

# **BONDERITE L-CA PF 404 ACHESON**

## **CASTING LUBRICANT**

(KNOWN AS PF 404)

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### **Description:**

BONDERITE L-CA PF 404 ACHESON (known as PF 404) is a blend of ultra-fine graphite particles dispersed in a water-extendible solution. Specifically designed for continuous casting, BONDERITE L-CA PF 404 ACHESON (known as PF 404) provides excellent release, superior tooling protection and high temperature wetting characteristics on copper/bronze dam blocks. Its unique formulation minimizes gassing which compounds porosity levels. BONDERITE L-CA PF 404 ACHESON (known as PF 404) does not build up and is easily washed from the dam block surface.

### **Physical Properties: (as supplied)**

Lubricant:	ultra-fine graphite
Diluent:	water
Consistency:	thick fluid to soft paste
Density:	9.1 lb/gal
Freezing point:	32°F (0°C)
Shelf life:	12 months from date of qualification under original seal

### **Method of Use:**

#### **Dilution/Application**

BONDERITE L-CA PF 404 ACHESON (known as PF 404) is supplied as a concentrate and should be diluted 1:1 to 1:5 (product : water) prior to application. Water should be added to the concentrate and then thoroughly agitated. This product should be periodically agitated when in use to prevent settling.

For best results and optimum film formation, BONDERITE L-CA PF 404 ACHESON (known as PF 404) should be spray applied.

### **Precautions:**

Harmful if swallowed. Do not freeze. See the Henkel Material Safety Data Sheet for proper first aid instructions, further precautions and handling procedures. Keep container tightly sealed when not in use.

**Container Size:** 45 lb

Henkel Corporation | 32100 Stephenson Highway | Madison Heights, MI 48071  
PHONE: (248) 583-9300 | FAX: (248) 583-2976 | [www.henkelna.com/](http://www.henkelna.com/)

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