

# BONDERITE C-AK 2260 IT

Known as Ridoline 2260 IT  
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## PRODUCT DESCRIPTION

BONDERITE C-AK 2260 IT provides the following product characteristics:

<b>Technology</b>	Industrial Cleaner
<b>Product Type</b>	Alkaline Cleaner
<b>Application</b>	Multifunctional

BONDERITE C-AK 2260 IT is a liquid, alkaline, multifunctional cleaner for metal surfaces. In combination with specific additives, BONDERITE C-AK 2260 IT can be used for many industrial applications, such as:

- 1) Dephosphating (dip and spray)
- 2) Electrolytic cleaning
- 3) Chemical cleaning (dip and spray)
- 4) Alkaline paint-stripping (dip and spray)
- 5) Descaling (dip and spray)

BONDERITE C-AK 2260 IT contains lots of caustic components, which grant to the bath a high saponification capacity for animal and vegetal fats and ensure high electrical conductivity.

In addition, BONDERITE C-AK 2260 IT contains a high amount of complexing agents which allow sequestering of dissolved metallic ions and prevent their re-deposition; finally, they avoid negative action due to limestone coming from water used for the bath.

BONDERITE C-AK 2260 IT can be used both on ferrous material and on copper alloys (by adjusting work parameters); on the contrary, it can't be used for light materials such as aluminium, zinc, etc.

Used by spray or dip, BONDERITE C-AK 2260 IT is normally assisted by a suitable cleaning additive.

## 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:

#### 1) Dephosphating

Used by oneself or with suitable additive, BONDERITE C-AK 2260 IT performs excellent dissolving action on phosphatic coatings, even high weight ones, and is used at the following average working parameters:

Concentration	70 to 130 g/L
Temperature	70 to 80°C
Time	to be set
Free Alkalinity	6 to 11 pts
Pressure (spray)	2 to 10 bar
Spray surfactant additive	1 to 3 g/L BONDERITE C-AD 0508 IT
Dip surfactant additive	1 to 3 g/L BONDERITE C-AD 0506

## 2) Electrolytic Cleaning

Normally used in the anodic phase for steel and copper materials, BONDERITE C-AK 2260 IT can also be used in cathode phase, cathode-anodic phase and in inverted systems. It is recommended not to use foaming detergent additives.

Concentration	100 to 170 g/L
Free Alkalinity	8 to 15 pts
Temperature	20 to 60°C
Time	20 to 300 sec
Current density	2 to 20 A/dm <sup>2</sup>

## 3) Chemical Cleaning

Assisted by a specific detergent additive suggested by our Technical Service, BONDERITE C-AK 2260 IT ensures a rapid and complete removal of surface pollutants when used at following conditions:

	Spray / Immersion
Concentration	40 to 60 g/L / 60 to 100 g/L
Free Alkalinity	3.5 to 5 pts / 5 to 8.5 pts
Time	to be set
Pressure	1 to 2.5 bar
Additive:	to be chosen according to the pieces to be treated and application

## 4) Paint stripping

Used by spray or dip, BONDERITE C-AK 2260 IT ensures a rapid removal of many types of paint, liquid, powder or electrophoretic, when used at following conditions. The combination with specific additives (as BONDERITE S-ST 5941 IT) speeds up the paint stripping operation and must be discussed with Our Technical Service.

Concentration	50 to 150 g/L
Free Alkalinity	4 to 13 pts
Time	to be set
Pressure	1 to 2.5 bar

### 5) Descaling

Due to its complexing and caustic components BONDERITE C-AK 2260 IT can be used for cleaning and descaling of tanks and crystalline phosphate plants.

Concentration	200 to 300 g/L
Temperature	90 to 100°C
Time	to be set
Stripping additive	to be decided (i.e. BONDERITE S-ST 5941 IT50 to 100 g/L)

### Bath Make-up:

1. Fill the tank up to approximately 3/4 of its operating volume.
2. Heat up to the working temperature.
3. Add slowly and carefully the required amount of BONDERITE C-AK 2260 IT (and additives) and mix through recirculation to complete homogeneity.
4. Make the controls.

### Bath Control:

BONDERITE C-AK 2260 IT solution is controlled by free alkalinity.

- Add 50 mL of DI water to 10 mL of operating bath.
- Add some drops of Phenolphthalein Indicator and 10 mL of Reattivo DF.
- Titrate the solution with 1 N hydrochloric acid.
- The endpoint will be shown by a colour change from pink-violet to colourless.

Being "A" the number of ml of Hydrochloric Acid used to achieve colour change:

Concentration	
BONDERITE C-AK 2260 IT (g/L)	A. x 11.6
BONDERITE C-AK 2260 IT (mL/L)	A. x 8.2

### Aluminium determination:

- Add 50 mL of DI water to 10 mL of operating bath.
- Add some drops of Phenolphthalein Indicator and 10 mL of Reattivo DF.
- Titrate with 1 N hydrochloric acid.
- The endpoint will be shown by a colour change from pink-violet to colourless.
- Mark as "A" the number of mL of Hydrochloric Acid used to achieve colour change.
- Add Potassium Fluoride (KF) or Sodium Fluoride (NaF) powder; in presence of aluminium the solution will become violet again.
- Mark as "B" the number of ml of 1 N Hydrochloric Acid used for the second titration.

### Calculation:

BONDERITE C-AK 2260 IT (g/L)	A x 11.6
Al (g/L)	B x 0.09

### Advices:

Keep the cleaning bath surface free from floating pollutants like dust, oil, etc. The plant can be made of common steel but it is advisable to use stainless steel for the spray nozzles. Small differences in product appearance do not affect its performances.

### Classification:

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

**Hazards identification**

**Transport information**

**Regulatory information**

### Storage:

Recommended Storage Temperature	+5 to 40°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 1.1