

BONDERITE S-ST 5668 AERO PAINT STRIPPER (KNOWN AS TURCO 5668)

INTRODUCTION:

BONDERITE S-ST 5668 AERO (known as TURCO 5668) is a diphase, liquid paint remover developed to remove resistant coatings, such as aluminized silicones, polyurethanes, acrylics, epoxies and chromated primers without using phenols, chromate, chlorinated solvents or acids.

BONDERITE S-ST 5668 AERO is ideal for the removal of PRC-1560M and PRC-1560MC coatings and is not detrimental to aircraft metals such as aluminum, titanium, magnesium, cadmium, conversion coatings, Dow coatings or ferrous alloys.

BONDERITE S-ST 5668 AERO is supplied with a built-in, non-aqueous chemical seal which retards evaporation and helps minimize drag out losses.

APPLICABLE SPECIFICATIONS:

BONDERITE S-ST 5668 AERO meets all the requirements of Military Specification MIL-R-83936B which covers the removal of paint from "Aircraft wheels, Landing gear components, and Other Aircraft and AGE components."

FEATURES:

- Flash point greater than 90°C, COC method
- Does not contain phenols, chromate, chlorinated solvents or acids
- Supplied with built-in seal
- Easily rinsed from parts with steam or high pressure water
- Ideal for use on multi-layers of paints
- Long tank life through use of additives

USE INSTRUCTIONS:

Equipment: Tanks and associated equipment may be fabricated from mild steel or stainless steel.

Preclean: Parts that are contaminated with oils, greases and shop soils should be precleaned to prevent contamination of the remover. Your HST Sales Representative can recommend a suitable precleaner based upon your requirements.

Tank Make-up: Add entire contents of container to stripping tank to insure proper stripper to seal ratio. When less than a full container is required, thoroughly agitate the container prior to making the additions to insure proper stripper to seal ratio. Heat tank to 70° to 80°C. Maintain the seal layer at four inches of depth or 15% by volume at all times by periodic addition of BONDERITE S-AD 5668 ADD1 AERO (Known as Turco 5668 ADDITIVE #1) to insure optimum performance.



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Paint Removal: Immerse parts of BONDERITE S-ST 5668 AERO, making sure the parts are under the seal layer. Maintain tank temperature at 70°C to 80°C. Immersion time will vary with different paints and paint thickness. Most paints will be removed in 15 minutes to 1 hour. Stripping efficiency is maintained through periodic addition of BONDERITE S-AD 5768 ADD AERO (known as Turco 5768 Additive) or BONDERITE S-AD 5668 ADD3 AERO (known as TURCO 5668 ADDITIVE #3), as determined by simple control procedures.

Rinsing: Remove parts from tank and rinse as soon as possible with high pressure tap water or steam.

NOTE: Parts that are to be stored after stripping should be protected from atmospheric corrosion. Your HST Sales Representative can recommend a suitable BONDERITE Rust Preventive based upon your production/storage conditions.

CONTROL:

Apparatus:

1. 205942 - Pipet, 5 mL
2. 205853 - Cylinder, 100 mL
3. 205700 - Buret, 25 mL
4. Weighing balance
5. 205402 - Beaker, 250 mL
6. pH meter

Reagents:

- 1 .0 N Sulfuric Acid

PROCEDURE:

Temperature:

Maintain the temperature in range of 150° to 180°F. Do not exceed 180°F to avoid loss of volatile ingredients and minimize chemical break down.

Liquid Seal:

1. The depth of the seal should be maintained at a minimum of 4" thick or the range of 15 - 17% of the total volume of solution in the tank. Add sufficient BONDERITE S-AD 5668 ADD1 AERO (known as Turco 5668 Additive #1) until the proper volume is attained.
2. The height of the solvent should be adjusted as necessary to insure that the uppermost point on all parts being cleaned is completely submerged. The parts should be at least 2" below the bottom of the seal layer.

Lower Layer - Alkalinity Test:

1. The total alkalinity of the solvent is determined by taking a sample of only the lower layer.
2. Pipet 5.0 mL of the lower layer into a beaker and add 100 mL distilled water.
3. Titrate with 1.0 N sulfuric acid to pH 8 using a pH meter.



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MAINTENANCE:

1. Liquid Seal: 4 " thick or 15 - 17% by volume using BONDERITE S-AD 5668 ADD1 AERO(known as Turco 5668 Additive # 1)
2. Alkalinity: 28 - 32 mL Range
3. To increase the alkalinity, add 1.2 gal of BONDERITE S-AD 5768 ADD AERO per 100 gals of lower layer for every 1.0 mL the alkalinity is below 30 mL.
4. For each mL above 30 mL, add 3.0 gallons of BONDERITE S-AD 5668 ADD3 AERO (known as Turco 5668 Additive #3) per 100 gals of lower layer.
5. The principal loss of alkalinity will be due to drag-out. Parts should be positioned to minimize drag-out.

DISPOSAL INFORMATION:

Dispose of spent solution per local, state and regional regulations. Refer to HENKEL SURFACE TECHNOLOGIES MATERIAL SAFETY DATA SHEET for additional disposal information.

PRECAUTIONARY INFORMATION:

DANGER! Contact may cause severe burns to skin and eyes. Harmful if swallowed.

BONDERITE S-ST 5668 AERO contains potassium hydroxide, amines and paraffin oil. Avoid contact with eyes, skin and clothing. Do not take internally. Use with adequate (equivalent to outdoor) ventilation.

Note: VOC = 765 g/L; VOC VP = <1 mm Hg (Rule 11241)

Protective clothing, such as a chemical face shield or goggles and gloves, apron and boots, made from solvent resistant materials should be worn when handling and using BONDERITE S-ST 5668 AERO.

Do not use BONDERITE S-ST 5668 AERO near open flames or torches since thermal decomposition may produce toxic gases. Do not store containers near strong oxidizing agents, nor above 50°C. Open containers with caution to avoid spurting of contents.

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



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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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