

BONDERITE L-GP 325EF ACHESON

Known as Emralon 325 EF
November 2015

PRODUCT DESCRIPTION

BONDERITE L-GP 325EF ACHESON provides the following product characteristics:

Technology	Lubricant
Product Type	PTFE dispersion in solvent
Application	Dry film lubricant

BONDERITE L-GP 325EF ACHESON is a fast-drying resin-bonded P.T.F.E. based dry film lubricant capable of coating wood, metal, rubber, plastic and glass substrates. BONDERITE L-GP 325EF ACHESON is specially designed for low-friction load repetitive stresses. Moving parts wear longer, work harder and need less maintenance when coated with BONDERITE L-GP 325EF ACHESON and the room temperature cure allows its use where conventional sintered PTFE coatings cannot be considered.

Special features

- Supplied as a concentrate for greater economy
- Clean, easy application
- Good surface adhesion to most substrates
- Excellent lubricity
- Hard abrasion resistant surface
- Thin film
- Room temperature cure
- Translucent coating
- Life long lubrication in many applications

Application Areas

Moving parts (wood, metal, fabric, plastic, rubber)
Coin mechanisms
Door and window guides/runners
Chutes
Business machines
Wood working tables
Saws and planes
Rack slides
Wood furniture Drawers
Wood table slides
Packaging Equipment
Lock parts
Computers

TECHNICAL DATA

(of wet product)

Lubricant	PTFE
Binder	thermoplastic resin
Solids content, %	~19.5
Viscosity, mPa.s (Brookfield 20°C, 20rpm)	~330
Flash Point, °C (DIN 51755/1)	-7
Density, kg/m ³	980
Colour	translucent
Diluent	butylacetate, MEK, ethyl acetate, etc.
Theoretical coverage, m ² /kg/ 10µm	10

(as cured)

Color	translucent
Static coefficient of friction	~0.07
Maximum service temperature:	
continuous, °C	80
intermittent, °C	115
Recommended film thickness, µm	5 to 15

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.

Pretreatment

Substrates to be coated should be clean and dry, free from contamination and residues such as dirt, grease or powder before applying BONDERITE L-GP 325EF ACHESON. A light rub with sandpaper or emery cloth followed by a solvent wipe and air dry may be sufficient. However, to obtain maximum performance from the coating, the surface cleaning process may be followed by either grit blasting or an appropriate chemical treatment, such as phosphating, anodizing or acid etching.

Dilution & Mixing

BONDERITE L-GP 325EF ACHESON is a concentrate to be diluted before use.

A dilution ratio of 3 : 1 (product : diluent) is recommended

Application

BONDERITE L-GP 325EF ACHESON can be applied by conventional spray, dip or brush techniques. The product may be sprayed using an externally atomising

spray gun with a nozzle diameter of 0.8 to 1.5 mm, and an air pressure of 2 to 3 bar.

For thicker coatings use multiple passes pausing a few minutes between passes to permit air drying.

Curing

BONDERITE L-GP 325EF ACHESON coatings are dry to touch in about 5 minutes and are dry enough to handle in approx. 20 minutes, depending on film thickness.

The coating is fully dried in 4 hours.

Slight warming, not over 65 °C will shorten the total drying period to approx. 15 minutes depending on thickness of application and substrate.

Application during periods of high humidity may increase opacity or blush, and exposure to strong sunlight may cause darkening, but neither phenomenon adversely affects coating performance.

Precautions

BONDERITE L-GP 325EF ACHESON coatings are moderately resistant to some inorganic corrosives, such as sulfuric acid and sodium hydroxide; however, contact with organic solvents such as alcohols, esters and ketones should be avoided.

Application to plastic or fabric may cause the substrates to swell or soften temporarily.

In most cases, plastic regains its original dimensions on drying.

Often the solvent action of the carrier etches the substrate, promoting increased coating adhesion.

Storage

Recommended Storage Temperature, °C	5 to 30
Shelf-life, months (in unopened original packaging)	12

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.

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