

BONDERITE L-GP MS 401LR ACHESON

Known as Dag MS-401 LR
March 2016

PRODUCT DESCRIPTION

BONDERITE L-GP MS 401LR ACHESON provides the following product characteristics:

Technology	Lubricant
Product Type	Yttriumoxide dispersion in solvent
Application	Protective coating

BONDERITE L-GP MS 401LR ACHESON is a silk screen printable stop-off for use in the fabrication of titanium components by the superplastic forming/diffusion bonding process.

BONDERITE L-GP MS 401LR ACHESON contains yttrium oxide and a low carbon residue binder in solvent.

Yttrium oxide is inert with respect to titanium, thus preventing the formation of alpha case in the titanium surface.

Its particle size is selected and controlled to reduce resistance to breakthrough.

The low carbon residue binder is chosen to give minimum carbon inclusion in the titanium surface.

BONDERITE L-GP MS 401LR ACHESON contains no halogens.

BONDERITE L-GP MS 401LR ACHESON is designed as a ready for use product for application by silk screen printing.

Benefits:

- Inert to titanium.
- Reduced breakthrough pressure.
- Minimum carbon inclusion in titanium surface.
- No Boron induced corrosion fractures.
- No halogen induced stress fractures.

Application Areas:

For use in the fabrication of titanium components by the superplastic forming/diffusion bonding process.

TECHNICAL DATA

(as supplied)

Appearance	Creamy liquid
Colour:	blue
Total solids (120°C), %	~56.0
Active solids (600°C), %	~51.0
Viscosity, cPs (Brookfield)	~3,500
Carrier	Butyl Glycol Acetate
Diluent	Butyl Glycol Acetate

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.

Method of Use:

Components should be thoroughly degreased before use. Although BONDERITE L-GP MS 401LR ACHESON does not settle a small amount of solvent may bleed from the surface during storage, therefore the product should be thoroughly stirred prior to use.

BONDERITE L-GP MS 401LR ACHESON is supplied ready for use by silk screen printing.

Apply in a well ventilated area.

Allow coatings to dry thoroughly.

Dilution

BONDERITE L-GP MS 401LR ACHESON should not require dilution. Occasionally, to suit a particular application, or if solvent has been lost due to evaporation, it may be necessary to dilute the product. In this case use only Butyl Glycol Acetate as a diluent.

Storage:

Recommended Storage Temperature, °C	5 to 40
Shelf life, months (in unopened original packaging)	12

Store in a dry place. Reseal containers after use to avoid contamination.

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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