

# BONDERITE C-IC HX-357 MU

Known as Deoxidizer HX-357 Make Up (UK)

September 2015

**PRODUCT DESCRIPTION**

The BONDERITE C-IC HX-357 MU provides the following product characteristics:

<b>Technology</b>	Metal Pretreatment
<b>Product Type</b>	Aluminum acid etching
<b>Application</b>	Dip 1.5 to 3.0 %

BONDERITE C-IC HX-357 MU is a concentrated liquid product formulated for deoxidizing or controlled etching of aluminum and its alloys.

**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:**

Bath preparation per 100 L add:

BONDERITE C-IC HX-357 MU      1.5 to 3.0 L

- Fill the tank 3/4 full with cold water.
- For each 100 L of working volume, add 1.5 to 3.0 L of BONDERITE C-IC HX-357 MU depending on desired concentration.
- Add sufficient water to bring the solution up to the working level, mix thoroughly and heat to operating temperature.

**Operating Data:**

BONDERITE C-IC HX-357 MU Titration, points	18 to 36
Bath temperature, °C	32 to 54
Immersion time, min	2 to 10

**Process Description:**

- Acid conditioning/deoxidizing
- Rinse
- Conversion coating
- Rinse
- Seal
- Oven drying
- Oven dry

**Equipment:**

The tanks for the BONDERITE C-IC HX-357 MU bath may be constructed of 300 Series stainless steel (Type 316L preferred) or lined with polyethylene or similar acid-resistant material.

**Control****BONDERITE C-IC HX-357 MU Titration**

Pipet a 10 mL sample into a beaker or Erlenmeyer flask which contains approximately 50 mL of distilled or deionized water. Add 8 to 10 drops of Indicator Solution 11. Fill the automatic burette to the zero mark with Titrating Solution 11. While stirring the sample, slowly add Titrating Solution 11 from the automatic burette until the solution turns blue.

**Replenishment**

For every 1 point lacking in titration, add 3 L of BONDERITE C-IC HX-357 MU per 100 L of bath.

**Post Treatment**

After the work has been treated in the BONDERITE C-IC HX-357 MU bath, it should be thoroughly rinsed in cold water. The rinse should be continuously overflowed to avoid contamination.

**Storage**

Recommended Storage Temperature, °C	0 to 50
Shelf-life, months (in unopened original packaging)	36

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

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