

FENELLA FLUID F 801

Water miscible synthetic hot forging lubricant (graphite free)

DESCRIPTION

FENELLA FLUID F 801 is a synthetic, brown, water extendable release agent, which is graphite and oil free. It provides excellent lubrication of the dies in forging and hot-steel pressing on automatic high-volume production systems such as Hatebur presses.

APPLICATIONS

The use of a FENELLA FLUID F 801 solution on horizontal systems for hot forging (eg Hotmatic, Hatebur) allows the production of complex pieces by improving the metal flow in extrusion and giving providing efficient die filling, pressure reduction and excellent release action.

Use of FENELLA FLUID F 801 improves the die life in comparison with water.

RECOMMENDATION FOR USE

Simple parts : 3 - 5 %
Rings and gears : 5 %
Difficult parts : 10 %
Used in circulating systems

TYPICAL PHYSICAL PROPERTIES

<i>Appearance</i>	<i>Brown liquid</i>	
<i>Specific gravity @ 20°C</i>	1.19	ASTM D 1298
<i>pH</i>	9.2	DIN 51396
<i>Refractometer factor</i>	2.0	
<i>Viscosity BK-20°C (S05-20rpm) mPa s</i>	140	

BENEFITS

- Reduces costs and increases productivity - very high lubrication properties, reduces die wear, prevents pick-up and scoring, promotes good metal flow in hot operations on dies up to 400°C.
- Reduces inventory - suitable for a wide range of metals and applications.
- Easy to use - stable, fine particle size graphite dispersion, can be used as supplied or easily diluted with water to form a dispersion.
- Operator and Environmentally friendly - mineral oil and ammonia free

ADDITIONAL PRODUCT DATA

It is recommended that dilutions are made with suitable mixing equipment. If manual 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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