

## BONDERITE M-CR ALCRM 1200 Powder Kit

### Chromium Conversion Brush Kit (Gold)

<b>Description</b>	<p>This Kit comprises of a powdered chemical (MP0476 – Powder Part P) which when dissolved in an acidic base (MP0477 – Acidic Base Part L) will impart an iridescent, golden, protective chromate coating of 0.3 – 2.0 g/m<sup>2</sup> on clean, oxide-free aluminium and aluminium-alloy surfaces.</p> <p>It is mostly specified when dipping is not commercially viable - for example, for repairing Alcrom-treated or anodised surfaces; as a preparation for aircraft coating systems; or the treating of a few small components.</p>
<b>Features</b>	<ul style="list-style-type: none"><li>• A rapid, non-electrolytic, chromate conversion treatment.</li><li>• Gives excellent protection from corrosion.</li><li>• Simple to use: easy mixing ratio.</li><li>• Gives an excellent base for paint systems.</li><li>• Forms an integral layer with aluminium - highly flexible and impact resistant.</li></ul>
<b>Complies With</b>	SAE AMS 03-18, MIL-DTL-5541, MIL-DTL-81706, DEF STAN 03-18.
<b>Product Codes</b>	<p><b>MP0475 1 LT Kit</b> comprises:</p> <ul style="list-style-type: none"><li>• MP0476 - Bonderite M-CR Alcrm 1200 Powder Part P (25 g)</li><li>• MP0477 - Acidic Base Part L (1 LT)</li><li>• MP0478 - Neutraliser Part N (25 g) – this is used only for neutralisation of the mixed product for disposal, it is not part of the active product for metal treatment.</li></ul>
<b>Equipment</b>	Mixing containers should be made of plastic or stainless steel. Glass, tin, mild or galvanised steel should <b>not</b> be used.
<b>Mixing</b>	<p><b>Thoroughly</b> dissolve all the Powder Part P (25 g) in the Acidic Base Part L (1 LT). Once mixed, the blend is ready for use.</p> <p>To dispose of excess mixed material, add the Neutraliser Part N (25 g) until the solution turns green, at which point the toxic hexavalent chromium has been successfully reduced to non-toxic trivalent chromium. Normally, this neutralised excess product is of sufficiently trivial quantity so as not to present a concern to Water Authorities – especially when copiously diluted with rinse waters.</p>
<b>Mixture Pot Life</b>	The mixed material (Powder Part P mixed with Acidic Base Part L) will remain usable for a period of up to 24 hours under normal working conditions. Excess mixed material should be discarded and not returned to a closed container.
<b>Coverage</b>	<p>The rate of consumption will depend on the coating weight obtained, wastage through excessive mixing and the care in application. As a guide, the following range has proved reliable:</p> <p>Brush: 15 – 20 m<sup>2</sup>/kg of mixed material.</p>

**TECHNICAL DATA SHEET****BONDERITE M-CR ALCRM 1200 Powder Kit**  
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**Application** All surface contamination must be removed and surfaces must be clean and oxide-free.

Normally the process sequence is:

1. Heavy oils or accumulated contamination should be cleaned off with a suitable degreasing agent.
2. Clean and deoxidise with Bonderite C-IC 624 (**MP0003**).
3. Cold water rinse to remove cleaners (see **Rinsing** below) and allow to drain.
4. Brush or swab the mixed Part P and Part L onto the work and allow to react for 15 seconds to 3 min (see **Notes on Application** below).
5. Cold water rinse (see **Rinsing** below).
6. Dry off (see **Force Drying** below).

**Notes on Application:**

The mixture (mixed Part P and Part L) should be applied quickly, liberally and evenly, working upwards on vertical surfaces. Use only on small areas – do not attempt to treat a large area at one time. A nylon brush is normally suitable, or soft bristle brushes or sponges can be used for specific purposes.

If there is poor wetting or bare areas showing after treatment, the most likely cause is inadequate pre-cleaning, with residual oil or oxide being left on the surface and preventing the correct reaction. Areas need cleaning again with Bonderite C-IC 624 (**MP0003**) and the mixed Part P and Part L reapplying.

**Rinsing** Normally, fresh mains water, dispensed either through a fine spray bottle, can or a hose, is most effective, applied from top to bottom. Avoid damaging the surface by rough wiping.

**Force Drying** To improve results, warm air should be used wherever possible. Temperatures up to 60°C are normally suitable.

**Shelf Life** For best before dates, see product labels.

**Storage** All three components should be kept separate in the original, unopened containers and stored in a cool, dry area. Once Acidic Base Part L and Powder Part P have been mixed, use the mixture within 24 hours, then add Neutraliser Part N to dispose (see **Mixing** above). **DO NOT store mixed product in closed containers.** Dangerous fume may develop in the headspace.

**Health & Safety** Refer to the products' Safety Data Sheets and safety advice on the product labels before use.

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