

4.1.1 LUBRICANTS FOR HOT-FORGED (WATER BASE)



4.1.2 LUBDECO 250 A

Not pigmented lubricant for forge die.

This is a lubricating and die demoulding product, which does not incorporate into its graphite formulation what makes it important for the applications where the presence of the graphite pigmented product is not proper or necessary. For example, in certain type of connecting rods, gears and other automotive pieces and manual tools, LUBDECO 250 A is a synthetic product, based on organic salts, silicon, oil and solid lubricant free.

PHYSICAL PROPERTIES:

| | |
|--------------|------------------------|
| Solid tenor: | 14.5 to 15.5 % |
| Color | Blue |
| Diluent | Water |
| Density | 1.07 g/cm ³ |
| Ph | 6-8 |

USAGE METHOD:

This product is a concentrate that must be diluted with water before being applied to dies. The dilution degree has to be determined in function of weight, piece complexity, and other operational variables, as die temperature, operation velocity, application system, application distance and time. Possible dilutions are located between 1:5 (product : water) and 1:10.

APPLICATION METHOD:

The characteristics of this product recommend its application to dies through the use of proper automated devices as pulverization guns or valves.

PRESENTATION:

Plastic drum with a 200 kg. capacity
Plastic container with a 18 kg. capacity