

# BONDERITE L-GP D 85 TER A AERO

Known as D 85 TER A

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## PRODUCT DESCRIPTION

BONDERITE L-GP D 85 TER A AERO provides the following product characteristics:

<b>Technology</b>	Lubricant
<b>Product Type</b>	MoS <sub>2</sub> dispersion in solvent
<b>Application</b>	Dry film lubricant

BONDERITE L-GP D 85 TER A AERO is a high temperature and wear resistant coating. The thin long life film based on MoS<sub>2</sub> does not disturb the size tolerance usually required in high tech industry.

### Special Features:

- Low and constant coefficient of friction.
- Solvents resistance even in hot conditions.
- Good chemical passivity, except to concentrated alkali.
- Good thermal stability at 200 to 250 °C.
- Good radiation stability.
- Utilisation in high vacuum.
- Good adherence to metals, special alloys and stainless steel.
- NMP Free.

## TECHNICAL DATA

### (as supplied)

Solids content, %	~29.5
Specific Gravity, kg/m <sup>3</sup>	~1,210
Flash Point, °C	95
Viscosity AFNOR cup No.4 (at 20°C), sec	~26.0

## 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.

### Thinners:

N-Ethyl-2-Pyrrolidone, dimethylformamide, dimethylacetamide or toluene/N-Ethyl-2-Pyrrolidone 1/1, xylene/N-Ethyl-2-Pyrrolidone 0.6/1

### Pretreatment:

For a good adhesion of the coating, a clean and dry surface is required:

Trichlorethane, ultrasonic bath and rinsing with acetone. A fine sandblasting may be necessary.

### Application:

BONDERITE L-GP D 85 TER A AERO diluted with about 10% of thinner can be applied by spray. A thin and regular coating of a few microns can be obtained. The parts can be pre-heated at 60 to 80 °C to get a more regular coating and to avoid flow out.

### Curing:

- Drying time: 1 hour at 100°C + 1 hour at 200°C to eliminate the solvents
- Heat curing: 1 hour at 250 °C

Curing time might be shortened depending of the weight of the parts.

To apply several coatings, follow the drying time + 1 minute at 250°C between two coatings.

It is possible to dry and cure the coating by infra red radiations. As an example, for a 100 cm<sup>2</sup> area and with a 400 watts heater placed at 20 cm from the surface, drying time will be 1 minute.

Placed between 5 and 10 cm from the surface, the curing time will be 3 minutes.

Before curing, the coating can be removed by SOLVAN 56 or N-Ethyl-2-Pyrrolidone.

To remove a cured coating, dip the parts in a hot 20 % solution of NaOH.

### Storage:

Recommended Storage Temperature, °C	4 to 8
Shelf life, months	12
(in unopened original packaging)	

### Classification:

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

**Hazards identification**  
**Transport information**  
**Regulatory information**

## ADDITIONAL INFORMATION

### Disclaimer

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Reference **N/A**