BONDERITE

Technical Data Sheet

BONDERITE S-FN 330 ACHESON

Known as Emralon 330
November 2015

PRODUCT DESCRIPTION

BONDERITE S-FN 330 ACHESON provides the following product characteristics:

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

BONDERITE S-FN 330 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 S-FN 330 ACHESON is a dispersion of fluorocarbon 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 S-FN 330 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
Binder	thermosetting resin
Solids content, %	25 to 26
Viscosity (Brookfield), mPas	60 to 150
Density, kg/m³	~960
Flash Point (open cup), °C	10
Theoretical coverage	~22 m² /kg at 10 µm dry coating thickness
Color	blue
Diluent	Methyl Ethyl Keton

(as a cured coating)

Colour	green
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, alcohols, ketones, chlorinated hydrocarbons, dilute acids, esters and aromatic hydrocarbons, gasohol.

*Coating cured at 160°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 blasting, phosphating, anodising or etching is recommended. Specific recommendations will be provided upon request.

Mixing

BONDERITE S-FN 330 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.
For thicker coatings use multiple passes pausing a few minutes between passes to permit air drying.
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 S-FN 330 ACHESON.

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Curing

For optimum results, BONDERITE S-FN 330 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 S-FN 330 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	5 to 30
Shelf-life, months (in unopened original packaging)	24

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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Henkel AG & Co. KGaA
40191 Düsseldorf, Germany
Phone: +49-211-797-0

Henkel Corporation USA
Madison Heights, MI 48071
Phone: +1-248-583-9300

Henkel (China) Co. Ltd.
201203 Shanghai, China
+86.21.2891.8000

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