



**STEP 3:**

After rinsing, wipe the surface with a fresh, clean dry cloth. Allow the metal surface to dry before the coating application.

**Note:**

Wet cleaning is highly recommended. If water wet abrasive is not allowed due to sensitive components in the vicinity of the area to be treated, dry abrasive followed by a wipe with a clean water-damp wiper is recommended to remove cleaning residues. Wipe until no dark residue is picked up from the surface. A surface clean of residue (smut, etc.) will help keep the felt tip from becoming fouled.

**Treating the Surface with BONDERITE M-CR 871:****STEP 1:**

Remove the cap. To activate, hold unit with applicator tip down on the cleaned active surface to be treated. Press and hold the pen tip down on the surface. This will open the spring valve allowing BONDERITE M-CR 871 to reach and wet the applicator tip. A new unit should charge in 15 to 30 seconds. When the BONDERITE just wets the tip, release the downward pressure. The unit is now ready to use.

**Note:**

The operator must insure that the tip does not become overly saturated with treatment solution.

**STEP 2:**

Apply BONDERITE M-CR 871 Coating to the aluminum surface with firm, smooth, even strokes. Be sure to cover all edges. Overlap each stroke 10 to 25% to insure full coverage. Excess overlap may deposit a very heavy coating which may be detrimental to performance. DO NOT PUDDLE! DO NOT RINSE! DO NOT WIPE!

**Note:**

Solution breaks (de-wetting) must not be observed. A void in the wet film indicates inadequate cleaning. If needed, repeat the cleaning. Firm strokes during the application helps to avoid de-wetting.

**STEP 3:**

A second coat is required at a 90-degree angle to the first coat. Apply the second coat within 5 minutes after the first coat dries due to the fact that the treated surface becomes more hydrophobic as it ages. DO NOT PUDDLE! DO NOT RINSE! DO NOT WIPE!

**Note:**

As long as the Touch-N-Prep pen wets the surface, an adequate coating will form. The dried coating deposited will range from nearly colorless to a white opaque color.

**STEP 4:**

BONDERITE M-CR 871 Coating can be allowed to air dry. Using warm air or a radiant heat source such as a heat lamp         consumer hair dryer is ideal and will avoid overheating the surface. Do not disturb the wet film during drying; such as by excessive airflow or contact with the treated surface.

**Note:**

An uneven appearance of the dry film is normal.

Pre-warming the surface will give a significantly more uniform appearance, and is recommended especially when the metal

**STEP 5:**

To rewet the applicator tip, repeat the activation process.

maintain constant coating weights and avoid over-wetting the felt tip.

**STEP 6:**

Always immediately replace the cap when not in use to avoid evaporation and contamination.

**STEP 7:**

When BONDERITE M-CR 871 is thoroughly dry, primers or other coatings may be applied.

**Note:**

(1) For Airbus paint adhesion applications, BONDERITE M-CR 871 must be rinsed with DI water or wiped with a DI water saturated wipe after application. (2) A new applicator tip can be cut to conform to any shape with a single edge razor blade.

Consult the appropriate Henkel Material Safety Data Sheets for safety and handling guidelines for this product.

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**Storage:**

0 to 40  
Shelf life, months 24  
(in unopened original packaging)

**Classification:**

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

**Hazards identification**  
**Transport information**  
**Regulatory information**

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