



**CERAMATERIALS**

*"Your One Stop Shop for Thermal Processing"*

**Graphite Coating (Water Based) Bonderite L-FG 137- Dag 137**

BONDERITE L-FG 137 ACHESON (known as DAG 137) is specifically formulated to provide superior lubricating and release film for high temperature applications. Its unique particle size and binder system combine to promote a tenacious graphite film for maximum protection against galling, soldering and seizing.

Specific advantages when using BONDERITE L-FG 137 ACHESON (known as DAG 137) are:

- Complete wetting of hot metal substances
- Excellent Coverage
- Superior adhesion and abrasion resistance
- Maximum release characteristics
- Finer surface finishes in casting applications

**Available in:**

- 1 Gallon
- 5 Gallon
- 55 Gallon

Physical Properties	
Lubricating Pigment	Graphite
Solids Content	22%
Consistency	Medium Thick Liquid
Diluent	Water
Density	9.5 gal/lb
pH	8
pH Tolerance	4-10
Freeze Data	32°F (0°C)
Shelf Life	One Year Under Original Seal
VOC	0.0 g/l

**Method Of Use:**

**Dilution**

BONDERITE L-FG 137 ACHESON (known as DAG 137) is a concentrate and should be diluted with distilled demineralized or soft water prior to use. The concentrate should be agitated prior to mixing. When mixing, slowly add water to the concentrate. Be sure to mix well throughout the water addition. The dilution ratio will vary depending on method of application and end use. The ratios typically vary between 1:4 in extrusion to 1:25 in permanent mold and parting compound uses. Periodic agitation (mechanical) is recommended while using diluted product.

**Application**

To achieve optimum film formation, the material substrates should be heated to at least 200°F (93° C). In most applications, the product should be spray applied. However, it can be swabbed, dipped or brushed. The diluted material should be periodically agitated to ensure consistent results.