Henkel
Surface
Technologies

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TECHNICAL DATA BULLETIN

ALODINE 1200L/1000L

(Manual Operation)

A. SUMMARY

1. INTRODUCTION

Alodine* 1000L & 1200L are liquid chemicals, designed to produce protective and paint bonding coatings on aluminium and aluminium alloys.

Alodine 1000L produces colourless coatings and is used for sign writing or the application of clear finishes. For other applications, **Alodine 1200L**, which produces golden to tan coatings, should be used.

Alodine 1000L & 1200L are made specifically for manual application. Other versions of **Alodine 1200** are available for application by immersion or recirculation spray.

These coatings conform to U.S.A. Military Specification MIL-C-5541E. The **Alodine 1000L & 1200L** coatings are electrically conductive. Fresh coatings (obtained from two minutes contact with deoxidised surfaces) usually have a resistance of 170 micro-ohms (i.e. a conductivity of 6,000 siemens) and this increases with age.

2. MAKE UP AND OPERATION

Alodine 1000L & 1200L are used without dilution, and are applied by brush, synthetic sponge or mop to the clean substrate.

One litre will treat approximately 10 square metres of surface.

3. EQUIPMENT

Containers should be of plastic or similar acid proof material. Do not use tin cans, galvanised buckets or glass containers.

B. TECHNICAL DETAILS:

1. OPERATIONAL RECOMMENDATIONS

(a) Pre Cleaning

Remove oil and grease deposits with a detergent solution, mineral turps, white spirits or kerosene. Wipe dry with a clean cloth. If no corrosion is evident, proceed with the application of the chemical, but first wet the surface with water.

If corrosion is evident, or if the surface requires to be deoxidised, apply **Deoxidine* 624** diluted, one (1) volume with three (3) volumes of water, or undiluted until the surface is free of water breaks. Flush off with fresh water or wipe up the chemical residues with clean rags. There is no need to dry the surface completely; in fact a wet surface will assist the formation of a uniform coating.

(b) Application

Apply the undiluted **Alodine 1000L** or **Alodine 1200L** solution freely using nylon or bristle brushes, synthetic sponge, cotton mops, or clean cloths; moving over a convenient area for about 1-2 minutes, or until the surface is uniformly wet. Apply a fresh lot of **Alodine** solution and leave for no more than 30 seconds. Hose off the residual chemical, and blow out any crevices, joints or pools.

For vertical surfaces, start at the bottom and treat each section fully before moving up to the next section. Finally, hose the complete article. Allow the article to air dry completely, or force dry at a temperature not exceeding 82°C (180°F) before applying further coatings.

2. PLANT MAINTENANCE

Application equipment, spills, etc. should be flushed with water to prevent the drying of residues.

Water authorities commonly set limits on the level of chromic acid in effluent. Where applicable, **Alodine** wastes and rinsings need to be treated before discharge into a sewerage system. Your Henkel** Technical Representative can provide basic recommendations on this step.

3. HANDLING PRECAUTIONS

4. SPECIFICATIONS

Alodine 1000L & 1200L are approved for use under MIL-C-5541E. Class 1A Form III
Method B application for **Alodine 1200L** and Class 3 Form 1 Method A&C for **Alodine 1000L.**

5. HENKEL* REFERENCE

Alodine 1000L
Alodine 1200L

* Registered Trade Mark of Parker Amchem U.S.A.
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