

BONDERITE C-AK 2500 IT

Known as Ridoline 2500 IT

August 2015

PRODUCT DESCRIPTION

BONDERITE C-AK 2500 IT provides the following product characteristics:

Technology	Industrial Cleaner
Product Type	Alkaline Cleaner
Application	Metal Pre-Treatment

BONDERITE C-AK 2500 IT is a one pack powder strongly alkaline product studied for the immersion cleaning of steel and zinc coated material before zinc phosphatising or before enamelling.

BONDERITE C-AK 2500 IT requires an activating step before phosphatising; the tensides are totally biodegradable.

TECHNICAL DATA

Density, g/cm³ 0.92

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.

Bath Make-up:

To prepare a 1,000 L bath use 50 to 80 kg of BONDERITE C-AK 2500 IT .

Fill the operating tank with clean tap water to 3/4 of the final volume.

Heat up to the working temperature and add slowly the required amount of BONDERITE C-AK 2500 IT .

Recirculate to homogeneity.

Fill up to the final volume and make controls.

HENKEL Technical Service will suggest you treatment parameters and best use concentration at the start up according to the type of plant and material to treat.

Operating Data:

BONDERITE C-AK 2500 IT is used in aqueous solution as a cleaning step in typical multistages immersion pretreatment cycles; the average working parameters are:

Concentration, %	5 to 8
Points	5 to 8
Temperature, °C	50 to 80
Time, min	5 to 10

Bath Control:

Total alkalinity (TA):

- Transfer 10 mL of working bath into a 250 mL flask.
- Add 100 mL of DI water and 3 to 5 drops Methylorange (1% aqueous solution).
- Titrate with 1 N Sulphuric Acid (H₂SO₄) solution until the colour turns from yellow to red/orange.
- The 1 N H₂SO₄ ml used for the titration is the T.A. value.
- A standard bath made up at 50 g/l of BONDERITE C-AK 2500 IT has a T.A = 5 points.

Replenishing:

To increase 1 point of Total Alkalinity, add 10 Kg BONDERITE C-AK 2500 IT for each 1,000 L of working bath. We suggest to make frequent controls and replenishments, to keep the initially fixed T.A value more consistent as possible.

Caution:

Keep the bath clean; in case of oil accumulation on the bath surface, a partial overflow is advisable in order to avoid contamination on the treated material.

It is advisable to make frequent controls of the concentration and consequently replenish the bath often.

Our Technical Service will give suggestions about the periodical bath renew depending on the type and amount of fat in the bath.

In case of renewal remove any sludge and thoroughly clean the tanks.

Slight differences in the product appearance do not affect its efficiency nor operating performances.

Classification:

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

Sheets for details on:

Hazards identification

Transport information

Regulatory information

Storage:

Temperature, °C 0 to 35

Minimum life time, months 24

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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