

# FENELLA FLUID F 601

Water miscible synthetic hot forging lubricant (graphite free)

## DESCRIPTION

FENELLA FLUID F 601 is successfully used in hammer, mechanical and mechanical/friction presses. The product covers moderate to heavy duty applications with severe extrusion of material (flow) and can be used for the production of complex parts.

FENELLA FLUID F 601 offers not only excellent general properties, but also eliminates tough and abrasive build-up on the dies, to increase die life.

FENELLA FLUID F 601 has very interesting advantages compared with oil based release-agents. During the application, there is no fume, flame and explosion danger, therefore no risk of tool cracking and rapid wear, whilst cleanliness in work areas is considerably improved.

## APPLICATIONS

The special formulation and the high concentration of its components allow use of the product at high dilution rate with high cost savings.

FENELLA FLUID F 601 forms a white coating on the die with excellent release and lubricating properties. This coating allows good metal flow during the hot forming, leaving on the die an adherent and resistant film even at high die temperatures.

FENELLA FLUID F 601 can also be used for Warm Forging on Schuler machines.

## RECOMMENDATION FOR USE

Mechanical and friction press : 3 - 10 %

Hammer : 10 -15 %

Automatic or hand spray application is recommended

## TYPICAL PHYSICAL PROPERTIES

<i>Appearance</i>	<i>Colourless liquid</i>	
<i>Specific gravity @ 20°C</i>	1.14	ASTM D 1298
<i>pH</i>	7.6	DIN 51396
<i>Refractometer factor</i>	2.75	
<i>Viscosity BK-20°C (S05-20rpm) mPa s</i>	150	

## BENEFITS

- Reduces costs and increases productivity - excellent forming properties, good release, reduces wear on the dies, low foaming, clean surfaces on the metal surface after forging reduce subsequent cleaning operations.
- Easy to use - easy to mix with water and control with a refractometer, forms a stable solution that uniformly wets the die surface.
- Operator and Environmentally friendly - graphite and oil free for a clean working environment. Ammonia free for a pleasant working environment.

## ADDITIONAL PRODUCT DATA

It is recommended that dilutions are made with suitable mixing equipment. If manually mixing, add water slowly to the product while mixing for best results.

## RELATED PRODUCTS

Houghton specialises in products and services for Heat Treatment, Machining and Grinding, Cleaning, and Fire Resistant Hydraulic Fluids and Industrial Lubricants. For more information, please contact your local Houghton representative.

## STORAGE

Please refer to section 7 of Safety Data Sheets for handling and storage information, including product shelf life. Product should be stored under cover in clean, dry conditions and protected from frost. Recommended storage temperature is usually between 5°C and 40°C unless otherwise specified. Use stock in delivery rotation.

## HEALTH AND SAFETY

Safety data sheets are available in accordance with Regulation (EC) No 1907/2006 Annex II where a substance or preparation meets the criteria in accordance with Directives 67/548/EEC or 1999/45/EC.

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**HOUGHTON™**

Houghton plc  
Beacon Road, Trafford Park  
Manchester M17 1AF

Tel +44 (0) 161 874 5000  
Fax +44 (0) 161 874 5001  
E-mail  
uk.enquiries@houghtoneurope.com  
<http://www.houghtonintl.com>

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