

**BONDERITE L-FM M 20A ACHESON
COLD EXTRUSION BILLET COATING**

(KNOWN AS MOLYDAG 20A)

Issued
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BONDERITE L-FM M 20A ACHESON (known as MOLYDAG 20A) is a unique, water based, molybdenum disulfide billet coating designed for use when cold extruding ferrous metals. It forms an excellent lubricating film over zinc and manganese phosphated substrates. BONDERITE L-FM M 20A ACHESON adheres extremely well in mechanical feed mechanisms and moves with the billet surface during deformation, enabling higher production rates and extreme area reductions. It also eliminates the expense and housekeeping problems associated with tumble-applied MoS₂ powder. Using BONDERITE L-FM M 20A ACHESON in cold forming processes offers the following advantages over conventional phosphate soap systems:

- Closer tolerances of complex shapes
- Precision extrusion of sharp angles and corners
- Excellent lubricating film
- Permits large reduction in area
- Uniform film thickness
- Easy control of bath
- No toxic fumes or vapors
- Excellent chemical stability in the application bath
- Increased tool life

Typical Applications:

Cold extrusion of:

carbon steels
alloy steels
stainless steels**Physical Properties:**

Lubricating solid:	molybdenum disulfide
Carrier:	water
Consistency:	viscous fluid
Density:	10.7 lb/gal (1.28 kg/l)
pH tolerance:	4 to 10
Freezing point:	32°F (0°C)
Flash point:	none
Shelf life:	24 months from date of qualification under original seal



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Method of Use:**Pretreatment**

Slugs should be degreased and phosphated before being coated with BONDERITE L-FM M 20A ACHESON.

Dilution

BONDERITE L-FM M 20A ACHESON is supplied as a concentrate and is diluted with ordinary tap water prior to use. However, if tap water in your area is high in mineral content, contact your Henkel representative for assistance.

Important: For initial dilution, add water to the concentrate. Stir the concentrate thoroughly before diluting and continue stirring during dilution. Film thickness depends upon the dilution ratio, which varies the solids content of the bath. For extreme extrusions, a dilution ratio of 1 part product to 1 part water is recommended. For moderate extrusions, dilute BONDERITE L-FM M 20A ACHESON with up to 2 parts water. The bath is easily adjusted by adding either water or concentrate.

Application(

BONDERITE L-FM M 20A ACHESON is designed to be dip-applied. Bath temperatures should remain between 160° and 170°F (71°-77°C) for best coating results. Tumble dry.

Precautions:

Caution! Do not take internally. May cause temporary discomfort on direct contact with eyes. Use with adequate ventilation if product is sprayed. Do not freeze. Tightly reseal containers to maintain shelf life. Store BONDERITE L-FM M 20A ACHESON in a cool place but do not freeze. Do not use if frozen or thawed. Do not store coated slugs outdoors. (See Henkel Material Safety Data Sheet for proper first aid instructions.)

Container Sizes:

1 gallon (10 lb)
5 gallon (52 lb)
55 gallon (550 lb)

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