

BONDERITE L-FG FB-685 ACHESON

Known as Deltaforge FB-685
September 2014

PRODUCT DESCRIPTION

BONDERITE L-FG FB-685 ACHESON provides the following product characteristics:

Technology	Lubricant
Product Type	Graphite Dispersion
Application	Billet coating

BONDERITE L-FG FB-685 ACHESON has been especially formulated to act as a billet coating when warm forging ferrous metals are used. It is composed of a selected graphite and oxidation inhibiting compounds in a water-extendible base. BONDERITE L-FG FB-685 ACHESON remains stable and resists deterioration even when exposed to billet temperatures as high as 900°C for up to 10 minutes.

Application Areas:

- Steel billet coating in warm forming metal process.
- Table lubrication in ring rolling process.
- All applications where a lubricant with high resistance to oxidation is required.

TECHNICAL DATA

Aspect	Black, low viscous liquid
Solids content, %	35.5 to 38.5
Viscosity, mPa.s (Brookfield 20°C, 20rpm)	5,000 to 7,500
Density, kg/m ³	1,260
pH-value	5.0 to 7.0

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:

Thoroughly clean the billets of any oil, dirt, etc., and preheat to 120 to 150 °C. Then briefly dip the heated billets into the BONDERITE L-FG FB-685 ACHESON lube bath. For best results optimum coating thickness should be found after diluting with water in a range of dilution ratio 1:1 to 1:5. Allow the parts to thoroughly dry before use. Best results may be obtained with a dry coating weight 5 to 10 mg/cm². The bath should be continually agitated to prevent sedimentation. A regular check of the quality of the bath is necessary to ensure optimum results. It is

recommended to keep the bath temperature between 60 to 90 °C. BONDERITE L-FG FB-685 ACHESON can also be applied by spray after dilution with water.

Storage:

Store BONDERITE L-FG FB-685 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:

Store BONDERITE L-FG FB-685 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.

- 12 months from date of qualification under original seal.

For maximum shelf life store BONDERITE L-FG FB-685 ACHESON at 5 to 35°C.

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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