



BONDERITE S-MA 550 AERO

Known as TURCO Form Mask 550

April 2014

PRODUCT DESCRIPTION

BONDERITE S-MA 550 AERO provides the following product characteristics:

Technology	Temporary protective coating
Product Type	Temporary protective coating
Application	Immersion, spray, manual

BONDERITE S-MA 550 AERO is a protective coating which has a superior degree of chemical resistance. It has been formulated for use as a top coat over BONDERITE Maskant films used on titanium and steel in the Chem-Mill process.

Application Areas

BONDERITE S-MA 550 AERO is used in chemical milling process.

TECHNICAL DATA

Appearance	Viscous blue liquid
Density, kg/l	0.9
Solid content (120°C), %	14 to 16
Viscosity (Zahncup 20 °C)	11 to 15

DIRECTION OF 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.

Use instructions

1. General

1.1. BONDERITE S-MA 550 AERO may be applied by spraying, dipping or flow coating methods.

2. Spray application:

2.1. **Equipment:** Hot airless spray equipment such as Graco, Nordson or Brinks may be used.

Example: Graco President 30:1 circulating unit with two 4 KW Spee-Flo heaters in series. Graco reflex gun with Graco

163-919 or -817 spray-tip alternatively a Spee-Flo gun can be used with 702-218 or -188 can be used. Further adequate compressed air volume at 6-8 bar is required for the pump set back pressure at 125-165 bar and the heater thermostat at 60-90°C.

2.2. Application Procedure: Hold the spray gun approximately 300-400 mm from the substrate moving the gun parallel and at right angles to the substrate surface. Use uniform straight strokes. Apply three box coats of which the first one is a little thinner with an over lap of 50-75%. The thickness will depend on the speed at which the spray gun is moved. Approximately 600-900 micrometer of wet film equates 200-300 micrometer dry film.

2.3. Dilution: BONDERITE S-MA 550 AERO is packaged ready to use. To assure uniform and reproducible results adequate mixing of the products is necessary and should be done at least once per 8-hour shift.

Storage

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

Classification

Please refer to the corresponding **Material Safety Data Sheets** for details on:

Hazardous Information
Transport Regulations
Safety Regulations



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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