

BONDERITE L-GP 554/20 ACHESON

Known as Dag 554/20
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PRODUCT DESCRIPTION

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

Technology	Lubricant
Product Type	Graphite in water dispersion
Application	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 ³	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:**

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