



BONDERITE S-MA 551LA-2 AERO

Known as TURCO Form Mask 551 LA-2
August 2013

PRODUCT DESCRIPTION

BONDERITE S-MA 551LA-2 AERO provides the following product characteristics:

Technology	Temporary protective coating
Product Type	Temporary protective coating
Application	Immersion and Spray

BONDERITE S-MA 551LA-2 AERO is a blue hand strippable coating formulated to provide protection to metal surfaces during successive fabrication operations, such as forming, chemical milling, chemical cleaning, conversion coating, type I and type II anodising and adhesive bonding. It is applied by hot airless spray methods, but can also be applied by dip and flow coating applications and can be used on ferrous and non-ferrous alloys. BONDERITE S-MA 551LA-2 AERO resists emulsion cleaners, acid deoxidisers, strong caustic solutions (at 120°C), anodising solutions, alkaline cleaners and various plating solutions.

Application Areas

BONDERITE S-MA 551LA-2 AERO is used in chemical milling process.

TECHNICAL DATA

Appearance	Viscous blue liquid
Density, kg/l	0.98
Soild content (120°C), %	30.7 to 31.3
Viscosity (Zahncup 20 °C)	30 to 38

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. Pre-cleaning:

The parts to be coated must be dry clean, free of corrosion, dirt, oil and grease. Your HST sales Engineer can

recommend suitable pre-cleaners based on your requirements.

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. Cold Airless Spray: BONDERITE S-MA 551LA-2 AERO may be sprayed cold. However 5 box coats may be required to obtain the same dry film thickness. Hot spray allows application of heavier wet films without sagging than can be obtained with cold spray.

2.4. Dilution: BONDERITE S-MA 551LA-2 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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