

**BONDERITE® O-PC 528 BLACK RFU**

May 2024

**PRODUCT DESCRIPTION**

BONDERITE® O-PC 528 BLACK RFU provides the following product characteristics:

<b>Technology</b>	Organic Coating
<b>Product Type</b>	Chromium-free
<b>Application</b>	On Metals

BONDERITE® O-PC 528 BLACK RFU is a high performance protective coating for metal of any surface profile. During the drying process the metal surface is converted into a phosphate, which in turn is protected by a resin layer containing an anti-corrosive agent. Because of this all in one process it provides a coating with outstanding adhesion and corrosion resistance.

**Application Areas:**

BONDERITE® O-PC 528 BLACK RFU has outstanding resistance to corrosion (salt spray and humidity) battery acids, fuel oils, solvents and brake fluid.

Because BONDERITE® O-PC 528 BLACK RFU can easily be spray applied without complete pretreatment or energy consuming baking processes, it is very popular for the coating of automotive components such as engine mountings, springs, brake components, metal pressings and almost all underbody components.

A single 25 micron thick coating will provide 240 hours ASTM B117 hot salt spray resistance on suitably cleaned mild steel panels, meeting some of the severest automotive specifications in use today.

**TECHNICAL DATA**

Appearance	Semi gloss finish
Viscosity as supplied	O-PC 528: 90 ± 5 s BS B4 cup at 25°C O-PC 528 RFU: 35 ± 2 s at 25°C
Dry Film thickness	25 microns sprayed reduced 5:1
Flash Point	21°C
Theoretical Spreading Rate Vol. solids 23.8	9.5m <sup>2</sup> /L* Wt. solids 36.8
Drying time (sprayed): Air Dry	40 min at 25°C touch dry
Salt Spray ASTMB117	240 h (sprayed test panel)
Hot oil resistance	Not affected
Petrol resistance	Not affected

\* The mileage achieved from this product depends on the efficiency of the application. For example conventional spraying is unlikely to be better than 50% efficient.

**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.

**Application:**

- Work to be treated with BONDERITE® O-PC 528 BLACK RFU should be free of scale, rust, grease or oil. A suitable solvent for grease removal would be Chemiclene 450.
- BONDERITE® O-PC 528 BLACK RFU should be stirred prior to use. To coat rough surfaces (castings) BONDERITE® O-PC 528 BLACK RFU is used undiluted for a dip application. If sprayed, it should be reduced 5:1 with Reducer 90.
- On smooth surfaces BONDERITE® O-PC 528 BLACK RFU is reduced 5:1 with Reducer 90 for both spraying and dipping.
- The coating touch dries at room temperature in 40 min but force drying will accelerate the through hardening. BONDERITE® O-PC 528 BLACK RFU needs a minimum application temperature of 18°C to ensure good phosphating.

**Viscosity when diluted with Reducer 90 (approx.):**

Undiluted	approx. 90 s B4 cup at 25°C
20:1	approx.60 s B4 cup at 25°C
10:1	approx.45 s B4 cup at 25°C
5:1	approx.30 s B4 cup at 25°C

**Storage:**

Recommended Storage Temperature, °C	0 to 40
Shelf life, months (in unopened original packaging)	24

A storage life of at least 24 months can be anticipated provided the can remains unopened and stored away from extremes of heat and cold.  
Store according to the 'Highly Flammable Liquids and Liquefied Petroleum Gases Regulations 1972'.

**Classification:**

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

**Sheets** for details on:

**Hazards identification**  
**Transport information**  
**Regulatory information**



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

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

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