

# **BONDERITE L-GP PRODAG ACHESON**

## **DIECASTING LUBRICANT**

(KNOWN AS PRODAG)

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### **DESCRIPTION**

BONDERITE L-GP PRODAG ACHESON (known as Prodag) is an aqueous graphite dispersion adapted for casting release in aluminum permanent mold applications. The highly refined semi-collodial dispersion forms a smooth continuous film with extra long wear life. BONDERITE L-GP PRODAG ACHESON is a general purpose product within the industry and provides superior release, improved surface finish and good mold protection. BONDERITE L-GP PRODAG ACHESON is smokeless, non-toxic and non-flammable, which provides an improved paint environment.

### **PHYSICAL PROPERTIES**

#### **BONDERITE L-GP PRODAG ACHESON (known as Prodag)**

Pigment	Processed micro-graphite
Carrier	Water
Consistency	Soft paste
Diluent	Water
Solids content	30%
Density	10 lb/gal
pH	-11
Shelf life	12 months from date of qualification under original seal

### **METHOD OF USE**

#### **Surface**

##### **Preparation**

Mold surfaces to be coated with BONDERITE L-GP PRODAG ACHESON should be thoroughly cleaned and free of any oil, dirt and grease. Solvent cleaning followed by wire brushing is normally sufficient to free the surface of contaminants that prevent good adhesion.

#### **Dilution**

BONDERITE L-GP PRODAG is a concentrate and should be diluted before use, preferably with distilled, soft or demineralized water. The concentrate should be agitated prior to and during the slow addition of diluent. For initial use, a ratio of at least 1:4 (product:diluent) is recommended; however, dilution ratios of 1:10 and higher are normal for production.

#### **Application**

Diluted BONDERITE L-GP PRODAG ACHESON should be applied by conventional spray techniques for best results. Spray application ensures more uniform coating thickness, more complete coverage and lower friction values. For optimum film formation, the diluted dispersion should be spray applied to surfaces heated to at least 200°F (93°C) to facilitate speedy evaporation of the carrier. The formulation of BONDERITE L-GP PRODAG ACHESON is such that a satisfactory film can be obtained by brush application. The diluted product should be stirred occasionally during use. If diluted material is left to stand overnight, or a comparable length of time, it should be re-gitated before use.



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### **COMPANION PRODUCTS**

BONDERITE L-CA 193 ACHESON (known as DAG 193) and BONDERITE L-CA 395 ACHESON (known as DAG 395), water based refractory dispersions, are frequently used as base coatings for BONDERITE L-GP PRODAG ACHESON. Using either BONDERITE L-CA 193 ACHESON or BONDERITE L-CA 395 ACHESON with BONDERITE L-GP PRODAG ACHESON provides a composite film having good thermal insulation properties together with excellent release.

### **STORAGE HANDLING**

BONDERITE L-GP PRODAG should be stored in a cool place, but not allowed to freeze. Containers should be tightly resealed after use in order to prevent evaporation. Careful resealing after use will prevent contamination.

### **Application Assistance**

Henkel's Application Specialists are available to assist you in production start-up with BONDERITE L-GP PRODAG ACHESON. Visit our website [www.henkelna.com/metals](http://www.henkelna.com/metals) for more information.

### **HEALTH AND SAFETY**

Please consult Material Safety Data sheet.

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