BONDERITE

Technical Data Sheet

BONDERITE C-IC 146

Known as Chemalyt 146
June 2017

PRODUCT DESCRIPTION

BONDERITE C-IC 146 provides the following product characteristics:

Technology	Industrial Cleaner
Product Type	Acid Spray - Cleaner
Application	Parts Cleaning, Derusting
Concentration	100 to 150 g/L
Operating Temperature	60 to 70 °C spray process

BONDERITE C-IC 146 contains phosphoric acid, inhibitors and a hydrotrope.

Application Areas:
Cleaning and degreasing of iron, steel, copper, brass and aluminium surfaces with no major metal attack. Rust and oxides are fast dissolved. Overpickling is inhibited. . BONDERITE C-IC 146 is used in spray processes.

TECHNICAL DATA

Appearance	clear, yellowish liquid
Density at 20°C, DIN 51757	~1.56 g/cm³
pH-value (in a solution of 10 g/L)	~1.55

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:
Add the required amount carefully to 700 L cold water into the circulation system.

BONDERITE C-IC 146	78 to 156 kg (50 to 100 L)

Before the start up, fill the tank with water to the working level (L).

Operating Data:

Free acid points	6 to 12
Temperature	60 to 70°C
Duration of treatment:	1 to 15 min depends on requirements
Iron(II)	max. 27 g/L
Spray pressure	0.8 to 1.5 bar

Bath Control:
BONDERITE C-IC 146 solution is controlled by the following analysis:

Titration of free acid:

Feed, mL	10 mL
Titrant:	1 N Sodium Hydroxide
End point:	pH 4.0
Indicator:	bromphenolblue (0.1 % alcoholic solution)

- Pipette 10 mL bath solution into a clean 300 mL Erlenmeyer-flask.
- Add 50 mL deionized water.
- Add 4 to 5 drops of indicator.
- Titrate the solution with 1 N Sodium Hydroxide.
- The endpoint will be shown by a colour change from yellow to blue (pH-value: 4.0).
- The added mL of 1 N Sodium Hydroxide is equal to the "Free acid" points.

Titration of the iron(II) content:

Before titration the presence of iron(II) in the bath solution has to be checked. A dipped in test strip must turn red

Feed, mL	5 mL
Titrant:	0.1 N potassium permanganate
End point:	pink colour, 15 sec
Indicator:	25% sulfuric acid
Titration factor (TF):	1.12
Iron (II) content:	max. 27 g/L

- Pipette 5 mL bath solution into a clean 300 mL Erlenmeyer-flask.
- Add 10 mL of 25 % sulfuric acid.
- Immediately afterwards add slowly 0.1 N potassium permanganate with a burette, while swirling or stirring the sample.
- The endpoint will be shown by a permanent pink colour

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(persists for at least 15 sec).

- The added mL of 0.1 N potassium permanganate multiplied by the factor TF 1.12 is equal to iron(II) in g/L.

If the iron(II)-content exceeds the given limit, then part or all of the BONDERITE C-IC 146 bath must be replaced with fresh cleaner.

Replenishing:

For each missing mL for a volume of 1,000 L add:

BONDERITE C-IC 146	13 kg (8.5 L)

Classification:
Please refer to the corresponding **Safety Data Sheets** for details on:
Hazards identification
Transport information
Regulatory information

Storage:

Recommended Storage Temperature	0 to 40°C
Shelf-life, months	24
Frost-Sensitive	yes

ADDITIONAL INFORMATION

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Reference 0.1

Sample

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