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	Used as received without dilution
Operation and Control:	
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

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.

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.

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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.

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