

# CICLO di pretrattamento BONDERITE

Step	TREATMENT	TIME	TEMPERATURE	%	pH	PRODUCT
1	Charge					
2	Alcalinic Degreasing	4 min	48 - 52°C *	2 - 5	9,0 - 9,5	HENKEL CLINSTONE L456
3	Washing	1 min	Ambient			
4	Washing	1 min	Ambient			
5	Washing demineralized	30 sec	Ambient			
6	Nano-technologic Passivation	1 min	Ambient	10 - 20	4,8 - 5,0	HENKEL BONDERITE NT-1
7	Washing	1 min	Ambient			
8	Washing demineralized	1 min	Ambient			
9	Washing demineralized	30 sec	Ambient			
10	Blowing	15 sec	Ambient			
11	Blowing forced air	15 sec	80 - 90°C * *			
12	First Drying	16 min	100 - 110°C * *			
13	Second Drying	30 min	140 - 150°C * *			
14	Cooling		Ambient			
15	Descharge		Ambient			
16	Visual control		Ambient			
17	Packaging		Ambient			

[\*] water temperature

[\*\*] air temperature