

# FENELLA FLUID F 3626 G

Ready to use water and graphite based hot forging release agent

## DESCRIPTION

FENELLA FLUID F 3626 G is a release agent based on water and graphite designed for hot and warm forging of ferrous metals.

It is designed to be used as supplied, removing the need for mixing equipment and concentration measurement in use.

## APPLICATIONS

FENELLA FLUID F 3626 G is typically used for medium to high difficulty hot forging of complex shapes such as crankshafts and cam shafts on mechanical presses.

FENELLA FLUID F 3626 G forms a graphite coating on the die with excellent release and lubricating properties. This coating allows a good metal flow during hot forging, leaving an adherent and resistant film on the die, even at high die temperatures.

## RECOMMENDATION FOR USE

Spray application is recommended. Volume required will vary with die and part geometry.

Mechanical and friction presses : 100 %

Die Temperature range : 150 – 400°C

FENELLA FLUID F 3626 G is compatible with the materials that are commonly used in forging presses and machine tools.

## TYPICAL PHYSICAL PROPERTIES

Appearance	Black liquid	
Specific gravity @ 20°C	1.04	ASTM D 1298
pH	11.1	DIN 51396
Solid Lubricant	Synthetic Graphite	
Viscosity BK-20°C (S05-20rpm) mPa s	650	

## BENEFITS

- Reduces costs and increases productivity - high lubrication properties, reduces die wear, prevents pick-up and scoring, promotes good metal flow in hot operations on dies up to 400°C.
- Easy to use - stable graphite dispersion, ready to use as supplied.
- Operator and Environmentally friendly - mineral oil and ammonia free

## ADDITIONAL PRODUCT DATA

It is recommended that dilutions, if required, are made with suitable mixing equipment. If manually mixing, add water slowly to the product while mixing for best results. Most graphite dispersions should be stirred in use to ensure even dispersion of the graphite, this is not normally required with FENELLA FLUID F 3626 G.

## 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.