



# BONDERITE 1455-W Wipes

November 2012

## PRODUCT DESCRIPTION

BONDERITE 1455-W Wipes provides the following product characteristics:

<b>Technology</b>	Surface treatment
<b>Application</b>	Surface conversion with corrosion protection and enhanced adhesion.

BONDERITE 1455-W Wipes is a chromium free and water-based corrosion protecting surface treatment for metals like aluminum, zinc, zinc alloy, cold- and hot rolled steel, stainless steel, galvanized, sand basted and armor plate surfaces. BONDERITE 1455-W Wipes produce a conversion which forms from a reaction with the above mentioned metal surfaces to form true chemical bonds. The converted surface provides an excellent base for organic finishes, paint, sealers and most adhesives. This reaction greatly enhances adhesion and corrosion resistance of subsequently applied paints (including primer when multiple coat systems are used), sealers and adhesives. BONDERITE 1455-W Wipes conversion coating process is a dry-in-place application and does not require subsequent cleaning.

## TECHNICAL DATA

Concentration	Ready to use wipes
Application	Wet the surface by wipe on
Evaporation time	min. 1 minute
Open time	max. 15 minutes
Ph-value	2.6
Application temperature	20 to 40 °C

## DIRECTION OF USE

### Preliminary Statement

Prior to application 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

Treating metal surfaces with BONDERITE 1455-W Wipes is the last step before starting with sealing, bonding or paint process.

The complete process sequence consists of the following steps:

1. All bare metal surfaces to be converted with BONDERITE 1455-W Wipes must be dry and free from grease, oil and other foreign matter before pre-treatment. Abrasive cleaning is acceptable method of surface preparation where scale or corrosion particles exist. Afterward thoroughly clean and prepare the metal surface using Teroson FI / FL+ or cleaners used in the paint shop (e.g. SiliconeEx).

2. Wipe the clean and dry surface with BONDERITE 1455-W Wipes. Use slightly over lapping vertical and horizontal, even with slightly application pressure. Make sure the entire bare metal surface is

wetted with fluid. The surface should remain wet for one minute for the chemical reaction to be bonded. If handling of the dried, treated work is necessary, operators should wear clean, lint free paint gloves so that the treated surface is not contaminated. If the treated surface becomes damaged or re-contaminated, go back to the first step above.

To use only on bare metal surfaces.

Not to use on paint primers 1K, 2K, Polyester fillers, residual paint coatings and plastic parts.

3. Allow the wetted surface to dry at ambient temperature or speed drying with low velocity (do not disturb film) forced warm air up to 100 °C max. We recommend a temperature around 60 °C (standard paint conditions).

4. Within 15 minutes apply paint, sealer or adhesive over the dry and converted surface. It is necessary to complete the painting, sealing or adhesive bonding operation. Make sure that all treated surface is covered.

### Storage

Temperature, °C	+10 to +25
Frost-Sensitive	yes
Shelf-life	12 months

### Storage requirements:

Store product in the unopened container in a dry location. Always reseal the wipe package immediately after removing BONDERITE 1455-W Wipes. BONDERITE 1455-W Wipes should be protected from freezing. If the chemical is frozen, it will be irreversibly damaged and should not be used. When BONDERITE 1455-W Wipes get in contact with the pre-treated surface it could be polluted with surface contamination. To ensure an optimal corrosion protection, the Wipes should be used only once. Wipe that are accidentally allowed to dry out completely should not be remoistured by adding water to the package; dried out wipe should be discarded. To keep wipes moist, reseal any opened package of BONDERITE 1455-W Wipes using the zip lock closure feature on the package. If free fluid accumulates in the bottom of the wipe package, vertically rotate the package 90° and roll the pack a few times around its own axle, the free fluid is re-absorbed by the less moist portion of the unused wipes.

## ADDITIONAL INFORMATION

### Disclaimer:

The Information provided herein, especially recommendations for the usage and the application of our products, is based upon our knowledge and experience. Due to different materials used as well as to varying working conditions beyond our control we strictly recommend to carry out intensive trials to test the suitability of our products with regard to the required processes and applications. We do not accept any liability with regard to the above information or with regard to any verbal recommendation, except for cases where we are liable of gross negligence or false intention.

This datasheet replaces all former versions.



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