Description:

BONDERITE L-GP AQUADAG ACHESON (known as AQUADAG) is an aqueous-based colloidal dispersion of ultra-fine graphite. This product forms a smooth continuous dry film with extra long wear life. The unique formulation results in maximum adhesion to most substrates. The fineness and purity of the product produces near perfect suspension properties which substantially reduce stirring or agitation during use. The high covering factor of BONDERITE L-GP AQUADAG ACHESON (known as AQUADAG) permits higher dilution ratios than commercially available alternatives, thus providing efficient product use. BONDERITE L-GP AQUADAG ACHESON (known as AQUADAG) is smokeless and non-flammable, which aids in improving plant environment. BONDERITE L-GP AQUADAG ACHESON (known as AQUADAG) can be utilized as a graphite additive into aqueous lubricating compositions for various applications. Specific advantages when using BONDERITE L-GP AQUADAG ACHESON (known as AQUADAG) are:

- Complete wetting and surface coverage- good economy
- Excellent coverage onto surfaces
- Superior adhesion and abrasion resistance
- Maximum release and lubricating characteristics
- Finer surface finishes in casting applications

FEATURES

Stable colloidal suspension of graphite
Fine particle size distribution
Zero VOC content
Lubricating, low friction graphite particles
Robust chemical compatibility

BENEFITS

Minimal mixing costs for blending into your finished lubricant
Provides cost-effective usage in finished lubricant to provide superior lubrication performance, consumer confidence and repeat sales
Environmentally friendly
Lubricating, low friction graphite particles
Minimizes formulation costs for achieving stable and effective product

TYPICAL APPLICATIONS

Chain lubricant
Penetrating lubricants
Parting compound
Thread lubricant
Machine and way lubricant

Assembly lubricant
General industrial lubricant
Metal casting release
Hot zone bearing lubricant
Dry gear lubricant
Physical Properties (as supplied):

- **Lubricating solid:** processed micrographite
- **Carrier:** water
- **Viscosity:** gel
- **Diluent:** water (demineralized water preferred)
- **Solid content:** 22%
- **pH:** 10 minimum
- **Particle size (by volume):** median 0.6 – 0.8 microns
- **Density:** 9.3 lbs/gal (1.12 kg/l)
- **Flash point:** None
- **Color:** Black

**Method of Use:**

**Dilution**

BONDERITE L-GP AQUADAG ACHESON (known as AQUADAG) is a concentrate and should be diluted with distilled, demineralized or soft water prior to use. The concentrate should be agitated prior to mixing. When mixing, slowly add water to the concentrate. Be sure to mix well throughout the water addition. The dilution ratio will vary depending on method of application and end use. The ratios typically vary between 1:4 in chain/conveyor applications to 1:25 in some metal release and parting compound uses.

**Application**

BONDERITE L-GP AQUADAG ACHESON (known as AQUADAG) may be applied using conventional spray, brush, or dip methods. In open recirculating systems, ammonia should be added periodically to maintain a pH of at least 10.

**Curing**

BONDERITE L-GP AQUADAG ACHESON (known as AQUADAG) will air dry to touch in 10-15 minutes, depending on room temperature and humidity. For optimum coating properties preheat the substrate to 200°-350°F (93°-177°C) before coating, OR heat the air-dried, coated part at 300°F (149°C) for 5 minutes. BONDERITE L-GP AQUADAG ACHESON (known as AQUADAG) adheres remarkably well to steel, aluminum, stainless steel, glass, copper alloys, rubber, and plastics with a minimum of pretreatment. For best results, substrates should be cleaned with a standard solvent or sandblasted. Substrates should be clean and dry before coating.

**Application**

Shake the container thoroughly before using. To ensure an even coating, spray about 8-10 inches from the substrate. Four to six light passes should build up the required coating thickness. After use, invert the can and press the button once or twice to clear the nozzle.

**Curing**

For general lubrication, the coating supplied by BONDERITE L-GP AQUADAG ACHESON (known as AQUADAG) is ready for use when dry to the touch—about 5 minutes at room temperature.

For electrical applications, air dry for 30 minutes; or air dry for 5 minutes, then bake for 5 minutes at 170°F (77°C).

**Storage/Handling:**

Keep container closed when not in use to avoid contamination. See Henkel Material Safety Data Sheet for proper first
aid instructions. Shelf life is 12 months from date of qualification under original seal.

Application/Assistance:
Henkel Application Specialists are available to assist you in production start-up with BONDERITE L-GP AQUADAG ACHESON (known as AQUADAG). Visit our website www.henkelna.com/metals for more information and for the Henkel’s global location nearest you.

Note: See separate Material Safety Data Sheet for health and safety details.