

**BONDERITE**<sup>®</sup>**BONDERITE C-AK 4215NC AERO**Known as TURCO 4215 NC  
July 2013**PRODUCT DESCRIPTION**

BONDERITE C-AK 4215NC AERO provides the following product characteristics:

<b>Technology</b>	Metal Pre-Treatment
<b>Product Type</b>	Alkaline Cleaner
<b>Application</b>	Immersion and Spray

BONDERITE C-AK 4215NC AERO is a granular mixture developed to clean aerospace metals, including metals that come in contact with LOX. BONDERITE C-AK 4215NC AERO is ideal for cleaning fuel and hydraulic components and articles that require adhesive bonding, anodizing and conversion coatings. BONDERITE C-AK 4215NC AERO is suitable for use on steel, titanium, nickel, copper and aluminum alloys either in spray or immersion systems at operating temperature from 60 to 70°C.

**Application Areas**

BONDERITE C-AK 4215NC AERO is used for metal pretreatment processes.

**TECHNICAL DATA**

Appearance white powder

**DIRECTION OF USE****Preliminary Statement**

Prior to use it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

**Solution make-up**

Spray systems: Add 15 to 20 g/l BONDERITE C-AK 4215NC AERO. Operating temperature is from 60 to 70 °C. Normal contact time is from 1 to 2 minutes. Immersion systems: Add 60 to 75 g/l BONDERITE C-AK 4215NC AERO. Operating temperature is from 60 to 70 °C, with air or mechanical agitation. Rinsing: Rinse parts with cold to warm water as soon as possible after cleaning.

**Control Procedure for BONDERITE C-AK 4215NC AERO****Apparatus**

- 100 ml graduated cylinder
- 300 ml Erlenmeyer
- Buret
- Dropper bottle for indicator
- pH meter
- Magnetic stirrer

**Reagents**

- 1.0 N sulphuric acid
- Methyl orange indicator solution
- Transfer 100 ml of sample by means of the graduated cylinder into the erlenmeyer
- If pH meter is not available add 3 drops of methyl orange indicator
- Titrate with 1.0 N sulphuric acid to pH 4.3 or end point (orange)

**Calculation**

- $VH_2SO_4 \times 2.3 = \text{g/l BONDERITE C-AK 4215NC AERO}$
- $VH_2SO_4 = \text{Volume sulphuric acid added to solution (ml)}$

**Maintenance**

Maintain bath concentration within recommended range by adding fresh materials.

**Storage**

Temperature, °C -10 to 50  
Shelf-life (in unopened original packaging), months 24

**Classification**

Please refer to the corresponding **Material Safety Data Sheets** for details on:

**Hazardous Information**  
**Transport Regulations**  
**Safety Regulations**

## ADDITIONAL INFORMATION

### Disclaimer

#### Note:

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