

BONDERITE L-CA HKKS ACHESON

Known as HYDROKOLLAG KOKILLENSCHLICHTE
July 2015

PRODUCT DESCRIPTION

BONDERITE L-CA HKKS ACHESON provides the following product characteristics:

Technology	Lubricant
Product Type	Graphite in water
Application	Gravity and low pressure die casting

BONDERITE L-CA HKKS ACHESON is a dispersion of high purity semi-colloidal graphite in water, proven over a long history as quality release agent in gravity and low pressure die casting of non-ferrous metals.

The fine graphite coating eases the release of castings and protects insulating coatings from premature wear.

Special features

- High covering power.
- Superior release and temperature resistance.
- Pore-free casting.

BONDERITE L-CA HKKS ACHESON is economic in use due to its high covering power. The constant quality of the product ensures excellent reproducibility.

BONDERITE L-CA HKKS ACHESON provides superior release and good high temperature resistance. Due to the absence of gas emitting raw materials pore-free castings are obtained.

Application

Release agent for gravity and low pressure die casting of aluminium and other non-ferrous metals. BONDERITE L-CA HKKS ACHESON is a top coating to be applied over insulating coatings from the BONDERITE L-CA CG series. For maximum reproducibility it is advised to apply a thin coating after every casting. Sometimes it is preferred to apply a thicker coating that allows several, less complex castings in a row. It is designed to be applied (manually) by dip, spray or brush.

TECHNICAL DATA

Appearance	homogeneous grey-black high viscous liquid
Pigment	high purity semi-colloidal graphite
Carrier	water
Diluent	soft or demineralized water
Solids content, %	21.5

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 HKKS ACHESON is a concentrate and should be diluted with water before application by spray, dip or brush.

To dilute BONDERITE L-CA HKKS ACHESON, soft water is stirred slowly into the concentrate.

In open systems, as in dip application, it is suggested to keep the pH between 8 and 9.

Ammonia is preferred to adjust the pH of diluted BONDERITE L-CA HKKS ACHESON.

On storage a sediment may form in the container. The concentrate should be homogenized before use. Agitation may be sufficient but stirring is preferred. The diluted product should also be agitated occasionally during use.

Dilution Ratios

BONDERITE L-CA HKKS ACHESON is usually applied by dip or spray, diluted one part with 5 to 50 parts of soft water. The product may be applied neat on insulating coatings by brush.

Storage

Store BONDERITE L-CA HKKS 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 prevent 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:

Hazardous Information
Transport Regulations
Safety Regulations

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