

FENELLA FLUID F 3602 N

Water miscible synthetic hot forging lubricant (graphite free)

DESCRIPTION

FENELLA FLUID F 3602 N is a water soluble, graphite and oil free release-agent for hot forging of ferrous metals and ring rolling of bearing materials.

APPLICATIONS

FENELLA FLUID F 3602 N forms a light brown film on the die with excellent release and lubricating properties. This coating allows a good metal flow during the hot forming, leaving an adherent and resistant film on the die, even at high die temperatures. For large bearing ring rolling it provides cooling and lubrication whilst preventing slipping of the ring.

RECOMMENDATION FOR USE

Mechanical and friction press : 5 - 15 %

Severe application : 15 - 25 %

Spray application is recommended

Ring Rolling : 2 - 15%

Spray or flood application is recommended

TYPICAL PHYSICAL PROPERTIES

<i>Appearance</i>	<i>Colourless liquid</i>	
<i>Specific gravity @ 20°C</i>	1.18	ASTM D 1298
<i>pH</i>	10.6	DIN 51396
<i>Refractometer factor</i>	3.1	
<i>Viscosity BK-20°C (505-20rpm) mPa s</i>	220	

BENEFITS

- Reduces costs and increases productivity - good 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.

GT 2013/11/08 GB



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>

This document contains information based on data that is believed to be correct. However, the product may not be applicable to all uses and operating environments. No warranty or guarantee is expressed or implied.