

BONDERITE L-GP GP 1904 EU ACHESON

Known as Emralon GP 1904
November 2015

PRODUCT DESCRIPTION

BONDERITE L-GP GP 1904 EU ACHESON provides the following product characteristics:

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

BONDERITE L-GP GP 1904 EU ACHESON is one of a series of Henkel resin-bonded lubricant coatings formulated to provide dry film lubrication in a variety of industrial and consumer applications.

BONDERITE L-GP GP 1904 EU ACHESON is a co-dispersion of fluorocarbon resin and carbon in a thermosetting binder, designed to be applied by spray.

It produces a low friction coating free of stick-slip characteristics.

The product is recommended for metal substrates.

For wood, rubber and plastics specially designed types of BONDERITE exist.

BONDERITE L-GP GP 1904 EU ACHESON is a one-package product which is not affected by low-temperature storage conditions.

Application Areas

- Fasteners
- Carburettor parts
- Lock mechanisms
- Valves (for water, gas or oil)
- Gears
- Bearings

TECHNICAL DATA

(of wet product)

Lubricant	fluorocarbon and carbon
Binder	thermosetting resin
Solids content, %	~26
Flash Point, °C	12
Density, kg/m ³	960
Color	black
Theoretical coverage, m ² /kg/ 10µm	19
Diluent	Methyl Ethyl Ketone
Viscosity, mPa.s (Brookfield 20 °C, 20 rpm)	~260
Viscosity (Ford Cup 4), sec.	~30

(as a cured coating)

Colour	black
Coefficient of friction (static and kinetic)	0.7
Flexibility, 3.2 mm radius bend on 0.8 mm steel test panels	no loss of adhesion
Salt spray resistance* (ASTM B 117)	greater than 500 hrs
Humidity resistance* (98% RH at 49°C)	greater than 500 hrs
Service temperature: continuous, °C	150
intermittent, °C	160
Chemical resistance	resistant to oils, chlorinated hydrocarbons, ketones, alcohols, dilute acids, esters and aromatic hydrocarbons, gasohol

*Coating cured at 150°C for 60 minutes; substrate: zinc phosphated steel; coating thickness: 0.025 mm.

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.

Pretreatment

Substrates should be clean and dry before application. A solvent wipe and air dry is usually sufficient. For critical applications requiring maximum adhesion, mechanical or chemical pretreatment such as grit or vapour blasting, phosphating, anodising or etching is recommended. Specific recommendations will be provided upon request.

Mixing

BONDERITE L-GP GP 1904 EU ACHESON can be spray applied undiluted. However, to obtain maximum smoothness, dilute the product with methyl ethyl ketone (MEK) in the ratio of three parts product (by weight) to one part solvent.

Application

Use an external-atomizing spray gun with 2 to 3 bar air pressure and adjust the gun to give a well-atomized spray. For optimum performance, the final coating thickness should be 10 to 25 µm. When properly applied, the coating will be even and free of runs, blisters or "fish eyes". Electrostatic spray equipment suitable for products with very low internal resistance may be used to apply BONDERITE L-GP GP 1904 EU ACHESON.

Curing

For optimum results, BONDERITE L-GP GP 1904 EU ACHESON should be cured on either one of the three following curing cycles:

1. 60 minutes/ 160°C (substrate temperature)
2. 30 minutes/ 180°C (substrate temperature)
3. 10 minutes/ 200°C (substrate temperature)

Cleaning up

Spray guns, tanks, mixing hardware and spills of BONDERITE L-GP GP 1904 EU ACHESON can easily be cleaned with MEK. Cured coatings can be removed by sand blasting or soaking in hot caustic solutions.

Storage

Recommended Storage Temperature, °C	4 to 25
Shelf-life, months (in unopened original packaging)	18

Classification

Please refer to the corresponding **Material Safety Data**

Sheets for details on:

Hazardous Information
Transport Regulations
Safety Regulations

ADDITIONAL INFORMATION**Disclaimer****Note:**

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