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Alodine and MIL-DTL-5541 Chemical Conversion Coating

Alodine 1200S at a glance

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Item	Value	Source
Product	BONDERITE M-CR 1200S AERO, known as Alodine 1200S; brown powder	Henkel TDS, Nov 2019
Approval	QPL-81706; makes Class 1A and Class 3 coatings under MIL-DTL-5541, bare or painted	Henkel TDS
Make-up	6.3 lb per 100 gal (7.5 kg per 1000 L); 12.5 lb (15 kg) for brush application	Henkel TDS
pH	1.3 to 1.8	Henkel TDS
Temperature	68 to 95 F (20 to 35 C)	Henkel TDS
Contact time	15 to 180 seconds	Henkel TDS
Finished colour	Light iridescent golden to tan	Henkel TDS
Rule on repairs	Apply immediately after corrosion removal and rinse; recoat if 48 h pass before primer or paint	AC 43.13-1B par. 6-136d(2)(e), 6-136j

Key points

- **One product sheet.** Bath data are from the Henkel M-CR 1200S AERO TDS (Nov 2019). Other products differ.
- **Class meanings** are from standard summaries; we did not read the MIL-DTL-5541 text.
- **Hazard rules** are the AC's and the SDS's. We add none.

SOURCES · FAA AC 43.13-1B CHG 1, Chapter 6 · Henkel, Technical Data Sheet BONDERITE M-CR 1200S AERO, November 2019 · PPG Aerospace, Desoprime CA7502 Chrome-Free Epoxy Primer, Technical Data Sheet

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Educational reference only, not approved data. Always consult the applicable SRM, AMM, or AC 43.13-1B and your certifying authority.