

BONDERITE S-OT 310B ACHESON

Known as Emralon 310-B
December 2015

PRODUCT DESCRIPTION

BONDERITE S-OT 310B ACHESON provides the following product characteristics:

Technology	Lubricant
Product Type	PTFE dispersion in solvent/water
Application	Dry film lubricant

BONDERITE S-OT 310B 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-OT 310B ACHESON is a two-package product which should be combined with BONDERITE L-GP T A COMP ACHESON (for properties: see Product data sheet of this product).

When mixed, it 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 and rubber substrates.

For wood and plastics specially designed types of BONDERITE exist.

TECHNICAL DATA

(of wet product)

Pigment	none
Binder	thermosetting resin
Solids content, %	~10.5
Color	blue
Flash Point, °C	8
Density, kg/m ³	910
Theoretical coverage, m ² /kg/ 10µm	7.7

(as a cured coating)

Colour	green
Coefficient of friction (static and kinetic)	~0.06
Service temperature:	
continuous, °C	150
intermittent, °C	160
Chemical resistance	resistant to oils, alcohols, ketones, chlorinated hydrocarbons, dilute acids, esters and aromatic hydrocarbons, gasohol

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:

The performance attained with BONDERITE S-OT 310B ACHESON depends on the substrate preparation, application and curing.

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 S-OT 310B ACHESON is marketed as a two-package system in combination with BONDERITE L-GP T A COMP ACHESON which should be mixed just before use.

The white BONDERITE L-GP T A COMP ACHESON, first properly homogenised by rolling, should be added very slowly to the blue BONDERITE S-OT 310B ACHESON with continuous, slow agitation, just enough to get a proper vortex, by a propeller-type mixer or equivalent.

Be sure that the BONDERITE L-GP T A COMP ACHESON does not build up as a layer on the bottom of the container, but avoid excessive agitation which will cause curdling.

The resulting mixture should be a smooth dispersion.

It is ready for use, though it should be agitated gently from time to time during actual application.

Only enough for immediate use should be mixed.

If smaller amounts of mix are needed, 22 parts by weight of the BONDERITE L-GP T A COMP ACHESON should be used for every 100 parts by weight of the BONDERITE S-OT 310B ACHESON.

Do not add further diluents to the mix.

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.

For rubber substrates a coating thickness of 5 to 10 µm is recommended.

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-OT 310B ACHESON.

Curing:

For optimum results, BONDERITE S-OT 310B 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-OT 310B 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)	18

Classification:

Please refer to the corresponding **Material Safety Data Sheets** for details on:

- Hazards identification**
- Transport information**
- Regulatory information**

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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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