

# FENELLA FLUID F 3802 N

Water miscible synthetic hot forging lubricant (graphite free)

## DESCRIPTION

FENELLA FLUID F N 3801 is a water based, oil and graphite-free lubricant for use in hot forging / warm forging of steel alloys.

## APPLICATIONS

FENELLA FLUID F 3802 N is a solution that combines organic compounds and metal salts to give the product the best performance in operations performed on hammers and operations requiring the diesel effect to ensure the proper release and extraction of parts, while leaving little residue in the dies.

FENELLA FLUID F 3802 N is designed for ferrous forging to replace oil based graphite or graphite free products normally applied by brush on hammers.

## RECOMMENDATION FOR USE

The dilution rate can vary according the severity of application.

Hammer : 10 - 20 %

Automatic or hand spray is recommended.

Concentration can be monitored with a refractometer.

## TYPICAL PHYSICAL PROPERTIES

Appearance	Brown liquid	
Specific gravity @ 20°C	1.16	ASTM D 1298
pH	9.7	DIN 51396
Refractometer factor	2.3	
Viscosity BK-20°C (S05-20rpm) mPa s	1000	

## 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.

GT 2013/11/08 GB



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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