BONDERITE

Technical Data Sheet

BONDERITE C-AK 1574 MRO

December 2019

PRODUCT DESCRIPTION

BONDERITE C-AK 1574 MRO provides the following product characteristics:

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

BONDERITE C-AK 1574 MRO is a liquid alkaline cleaner for steel, applicable in spray and immersion processes.

Application Areas:
BONDERITE C-AK 1574 MRO is a strong alkaline degreasing and derusting cleaning product for general parts cleaning. BONDERITE C-AK 1574 MRO is especially used for the removing of oil-carbon at engine remanufacture processes. BONDERITE C-AK 1574 MRO inhibits efficiently the build up of lime stone in the washer. BONDERITE C-AK 1574 MRO will be used with a suitable cleaning booster depending on the application.

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:
Fill the tank with water, start pumping and add to the bath:

Amount of product for 1,000 L bath:

Operating Data:
Adjusting the following parameters could be necessary depending on the line conditions.

For example:	
BONDERITE C-AK 1574 MRO	7.1 to 428 L = 10 to 600 kg
Application 1:	10 to 30 kg degreasing
Application 2:	100 to 200 kg degreasing and derusting operation
Application 3:	200 to 600 kg heavy duty derusting and paint removal

Total alkalinity points / mL consumption
for make-up with BONDERITE C-AK 1574 MRO:

Application 1:	5.2 to 15.6
Application 2:	52 to 104
Application 3:	104 to 312

Free alkalinity points / mL consumption
for make-up with BONDERITE C-AK 1574 MRO:

Application 1:	4.4 to 13.2
Application 2:	43.7 to 87.4
Application 3:	87.4 to 262

Spray pressure:	0.8 to 2 bar
Temperature:	50 to 80 °C
Duration of treatment:	1 to 20 min.

Bath Control:
BONDERITE C-AK 1574 MRO solution is controlled by the titration of the total alkalinity or free alkalinity.

Titration of total alkalinity:

- Pipette 10 mL bath solution into an Erlenmeyer-flask and add 50 mL deionized water. (1 mL bath solution for higher concentration > 100 kg/1,000 L bath).
- Add 4 to 5 drops of indicator Bromcresolgreen.
- Titrate the solution against 0.1 N hydrochloric- or sulfuric acid. The endpoint will be shown by a color change from blue to yellow (pH 3.8 to 4.5).
- The consumption of 0.1 N sulfuric acid in mL is equal to points of total alkalinity (x 10 for taken 1 mL bath solution).

Titration of free alkalinity:

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- Pipette 10 mL bath solution into an Erlenmeyer-flask and add 50 mL deionized water. (1 mL bath solution for higher concentration > 100 kg/1,000 L bath).
- Add 4 to 5 drops of indicator Phenolphthaleine.
- Titrate the solution against 0.1 N hydrochloric- or sulfuric acid. The endpoint will be shown by a color change from pink to colorless.
- The consumption of 0.1 N sulfuric acid in mL is equal to the points of free alkalinity (x 10 for taken 1 mL bath solution).

Replenishing:
Replenishing is to be done with BONDERITE C-AK 1574 MRO, irrespective of the substrates to be treated.
For each missing point for a volume of 1,000 L add:

Total alkalinity	1.36 L = 1.92kg
Free alkalinity	1.61 L = 2.27kg
Cleaning booster	depends on requirements

General Remarks:
Waste water disposal must be carried out according to the directives of local authorities.

Caution:
Aid and handling recommendations on the material safety data sheet should be read, understood and followed by everybody getting in contact with the product.

Bath Analysis:
Required equipment and reagents:
Pipette, 10 mL
Erlenmeyer flask, 300 mL
Burette, 25 mL
Deionized water
0.1 % alcoholic phenolphthaleine-solution
1.0 % alcoholic bromecresolgreen-solution
0.1 N sulfuric acid

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	36 months

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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Sample

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