

BONDERITE**BONDERITE C-NE 6765**Known as P3-emulpon 6765
August 2014**PRODUCT DESCRIPTION**

BONDERITE C-NE 6765 provides the following product characteristics:

Technology	Industrial Cleaner
Product Type	Neutral Cleaner
Application	Corrosion protection
Concentration	
in immersion process	20 to 50 g/L
in spray process	10 to 30 g/L
Operating Temperature	30 to 80 °C

BONDERITE C-NE 6765 is a corrosion protection emulsion, applicable in spray and immersion processes especially in the last zone of multistage plants. BONDERITE C-NE 6765 can be also used as a mineral oil based general purpose coolant, suitable for a wide range of operations and water hardness.

Application Areas

Passivating of steel and cast iron for subsequent storage in closed and heated warehouses.
Also Metalworking for steel, cast iron and aluminium.
BONDERITE C-NE 6765 is composed of organic corrosion protection components, non-ionic surfactants and mineral oil fractions.

Technical Data

Appearance	clear, yellow liquid
Density at 20°C, DIN 51757	~0.97 g/cm ³
pH-value	~9.3 (30 g/l)

DIRECTIONS FOR 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.

Bath make-up:

Add the required amount carefully to the circulation system.

For passivation:	
in immersion process	20 to 50 g/l
in spray process	10 to 30 g/l

For metal working:	Make-up	Top-up
Drilling, Turning	3 to 5 %	2 to 4 %
Milling	4 to 6 %	3 to 5 %
Grinding	3 to 4 %	1 to 3 %

Operating data:

Temperature	30 to 80°C
Duration of treatment	0.5 to 3 min

Foam behaviour:

BONDERITE C-NE 6765 can be used in spray applications when used in the above mentioned concentration range, in water of >10 degree German hardness (specially Calcium hardness).

Bath monitoring:

BONDERITE C-NE 6765 solution is controlled by titration of total alkalinity.

Feed	100 ml
Titrand	0.5 N hydrochloric or 0.5 N sulfuric acid
End point	pH-value 3.6
Indicator	methylorange
Titration factor (TF)	2.8 g/l x ml

- with a pipette fill 100 ml bath solution into a clean 300 ml Erlenmeyer-flask
- add 4 to 5 drops of indicator
- titrate the solution with 0.5 N hydrochloric or 0.5 N sulfuric acid
- the endpoint will be shown by a colour change from orange to red (pH-value: 3.6)
- Multiply the consumption of the acid solution with the titration factor TF, to get the concentration in g/L
- Divide this by 10 to get the value in %

Another control method:

Splitting with acid (DIN51360)
100 ml Emulsion is split with concentrated acid. The measured amount of ml separated oil multiplied with 1.15 corresponds to the concentration in %.



Additional directions:

Corrosion protection is increased, if deionized water instead of tap water is used and the work pieces are stored at low relative air humidity and shielded against weather exposure.

Classification:

Please refer to the corresponding **Material Safety Data**

Sheets for details on:

Hazardous Information

Transport Regulations

Safety Regulations

Storage

Recommended Storage Temperature	0 to 40°C
Shelf life, months (in unopened original packaging)	12months
Frost-Sensitive	no

ADDITIONAL INFORMATION**Disclaimer****Note:**

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