

BONDERITE L-CA CG 515 ACHESON

Known as Deltacast CG-515

November 2014

PRODUCT DESCRIPTION

BONDERITE L-CA CG 515 ACHESON provides the following product characteristics:

Technology	Lubricant
Product Type	Primer coating
Application	Gravity and low pressure die casting

BONDERITE L-CA CG 515 ACHESON is a primer (or base) coating that acts as a key for a top coating, giving superior coating-adherence on the mould surface and promoting a longer coating life.

When correctly applied, BONDERITE L-CA CG 515 ACHESON gives the optimum surface texture for the subsequent application of any other product in the BONDERITE L-CA CG 500 ACHESON range of products.

As a primer coating, BONDERITE L-CA CG 515 ACHESON can be considered a neutral coating as it will have a negligible effect on the thermal conductivity and surface finish characteristics of whichever coating is subsequently applied.

Application:

BONDERITE L-CA CG 515 ACHESON can be used either as a primer coating, below other products in the BONDERITE L-CA CG 515 ACHESON series, or as a single-coat protector of casting-tools for the Gravity or Low-Pressure diecasting of Aluminium or Zinc alloys.

BONDERITE L-CA CG 515 ACHESON is red in colour. It can therefore be used as a wear-indicator when applied beneath the white coloured top-coatings of the rest of the BONDERITE L-CA CG 500 ACHESON series products.

BONDERITE L-CA CG 515 ACHESON can be used without the subsequent application of a top-coat where there is no requirement for specific thermal or texture characteristics.

BONDERITE L-CA CG 515 ACHESON should be applied to die surfaces thoroughly cleaned of dirt, oil, grease and previous coatings. Light sandblasting is ideal, but wire brushing may be sufficient to free the surface of contamination.

To achieve uniform, long-lasting coatings, the diluted material should be spray applied to die surfaces pre-heated between 160 to 200 °C. For brush application the surfaces to be treated should be pre-heated between 140°C.

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.

Dilution:

BONDERITE L-CA CG 515 ACHESON is a concentrate and should be diluted with water before application by spray or brush.

On storage a sediment may form in the container. The concentrate should therefore be homogenised before use. Agitation may be sufficient but stirring is preferred.

The diluted product should also be agitated occasionally during use.

It is preferable to add water to the concentrate whilst stirring.

Dilution Ratio:

Dilution ratios will vary with application but are usually in the range 1 part of BONDERITE L-CA CG 515 ACHESON with 5 to 10 parts of water for spray application and less than 5 parts of water for brush application.

For use in the protection of casting-tools, application is by dipping the ladle or other tool into BONDERITE L-CA CG 515 ACHESON diluted with 20 to 30 parts of water.

Storage:

Store BONDERITE L-CA CG 515 ACHESON in a cool place, but do not allow it to freeze. Product should not be used once frozen.

Shelf Life:

- 12 months from date of qualification under original seal.

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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