

BONDERITE M-AD BASE EP AERO

April 2023

PRODUCT DESCRIPTION

BONDERITE M-AD BASE EP AERO provides the following product characteristics:

Technology	Metal Pre-treatment
Product Type	Conversion Coating
Appearance	Viscous white liquid
Application Method	Brush
Application	Surface treatment process, Aviation Conversion Coating

BONDERITE M-AD BASE EP AERO is a thickening material formulated to enhance paint or varnish adhesion on vertical surfaces. It is specially designed to ease the application of chromate coatings on aluminum alloys.

TECHNICAL DATA

pH 6 to 8

GENERAL INFORMATION

Please consult the Safety Data Sheet (SDS) for safe handling information of this product.

DIRECTIONS FOR USE

Processing Equipments

Containers for BONDERITE M-AD BASE EP AERO should be made of stainless steel, plastic, synthetic rubber or other acid resistant material.

Lead, tin, glass and galvanized iron containers are not suitable for this material.

Recommended Mix Ratios

Dissolve the required amount of chromate material listed below for every 1 kg of BONDERITE M-AD BASE EP AERO

BONDERITE M-CR 1200 S AERO, grams	6 to 8
BONDERITE M-CR 1200 AERO, grams	16 to 20
BONDERITE M-CR 1500 AERO, mL	10

Mix continuously until material forms into a homogeneous, viscous paste. As soon as this consistency is reached, the chromate paste is ready to use.

Chromate Mixture Shelf Life

Although the resulting chromate mixture can be kept for a few days, it is, nevertheless, advised to only prepare a specified quantity needed for the work day.

Chromate mixture is best used before 24 hours after mixing. An upper layer can be observed with time which can easily emulsified.

Chromate Application Process

- Aluminum alloy surfaces to be chromated should be clean, dry and free from any contaminants that will affect adhesion. Deoxidize using BONDERITE C-IC 670 (10% solution) per manual application, by brush or wipe, at room temperature. Note that deoxidizing material concentration needs to be adjusted according to the fatty contamination level and/or oxide layer thickness.
- Allow deoxidizing material to stay for about 10 minutes. Carefully rinse off with water, using brush or spray. Allow surface to completely dry.
- Apply the chromate mixture using a brush.
- Reaction time is usually about 10 minutes under normal temperature conditions.
- Carefully rinse again with water, using brush or spray. Allow to completely dry.
- Regularly mix to keep the chromate mixture homogeneous throughout the chromate application process.
- Tightly close the container after application.

STORAGE AND HANDLING

Handling

- Solidification can happen by time (especially during extended storage at elevated temperatures).
- Upper superficial solidification will not yield any negative effect to the performance of the product.
- Re-mixing to homogenize the solution may be needed to prepare for further use.

Storage

Store in original, tightly covered containers in clean, dry areas. Storage information may be indicated on the product container labeling.

Optimal Storage: 0 to +35°C. Storage below 0°C can adversely affect product properties.

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local



Henkel Representative.

Not for product specifications

The technical data contained herein are intended as reference only. Please contact your local quality department for assistance and recommendations on specifications for this product.

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