

BONDERITE L-CA CG 575 ACHESON

Known as Deltacast CG-575
April 2015

PRODUCT DESCRIPTION

BONDERITE L-CA CG 575 ACHESON provides the following product characteristics:

Technology	Lubricant
Product Type	Insulating coating
Application	Gravity and low pressure die casting

BONDERITE L-CA CG 575 ACHESON is a fine particle size, water based die dressing for use in gravity and low pressure die-casting.

BONDERITE L-CA CG 575 ACHESON is one of a series of insulating coatings which have been developed to provide a range of controlled cooling rates. It provides a tenacious long lasting coating with a relatively low level of insulation which allows a higher rate of chilling of the molten metal to facilitate the production of high quality castings.

BONDERITE L-CA CG 575 ACHESON is particularly suitable for the production of castings having large flat surfaces requiring excellent flow into thin sections.

Its fine particle size ensures excellent surface finish.

Application

BONDERITE L-CA CG 575 ACHESON should be applied to die surfaces thoroughly cleaned of dirt, oil, grease and previous coatings. Light sandblasting is ideal, but wire brushing may be sufficient to free the surface of contamination.

Recommended is application of BONDERITE L-CA CG 575 ACHESON on top of primer coating BONDERITE L-CA CG 515 ACHESON.

To achieve uniform, long-lasting coatings, the diluted material should be spray applied to die surfaces pre-heated between 160 to 200 °C. For brush application the surfaces to be treated should be pre-heated between 120 to 140°C.

Several thinner coatings, dried between each application, are preferred over one heavy coating. Coatings can be touched up at normal die working temperatures.

TECHNICAL DATA

(as supplied):

Appearance	white thick fluid
Coating insulation	low to medium
Pigment	blend of refractory materials
Carrier	water
Diluent	water
Solids content, %	53

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.

Dilution

BONDERITE L-CA CG 575 ACHESON is a concentrate and should be diluted with water before application by spray or brush.

On storage a sediment may form in the container. The concentrate should therefore be homogenised before use. Agitation may be sufficient but stirring is preferred.

The diluted product should also be agitated occasionally during use.

It is preferable to add water to the concentrate whilst stirring.

Dilution Ratio

Dilution ratios will vary with application, but BONDERITE L-CA CG 575 ACHESON is normally used diluted 1 to 1 with water.

For brush application the product may be used undiluted.

Particular applications may require further dilution in order to obtain optimum performance.

Storage

Store BONDERITE L-CA CG 575 ACHESON in a cool place, but do not allow it to freeze. Product should not be used once frozen.

Always tightly reseal the container to avoid contamination.

Shelf Life

- 12 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

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Reference **N/A**