

BONDERITE L-CA CG 555 ACHESON

Known as Deltacast L-CA CG-555
July 2015**PRODUCT DESCRIPTION**

BONDERITE L-CA CG 555 ACHESON provides the following product characteristics:

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

BONDERITE L-CA CG 555 ACHESON is a water based semi-permanent die coating for use in gravity and low pressure die casting.

BONDERITE L-CA CG 555 ACHESON provides a long lasting coating with an excellent heat insulation. The refractory film acts as a heat retaining blanket and helps to prevent 'shrinks' or vacuum holes caused by uneven cooling of the molten metal. Coatings from BONDERITE L-CA CG 555 ACHESON are durable and reduce mold wear. Once established they last between one and three days depending on the type of casting and cycle speed.

Application

BONDERITE L-CA CG 555 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.

To achieve uniform, long-lasting coatings, the diluted material should be spray applied to die surfaces pre-heated between 150 to 175°C.

If preferred, the mixture may be applied by brush.

Several thinner coatings, dried between each application, are preferred over one heavy coating.

After the first casting, it may be found that the coating has been removed from certain parts of the die.

The worn spots can easily be touched up either by spraying or brushing the area with the mixture, and this tendency to wear away will quickly disappear with continued use.

No definite limits are recommended for the coating thickness, but as a guide in practice the average mould coating is about 0.1 mm.

For gates, runners and risers, a thicker application is often essential, this is best achieved by using multiple coats, but can also be achieved by application of a more concentrated dilution of BONDERITE L-CA CG 555 ACHESON.

A graphite coating can be applied over the base coat of BONDERITE L-CA CG 555 ACHESON to reduce wear and improve release.

Information regarding product selection may be obtained from our technical support departments.

TECHNICAL DATA

Appearance	beige medium viscous fluid, strong sedimentation
Coating insulation	high
Pigment	blend of refractory materials
Carrier	water
Diluent	water
Solids content, %	30

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 555 ACHESON is a concentrate to be diluted before use. On storage a strong sediment forms in the container. The concentrate should therefore be fully homogenized before use. Agitation may be sufficient but stirring is preferred. After thorough initial mixing of the prepared dilution, the diluted product should also be agitated/stirred occasionally during use. It is preferable to add water to the concentrate whilst stirring.

Dilution Ratios

The usual dilution for spray application is 1 part to 2 to 5 parts of water, but this ratio depends on the spraying consistency required by the operator. For thicker spray application (gate area, runners and risers) or brush application a ratio of 1 part BONDERITE L-CA CG 555 ACHESON to 1 part of water may be used.

Storage

Store BONDERITE L-CA CG 555 ACHESON in a cool place, but do not allow it to freeze. Freezing will damage the stability of the product and it 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.

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