

FENELLA FLUID F 603 G

Water and graphite based hot forging release agent

DESCRIPTION

FENELLA FLUID F 603 G is a new generation forging lubricant based on a stable dispersion of graphite in water.

FENELLA FLUID F 603 G forms a tenacious lubricating film with excellent resistance to high die temperatures to increase die life and ensure proper metal flow in the dies. In use there is no fume, flame or explosion danger, therefore reducing the risk of die cracks and rapid wear.

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

APPLICATIONS

Successfully used in hammer, mechanical, friction and crank presses, the product covers heavy duty applications such as severe extrusions and deep forgings in steel and can also be used for the production of complex parts.

FENELLA FLUID F 603 G is used diluted with water and is best applied by automatic or manual spray. Frequently used on large, closed die steel forgings, replacing graphited oil products commonly used in these parts

RECOMMENDATION FOR USE

Mechanical and friction press : 10 - 50 %

Hammer : 20 - 50 %

Product may be used as supplied for some very large forgings.

Automatic or manual spray application is recommended

TYPICAL PHYSICAL PROPERTIES

<i>Appearance</i>	<i>Black liquid</i>	
<i>Specific gravity @ 20°C</i>	1.07	ASTM D 1298
<i>pH</i>	9.5	DIN 51396
<i>Solid Lubricant</i>	<i>Natural Graphite</i>	
<i>Viscosity BK-20°C (S05-20rpm) mPa s</i>	360	

BENEFITS

- Reduces costs and increases productivity - economical product, 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, large 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 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.

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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