

BONDERITE L-GP 154 RFU ACHESON GRAPHITE DISPERSION IN SOLVENT (KNOWN AS DAG 154 RFU)

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DESCRIPTION

BONDERITE L-GP 154 RFU ACHESON (known as DAG 154 RFU) (Ready-For-Use), a specially processed colloidal graphite dry film lubricant, air dries rapidly at room temperature and adheres tenaciously to most substrates with minimum surface preparation. The thinness of the coating, coupled with high lubricity, provides clean, long-wearing lubrication without redesign of component dimensions. Supplied in Ready-For-Use form, coatings are easily applied during manufacture or assembly by standard spray techniques.

BONDERITE L-GP 154 RFU ACHESON (known as DAG 154 RFU) is also an easy-to-apply resistance coating designed to provide conductivity, and excellent release properties to many nonconductive substrates, including most plastics.

FEATURES

- Ultra-thin opaque film forming properties
- Excellent adhesion to most substrates
- Fast air-cure times
- Ability to vary conductivity
- Spray (Ready-For-Use) version of BONDERITE L-GP 154 ACHESON (known as DAG 154)

BENEFITS

- High lubricity for tight tolerances of mating parts
- Allows for a variety of parts to be processed with the same coating, saving on costs
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- Multi-purpose application for conductive effect on the part
- No additional solvent required for dilution

TYPICAL APPLICATIONS

- Automotive and industrial gaskets
- Anti-seize thread lubricant
- Aerosol lubricant additive
- Printed circuits, static bleed
- Engine components for assembly and break-in requirements
- Mating surfaces of assemblies and machinery components
- Low noise communication cables
- High resistance coating on plastics
- Impregnation of fibers and paper

TYPICAL PROPERTIES (of wet product)

Color:	black
Pigment:	colloidal graphite
Binder:	thermoplastic resins
Carrier:	isopropanol
Diluent:	isopropanol
Consistency:	thixotropic gel
Density:	6.6 lbs/gal (0.8 kg/l)
Solids content by weight:	3.3 – 3.7%
Flashpoint:	11°C (52°F)
VOC:	6.4 lbs/gal (766 gal/l)



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Theoretical coverage:	63 sq. ft/gal @ 1 mil
TYPICAL PROPERTIES (as cured)	Color: Black
	Coefficient of friction: 0.19 static
	Service temperature - continuous: 204°C (400°F)
	Sheet resistance: < 2400 ohms/sq @ 25 µm (1 mil) dry film thickness

METHOD OF USE

Surface Preparation

Substrates to be coated must be clean and dry. A solvent wipe with air dry is sufficient for smooth surfaces. For porous surfaces, use the same procedure followed by heating to drive off entrapped contaminants, solvents or moisture.

Mixing/Blending/Dilution

BONDERITE L-GP 154 RFU ACHESON (known as DAG 154 RFU) is supplied in Ready-For-Use form. If dilution is required, use isopropanol (or equivalent) to the consistency required by the application method chosen.

BONDERITE L-GP 154 RFU ACHESON (known as DAG 154 RFU) is intended for spray application, however, application by brush, dip or roller can be used. Always agitate thoroughly just prior to use.

Typical film thickness ranges from 0.2 to 0.5 mil (5–12 microns). A coating thickness of 1 mil (25 micron) of **BONDERITE L-GP 154 RFU ACHESON (known as DAG 154 RFU)** is best built up by the application of 5 coats of 0.2 mil thickness by spray application.

Application

For small production work and prototypes, a suction cup gun may be used, if **BONDERITE L-GP 154 RFU ACHESON (known as DAG 154 RFU)** is thoroughly mixed prior to spray application. For intermediate production runs or many small parts, propeller-type attachments should be used on the suction gun to ensure coating uniformity. Full production is best handled with propeller-agitated pressure pot systems, which provide the best in application efficiency.

Note: Handle **BONDERITE L-GP 154 RFU ACHESON (known as DAG 154 RFU)** as you would a quality automotive coating. AVOID DRY SPRAY, as this will cause poor adhesion. To reduce overspray, use the minimum atomization pressure required for adequate coverage.

Curing

The coating air dries to touch in 5 minutes and is ready for use in 30 minutes. Following the air dry, bake for 5 minutes at 75°C (167°F) to achieve optimum coating qualities in a shorter curing cycle.

STORAGE/HANDLING

Shelf life for this product is 1 year from date of qualification under original seal. Keep from freezing. Keep container tightly closed when not in use. Store in a cool, well ventilated area. Keep away from heat, sparks, and open flame. Protect material from direct sunlight. Ground and bond containers when transferring materials. Empty containers may



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retain hazardous properties. Follow all MSDS/label warnings even after container is emptied.

APPLICATION ASSISTANCE

Henkel's Application Specialists are available to assist you in production start-up with **BONDERITE L-GP 154 RFU ACHESON (known as DAG 154 RFU)**. Visit our website www.achesonindustries.com for more information and for the Acheson global location nearest you.

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