BONDERITE

Technical Data Sheet

BONDERITE L-GP D 148A ACHESON

Known as ENDU PTFE D 148A
June 2015

PRODUCT DESCRIPTION

BONDERITE L-GP D 148A ACHESON provides the following product characteristics:

Technology	Lubricant
Product Type	PTFE dispersion in solvent
Application	Dry film lubricant

BONDERITE L-GP D 148A ACHESON is a PTFE based varnish developing a dry and lubricating coating after curing.
BONDERITE L-GP D 148A ACHESON forms a smooth and dry lubricant film.
BONDERITE L-GP D 148A ACHESON is a 2 compounds material used in combination with a hardener (BONDERITE S-OT DURCISSEUR/ BONDERITE S-OT AH 1 ACHESON).

TECHNICAL DATA

(of wet product)	
Aspect	Viscous green liquid
Solids content, %	51 to 53
Viscosity, mPa.s (Brookfield 20 °C, 20 rpm)	100 to 200
Flash Point, °C	-4
Density, kg/m³	1,280

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.

Method of Use

- BONDERITE L-GP D 148A ACHESON resin compound is used in combination with BONDERITE S-OT AH 1 ACHESON.
- Homogenize BONDERITE L-GP D 148A ACHESON.
- The BONDERITE S-OT AH 1 ACHESON is added to the to the BONDERITE L-GP D 148A ACHESON, while stirring.
- The mixing ratio is: 100 grams of BONDERITE L-GP D 148A ACHESON with 17 grams of BONDERITE S-OT AH 1 ACHESON.
- Stir the blend correctly to full homogeneity.
- The pot life of the blend is 20 hours at 20 °C.

Pretreatment

The surfaces have to be clean and well degreased. A sand-blasting of the surface improves the adhesion of the film.

Application

The blend of resin and hardener is adjusted to the correct viscosity for spray using thinner.

Curing

About 24 hours at room temperature.
The hardening can be accelerated by heat: after 1 hour air drying, the heat hardening sequences are:

- cure during 2 hours at 60 °C
- cure during 1 hour at 150 °C
- cure during 30 minutes at 180 °C

Thinners

- Ethylacetate, MEK, MIBK
- Never use alcohols

Storage

Recommended Storage Temperature, °C	5 to 40
Shelf life, months (in unopened original packaging)	12

Classification

Please refer to the corresponding **Material Safety Data Sheets** for details on:

Hazards identification
Transport information
Regulatory information

Henkel

ADDITIONAL INFORMATION

Disclaimer

Note:

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.
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