

BONDERITE S-FN 7400

Known as P3-prevox 7400

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PRODUCT DESCRIPTION

BONDERITE S-FN 7400 provides the following product characteristics:

Technology	Industrial Cleaner
Product Type	Corrosion protection, oil-free
Application	Temporary corrosion protection
Concentration on steel g/L	5 to 20
Concentration on cast iron g/L	15 to 30
Operating Temperature °C	15 to 80

BONDERITE S-FN 7400 is an aqueous temporary corrosion protective based on organic components.

Change of colour is caused by raw material and has no impact on performance.

Application Areas:

Passivation of steel and cast iron for subsequent storage in closed warehouses.

Application in immersion and spray systems, especially in the last stage of multiple zone systems.

Fields of application:

- water for leak testing hollow parts, e.g. radiators, fuel tanks, intake manifolds, cooling systems and silencers
- cooling water circuit on engine test benches
- cooling water for induction hardening
- mildly alkaline solutions as well as neutral cleaner solutions for improving the corrosion protection
- prior to painting

TECHNICAL DATA

Appearance clear, light yellowish liquid
Density at 20°C, DIN 51757 ~1.05 g/cm³
pH-value, 10 g/L in DI water, 20 °C ~10.1
DIN 51369

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.

Bath Make-up:

Add the required amount carefully to the circulation system.

Concentration on steel 5 to 20 g/L
Concentration on cast iron 15 to 30 g/L

Operating Data:

Temperature 15 to 80°C
Duration of treatment 0.5 to 3 min

Longer duration of treatment may cause discolouration on nonferrous metals.

Bath Monitoring:

BONDERITE S-FN 7400 solution is controlled by total alkalinity.

Feed, mL 100 mL
Titrant: 0.5 N hydrochloric or 0.5 N sulphuric acid
End point: pH 3.6
Indicator: Methyl orange
Titration factor (TF): 2.4

- Pipette 100 mL bath solution into a clean 300 mL Erlenmeyer-flask.
- Add 50 mL deionized water.
- Add 3 to 5 drops of indicator.
- Titrate the solution with 0.5 N hydrochloric or 0.5 N sulphuric acid.
- The endpoint will be shown by a colour change from orange to red (pH: 3.6).
- The added mL of 0.5 N hydrochloric or 0.5 N sulphuric acid multiplied by the factor TF 2.4 is equal to the concentration in g/L.
- Divide this by 10 to get the value in %.

Additional Directions:

Corrosion protection is increased, if deionized water instead of tap water is used and the work pieces are stored at low relative air humidity and shielded against weather exposure.

Below -5 °C the product may become solid. After heating and homogenization it can be used without any loss of efficiency.



Classification:

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

Hazards identification
Transport information
Regulatory information

Storage:

Recommended Storage Temperature -5 to 40°C
Shelf-life, months 24 months

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Reference 0.2