

# BONDERITE M-CR 600RTU AERO CHROMATE COATING

(KNOWN AS ALODINE600 RTU)

# INTRODUCTION:

BONDERITE M-CR 600RTU AERO (known as ALODINE 600 RTU) is a ready to use liquid product which produces a chromate conversion coating on aluminum and its alloys. The coating produced provides excellent protection for unpainted aluminum and bonds paint well.

## FEATURES:

- Approved product listed on the QPL-81706
- Ready-To-Use Conversion Coating
- Reduces waste and operator exposure

## **OPERATING SUMMARY:**

Chemical:	Bath Preparation per 100 Gallons:
BONDERITE M-CR 600RTU AERO Operation and Control:	Used as received without dilution
Time:	1 - 5 minutes
Temperature:	70° to 100° Fahrenheit

### **PROCESS:**

The complete process normally consists of the following steps:

- 1. Cleaning
- 2. Rinsing
- 3. Deoxidizer (If Necessary)
- 4. Rinsing
- 5. Treating with the BONDERITE M-CR 600RTU AERO processing solution
- 6. Rinsing
- 7. Drying

The work, after drying, is ready for use either painted or unpainted.

### MATERIAL:

BONDERITE M-CR 600RTU AERO





# BONDERITE M-CR 600RTU AERO CHROMATE COATING

(KNOWN AS ALODINE600 RTU)

# EQUIPMENT:

The work is processed in conventional spray processing equipment. The equipment for the BONDERITE coating chemical should be constructed of stainless steel (Type 316 preferred for weld ability) or other suitable acid resistant material, but no lead or glass.

All heated tanks should be equipped with steam plate coils and side heating (preferred for a more even temperature distribution) or other heat sources capable of heating the bath to the specified temperature.

Acid-resistant crates, baskets, tumbling barrels, or conveyors, etc., should be provided to carry the work through the various stages.

NOTE: Detailed equipment specifications for a particular processing line should be obtained from your technical representative.

### SURFACE PREPARATION:

#### Cleaning:

All metal to be treated with the processing solution must be free from grease, oil and other foreign material before treatment. A complete line of cleaners is available. Our representative will recommend the proper cleaner for your processing needs.

#### Water Rinsing:

After cleaning, the metal must be thoroughly rinsed with water. The rinse should be overflowed continuously at a rate which will keep it clean and free from scum and contamination.

### TREATING WITH THE BONDERITE M-CR 600RTU AERO PROCESSING SOLUTION:

Each alloy reacts with the BONDERITE M-CR 600RTU AERO conversion chemical bath to produce a coating that is characteristic of that alloy. For the treating time selected, the bath should produce a light iridescent gold to tan coating on aluminum.

The data contained herein are normal for most installations; however, your technical representative may suggest a deviation from this data if indicated by production conditions.

If the BONDERITE coating is powdery, the cause may be one or more of the following:

- 1. The work has been improperly cleaned and/or rinsed.
- 2. The coating time is too long.
- 3. The bath temperature is too high.

If the BONDERITE coating is too light, the cause may be one or more of the following:

- 1. The treating time is too short.
- 2. The temperature of the bath is below the specified range.





# BONDERITE M-CR 600RTU AERO CHROMATE COATING

(KNOWN AS ALODINE600 RTU)

## **OPERATION:**

Time: 15 to 30 seconds. Temperature: 70° to 100° Fahrenheit.

### AFTER TREATMENT:

### Rinsing and Drying:

Unreacted coating chemical should be removed by one of the following methods:

1. Flush the work thoroughly with clean water followed by (a) air drying; (b) blowing dry with compressed air; (c) warm or hot air drying; or (d) wiping dry with clean cloths.

2. Wipe with water-damp cloths followed by wiping dry with clean cloths. Any seams, joints and crevices should be blown dry with clean, dry, compressed air and the moisture splatters wiped dry with clean rags.

## **STORAGE REQUIREMENTS:**

This chemical should be stored indoors away from alkaline and organic materials. Do not allow BONDERITE M-CR 600RTU AERO to freeze. Do not store with chlorine containing materials.

### DISPOSAL INFORMATION:

Applicable regulations covering disposal and discharge of chemical should be consulted and followed. Disposal information is given on the Henkel Material Safety Data Sheet for this product.

The solution is acidic and contains hexavalent chromium and fluoride. Waste treatment and neutralization may be required prior to discharge.

Refer to HENKEL TECHNOLOGIES MATERIAL SAFETY DATA SHEET for additional disposal information.





# BONDERITE M-CR 600RTU AERO CHROMATE COATING

(KNOWN AS ALODINE600 RTU)

### **PRECAUTIONARY INFORMATION:**

Before using this product refer to container label and HENKEL TECHNOLOGIES MATERIAL SAFETY DATA SHEET for additional precautionary, handling and first aid information.

#### NOTICE:

The above information and recommendations concerning this product are based upon our laboratory tests and field use experience with this or similar products. However, since conditions of actual use are beyond our control, any recommendations or suggestions are made without warranty, express or implied. Manufacturer's and seller's sole obligation shall be to replace that portion of the product shown to be defective. Neither shall be liable for any loss, damage, or injury, direct or consequential, arising out of the use of this product.

Rev. 8/2013

Henkel Corporation | 32100 Stephenson Highway | Madison Heights, MI 48071 PHONE: (248) 583-9300 | FAX: (248) 583-2976 | www.henkelna.com/

#### Trademark usage

Except as otherwise noted, all trademarks in this document are trademarks of Henkel Corporation in the U.S. and elsewhere. (a) denotes a trademark registered in the U.S. Patent and Trademark Office.

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits. The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.** 

