



BONDERITE



Technical Process Bulletin

BONDERITE C-AK 319MM
ALKALINE CLEANER
 (KNOWN AS PARCO CLEANER 319MM)

Issued 5/31/2013

1. Introduction:

BONDERITE C-AK 319MM (KNOWN AS PARCO CLEANER 319 MM) is a single package liquid alkaline cleaner specially designed as a multi-metal cleaner. BONDERITE C-AK 319MM (KNOWN AS PARCO CLEANER 319 MM) contains a unique, low foaming surfactant package that allows operation by both spray and immersion applications over a fairly wide temperature range. It has inter-stage corrosion protection additives and will chemically help to prevent nubbing on galvanized surfaces.

2. Operating Summary:

<u>Chemical:</u>	<u>Bath Preparation per 100 Gallons:</u>
BONDERITE C-AK 319MM (KNOWN AS PARCO CLEANER 319 MM)	0.5 to 5 gallons
<u>Operation and Control:</u>	
Free Alkali	1.5 to 15.0 points (ml)
Time (Spray)	30 to 120 seconds
Time (Immersion)	1 to 5 minutes
Temperature (for steel)	125° to 160° Fahrenheit
Temperature (for galvanized steel & aluminum)	110° to 150° Fahrenheit

3. Materials:

BONDERITE C-AK 319MM (KNOWN AS PARCO CLEANER 319 MM)
 Testing Reagents and Apparatus

4. Equipment:

The process tank, housing, pumps and piping for use with this solution may be constructed of mild steel. In spray applications, maintenance will be simplified if nozzels are fabricated from 300 series stainless steel. The heat exchanger plates should be polished 316 stainless steel. If gas fired burner tubes are used, they should be made of schedule 80 mild steel pipe or equivalent. All process circulating pump seals, valve seats, door seals, and other elastomers which come in contact with the working process solution should be Buna-N, PTFE or CSPE. FKM may be used but its life will be shorter. EPDM elastomers should be avoided.

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Automatic process control equipment, which promotes consistent quality and controlled costs, is available for automatically controlling this process. Auxiliary equipment, which is engineered and specified for this process, include air operated chemical transfer pumps, chemical metering pumps, reliable level controls, solenoid valve assemblies and bulk storage tanks, all chemical pump seals, valve seats and other elastomers which come in contact with the concentrated solution should be PTFE or CSPE.

Our sales representative should be consulted for information on Henkel Surface Technologies automatic process control equipment for this process and any additional questions.

5. Cleaning with BONDERITE C-AK 319MM (KNOWN AS PARCO CLEANER 319 MM):Buildup:

BONDERITE C-AK 319MM (KNOWN AS PARCO CLEANER 319 MM) will clean effectively over a wide concentration range. Our representative will assist in establishing the most effective concentration for each application.

Fill the tank about three-fourths full with cold water. Add the recommended amount of BONDERITE C-AK 319MM (KNOWN AS PARCO CLEANER 319 MM), then heat to the operating temperature. Buildup is usually in the range of 0.5 to 5 gallons per 100 gallons of working volume and is dependent upon the soil encountered, the metal being treated and the operating equipment and conditions.

6. Testing and Control:

Never pipet by mouth, use a pipet filler.

Free Alkali:

Pipet a 10 ml sample into a 150-ml beaker. Add 5 drops of Indicator 3, then titrate with Titrating Solution 20 until one drop discharges the last of the pink. The ml of Titrating Solution 20 used is the free alkali value in points.

Please note that when processing high levels of aluminum metal, the free alkalinity test may need modification. See your Henkel Surface Technologies representative for details.

Free alkali range: within ± 1 point of the value which gives the best results.

To increase value 1 point: 0.3 gallon of BONDERITE C-AK 319MM (KNOWN AS PARCO CLEANER 319 MM) per 100 gallons of solution volume.

<u>gals per 100 gals</u>	<u>Points</u>
1.0	3
2.0	6
3.0	9
4.0	12
5.0	15



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7. Storage Requirements:

Extreme temperatures should be avoided when storing BONDERITE C-AK 319MM (KNOWN AS PARCO CLEANER 319 MM). Indoor storage at or near ambient temperature is recommended.

8. Waste Disposal Information:

Applicable regulations covering disposal and discharge of chemicals should be consulted and followed.

Disposal information for the chemical, in the form as supplied, is given on the Material Safety Data Sheet.

The cleaner solution is alkaline. Neutralization may be required prior to discharge to the sewer. (Refer to Waste Treatment Information Bulletin WT1007, available on request).

The cleaner solution and sludge can contain ingredients other than those present in the chemical as supplied and analysis of the solution and/or sludge may be required prior to disposal.

9. Precautionary Information:

When handling the chemical in the form as supplied, the precautionary, first aid and handling recommendations on the Material Safety Data Sheet for the product should be read, understood and followed.

The cleaner solution is alkaline and can cause irritation of the skin and eyes and may burn eyes. Do not get in eyes, on skin or on clothing. In case of contact, follow the recommendations on the Material Safety Data Sheet for BONDERITE C-AK 319MM (KNOWN AS PARCO CLEANER 319 MM).



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1-800-375-0605
Option 8 for 24/7 Service



6550 Oley Speaks Way
Canal Winchester, OH 43110



www.rudolphbros.com
rbcsupport@rudbro.com