

# BONDERITE L-CA CG 595 ACHESON

Known as Deltacast CG-595

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## PRODUCT DESCRIPTION

BONDERITE L-CA CG 595 ACHESON provides the following product characteristics:

<b>Technology</b>	Lubricant
<b>Product Type</b>	Insulating and lubricating coating
<b>Application</b>	Gravity and low pressure die casting

BONDERITE L-CA CG 595 ACHESON is a fine particle size, water based die dressing for use in gravity and low pressure die-casting.

By combining boron nitride and titanium dioxide, BONDERITE L-CA CG 595 ACHESON provides an insulating film to promote controlled metal flow and chill characteristics whilst demonstrating excellent lubrication qualities for release.

The long life, abrasion resistant coating also exhibits good adherence to the die and will withstand temperatures up to 1,000°C.

It is white and produces bright, shiny, stain-free castings making it particularly suitable for the low pressure die casting of aluminium wheels.

## Application

BONDERITE L-CA CG 595 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 to between 150 to 180 °C.

The product may also be applied by brush.

Several thinner coatings, dried between each application, are preferable to one heavy coating. Coatings can be touched up at normal die working temperatures.

## TECHNICAL DATA

### (as supplied):

Appearance	smooth white creamy fluid
Coating insulation	low to medium
Pigment	boron nitride, titanium dioxide
Carrier	water
Diluent	water
Solids content, %	45

## 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 595 ACHESON is a concentrate and should be diluted with water before application by spray or brush. On storage a sediment may form in the container. The concentrate should therefore be homogenised before use. Agitation may be sufficient but stirring is preferred. It is preferable to add water to the concentrate whilst stirring.

### Dilution Ratio

Dilution ratios will vary with application but are usually in the range 1 part of BONDERITE L-CA CG 595 ACHESON with between 1 and 5 parts of water.

For brush application the product may be used undiluted.

### Disposal

Spills should be collected and mopped up with absorbent material. Wash the area well with water and dry off to avoid slippages. Bulk material should be disposed of according to local authority regulations or via an approved waste disposal company.

### Storage

Store BONDERITE L-CA CG 595 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 evaporation or contamination.

### Shelf-Life

- 12 months from date of qualification under original seal.

### Classification

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

**Hazards identification**

**Transport information**

**Regulatory information**

**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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