Type | Alkaline Cleaner |
| Application | Parts Cleaning |
| Concentration, g/l | 15 to 150 |
| Operation Temperature °C | 30 to 90 |

BONDERITE C-AK 2795 IT is a highly alkaline liquid product which has a yellowish colour and it is used with other cleaning additives for degreasing of metallic surfaces like steel. It can also be used for copper, zinc, and their alloys with adjustments of the working parameters.

Due to the presence of sequestering and chelating agents, BONDERITE C-AK 2795 IT is specifically recommended for chemical and electrolytic cleaning operations, but it is equally suitable for the preparation of materials before chemical conversion, enamelling, polishing treatments, etc.. Other possible applications of BONDERITE C-AK 2795 IT are de-phosphatising processes and ultrasound cleaning if used with other additives.

BONDERITE C-AK 2795 IT results economic because of its high concentration.

The use of the product in combination with a cleaning additive containing surfactants allows to remove even the strongest pollutants from the treated surfaces.

TECHNICAL DATA

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|---------------------------------------|---|
| Appearance | colourless to pale yellow, clear liquid |
| Density, g/cm ³ | 1.415 |
| pH-value (in a solution of 10 g/L) | ~13 |

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 C-AK 2795 IT is used in aqueous solution as supplied or with the addition of another cleaning additive at the following indicative working parameters:

Application by dip:

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|----------------|---|
| Concentration | 30 to 60 g/l (possible additive: 2 to 10 g/l) |
| Temperature | 50 to 90 °C |
| Treatment time | 5 to 15 min |

Application by (anionic-cationic) electrolytic cell for iron:

| | |
|-------------------|---------------------------|
| Concentration | 60 to 80 g/l |
| Temperature | 30 to 60 °C |
| Treatment time | 1 to 5 min |
| Current intensity | 2 to 10 A/dm ² |

Application by (anionic-cationic) electrolytic cell for alloys:

| | |
|-------------------|---------------------------|
| Concentration | 60 to 80 g/l |
| Temperature | room temperature |
| Treatment time | 20 sec to 5 min |
| Current intensity | 2 to 10 A/dm ² |

Ultrasound application:

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|----------------|---|
| Concentration | 30 to 60 g/l (possible additive: 2 to 10 g/l) |
| Temperature | 50 to 70 °C |
| Treatment time | 2 to 5 min |

Application by spray:

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|----------------|---|
| Concentration | 15 to 40 g/L (possible additive: 2 to 10 g/l) |
| Temperature | 30 to 70 °C |
| Treatment time | 1 to 5 min |
| Pressure | 1.5 to 2 Atm |

Bath make-up:

- Fill the operating tank with clean tap water to 3/4 of the final volume.
- Activate the recirculating pump and heat to operating temperature.
- Add carefully the requested amount of BONDERITE C-AK 2795 IT and the possible additive according to the application type.
- Fill the tank to the final volume and bring the bath to operating temperature. Let homogenise for minutes.
- Make the final controls.

Bath Control:

Control the working bath through free alkalinity determination.

A standard with 50 g/l BONDERITE C-AK 2795 IT concentration should have a value of approx. 3.0.

Free alkalinity:

- Pipette 10 ml of working bath into a 250 ml flask.
- Add 25 ml deionized water.
- Add 3 to 5 drops of phenolphthalein indicator (1% hydroalcolic solution).
- Titrate the solution with 1 N HCl.
- The endpoint will be shown by a colour change from yellow to red.
- The ml of 1 N HCl used for the titration represent the free alkalinity.

| | |
|--|--------------|
| BONDERITE C-AK 2795 IT concentration (g/l) | 1 N HCl x 17 |
| BONDERITE C-AK 2795 IT concentration (ml/l) | 1 N HCl x 12 |

Replenishing:

The working bath must be periodically controlled and kept at the right concentration fixed at the initial stage.

For each 1,000 l of bath and for each missing point add about 17 kg (12 l) of BONDERITE C-AK 2795 IT.

Additions of the possible additive are fixed according to the amount the product replenished (normally it is about 5 to 10 %).

Caution:

After a possible separation of oil phase, the exhausted bath has to be treated in a water-waste plant to adjust the pH value and to produce solid precipitations before final discharge. If the bath contains cleaning additives perform a further treatment to remove residual oils and surfactants.

The tanks and the other parts of the plant can be made of common steel. Avoid using aluminium and other light alloys.

Classification:

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

Hazardous Information
Transport Regulations
Safety Regulations

Storage

| | |
|--|-----------|
| Recommended Storage Temperature | 4 to 35°C |
| 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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Reference 0.0