

# BONDERITE L-GP 554/20 ACHESON

Known as Dag 554/20  
January 2016

## PRODUCT DESCRIPTION

BONDERITE L-GP 554/20 ACHESON provides the following product characteristics:

<b>Technology</b>	Lubricant
Product Type	Graphite in water dispersion
<b>Application</b>	Forging die lubricant

BONDERITE L-GP 554/20 ACHESON is a smokeless, water based press and forge die lubricant.

BONDERITE L-GP 554/20 ACHESON a dispersion of colloidal graphite in water, is used in aluminium extrusion to apply a graphite coating on the pressure pad (dummy block) to prevent it from sticking to the billet end after extrusion.

Dipping of the pressure pad, immediately after extrusion in diluted BONDERITE L-GP 554/20 ACHESON, will form a graphite film, having excellent lubricating and parting properties, and at the same time provide the necessary cooling.

### Special features

- Excellent lubricating properties
- Positive release properties
- Possibility of controlling die temperature by adjusting dilution ratio
- Rapid wetting and film forming on the metal
- Non corrosive to die and work piece
- Absence of smoke, fumes and toxic effects when sprayed onto hot metal

### Application

- Aluminium extrusion
- Hot forging and pressing of plain carbon steels, aluminium and brass

## TECHNICAL DATA

### (as supplied)

Pigment	graphite
Carrier	water
Solids content, %	~20
Density, kg/m <sup>3</sup>	1,120
Diluent	water
Consistency	black paste
Lubricant	high purity micro-graphite
pH-value	10 to 12

## DIRECTION OF USE

### Preliminary Statement

Prior to use 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.

### Method of Use for Forging:

#### Dilution

BONDERITE L-GP 554/20 ACHESON is a concentrate and it should normally be diluted before use with distilled soft or demineralized water. It is important to carry out dilution as follows:

- Stir the product well in its original container before transferring to a suitable container.
- Slowly add the required quantity of water, with constant stirring, until the mixture is homogeneous.

#### Dilution Ratio

The dilution varies according to the working conditions and the degree of cooling required. For initial trials, a ratio of 1 part BONDERITE L-GP 554/20 ACHESON to 5 to 10 parts water by volume is recommended.

#### Pretreatment of dies

To obtain rapid formation of an adherent lubricating film, the dies should be degreased and then preheated to approximately 150°C.

#### Application

BONDERITE L-GP 554/20 ACHESON should be applied by spray. BONDERITE Spray Equipment is particularly suitable. Once the die has been "run-in" and the spray equipment properly adjusted, a further dilution may be tried for maximum economy, using handguns or automatic spray equipment.

### Method of Use for Extrusion:

#### Dilution

BONDERITE L-GP 554/20 ACHESON is diluted before use with 30 to 50 parts of water.

Before dilution the product should be stirred well in its original container.

Dilution is done by slowly adding the water under continuous stirring.

The hot pressure pads are dipped in the diluted product until they are cooled to the required temperature.

**Storage**

Store BONDERITE L-GP 554/20 ACHESON in a cool place, but do not allow it to freeze.

Storage in direct sunlight may overheat the product and impair its quality.

Reseal containers after use to avoid contamination.

**Shelf-Life**

- 24 months from date of qualification under original seal.

**Classification**

Please refer to the corresponding **Material Safety Data**

**Sheets** for details on:

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

**ADDITIONAL INFORMATION****Disclaimer****Note:**

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

**In case products are delivered by Henkel Belgium NV, Henkel Electronic Materials NV, Henkel Nederland BV, Henkel Technologies France SAS and Henkel France SA please additionally note the following:**

In case Henkel would be nevertheless held liable, on whatever legal ground, Henkel's liability will in no event exceed the amount of the concerned delivery.

**In case products are delivered by Henkel Colombiana, S.A.S. the following disclaimer is applicable:**

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

**In case products are delivered by Henkel Corporation, Resin Technology Group, Inc., or Henkel Canada Corporation, the following disclaimer is applicable:**

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

**Trademark usage**

Except as otherwise noted, all trademarks in this document are trademarks of Henkel Corporation in the U.S. and elsewhere. ® denotes a trademark registered in the U.S. Patent and Trademark Office.

Reference 0.0