

# BONDERITE L-GP C4 HT ACHESON

Known as CARBOSTOP C4 HT  
May 2016

## PRODUCT DESCRIPTION

BONDERITE L-GP C4 HT ACHESON provides the following product characteristics:

<b>Technology</b>	Lubricant
<b>Product Type</b>	Boric oxide dispersion in solvent
<b>Application</b>	Stop off

BONDERITE L-GP C4 HT ACHESON is a stopping off paint for preventing carburising and carbonitriding taking place whilst hardening in gas carburising atmosphere furnaces.

BONDERITE L-GP C4 HT ACHESON has been formulated with a low odour high flash point solvent.

### Special Features:

- More cost effective than traditional copper plating.
- Easy to apply by brushing, dipping or spraying.
- No adverse effects on furnace refractories.
- Will not adversely contaminate quench tanks.
- Residue is easily removed after heat treatment by alkali or hot water wash.
- Effective protection against carburising to case depths up to 3 mm.
- Quick drying (1 hr to 2 hr).

## TECHNICAL DATA

### (as supplied)

Total solids, %	67.5
Viscosity, cPs (Brookfield)	10,000
Flash Point, °C	47
Color	blue
Diluent	white spirit
Density, kg/m <sup>3</sup>	1,200

## 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.

### Application:

BONDERITE L-GP C4 HT ACHESON should be thoroughly stirred before use. Components should be thoroughly degreased before applying BONDERITE L-GP C4 HT ACHESON.

If vapour degreasing is used, components should be allowed to cool to room temperature before coating.

BONDERITE L-GP C4 HT ACHESON is supplied ready for use by brushing or dipping.

BONDERITE L-GP C4 HT ACHESON can be thinned with suitable thinners and applied by spray gun. It is recommended that low pressure spraying equipment is used in a suitable flame proof spray booth.

Apply one even coat of BONDERITE L-GP C4 HT ACHESON to the area requiring protection and allow to dry thoroughly.

Drying time for BONDERITE L-GP C4 HT ACHESON depends upon ambient conditions, but components should be allowed to dry for at least 1 hour.

One single coat of BONDERITE L-GP C4 HT ACHESON will give protection against case depths up to 1.5 mm. For case depths above this figure it is recommended that a second coat be applied.

Components can be stored ready painted with BONDERITE L-GP C4 HT ACHESON for several days without deterioration provided they are stored in a dry atmosphere.

### Storage:

Recommended Storage Temperature, °C	5 to 35
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**

**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.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

**In case products are delivered by Henkel Belgium NV, Henkel Electronic Materials NV, Henkel Nederland BV, Henkel Technologies France SAS and Henkel France SA please additionally note the following:**

In case Henkel would be nevertheless held liable, on whatever legal ground, Henkel's liability will in no event exceed the amount of the concerned delivery.

**In case products are delivered by Henkel Colombiana, S.A.S. the following disclaimer is applicable:**

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. 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.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

**In case products are delivered by Henkel Corporation, Resin Technology Group, Inc., or Henkel Canada Corporation, the following disclaimer is applicable:**

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

**Trademark usage:** [Except as otherwise noted] All trademarks in this document are trademarks and/or registered trademarks of Henkel and its affiliates in the U.S. and elsewhere.

Reference 0.0