

FENELLA™ F 3802-G

Water extendable Hot Forging Release Agent

DESCRIPTION

FENELLA F 3802-G is a high quality graphite aqueous lubricant specially developed for steel hot forging.

FENELLA F 3802-G is a lubricant/release-agent based on water-dispersed graphite for high performance use. Its main application is steel hot & warm forging, but it can also be used for copper titanium & nickel stamping.

FENELLA F 3802-G is applied with success on both mechanical and screw presses, on hammer, even for very severe operations to form difficult pieces.

FENELLA F 3802-G shows an exceptional adhesion at high temperature and forms on the die a film with superior release and lubricating properties due to its graphite parameters content such as particle size and crystal-clear network. The film provides a very good metal flow during deformation at high temperature and no built-up of residual film is left on the die.

FEATURES

- **FENELLA F 3802-G** owns spraying systems cleaning properties which allows an important decrease in nozzle blocking problems.
- High Quality Graphite used
- Can be used for Non-Ferrous metals
- No build-up of residual film

TYPICAL VALUES

Product Appearance	Black fluid
pH Neat	11.2
Specific Gravity @15°C	1.156 kg/L
Brookfield Viscosity @20°C (SO5—20rpm)	1200 mPa.s
Solid Lubricant:	Synthetic Graphite

HEALTH AND SAFETY

Refer to MSDS for proper handling and disposal. Please note that the MSDS includes handling, health and disposal information which should be passed on to your employees, and to anyone else who comes in contact with our product. Additional advice can also be obtained from your local Houghton representative.

NOTE: Read and understand all precautions on container labels before using this product.

01 July 2011 Version 1.0, Code: D8901L5109



D.A. Stuart India Private Limited
 Plot No. 32A. HUDA Enclave,
 Jubilee Hills, Hyderabad
 Andhra Pradesh 500033 India

Phone: +91 (40) 2354-1250
 Fax: +91 (40) 2354-4869
 info@houghtonindia.com
 www.houghtonindia.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.

FENELLA™ F 3802-G

Water extendable Hot Forging Release Agent

REFERENCES

FENELLA F 3802-G is compatible with materials commonly used by machine tools manufacturers.

HOW TO USE

FENELLA F 3802-G viscosity is suitable for all the kind of dosing systems generally used in forging.

Working concentration of **FENELLA F 3802-G** can vary in function of the specific process.

Basic operations	3-10% in water.
Very severe operations	10-20% in water.

Diluted dispersion is applied by a spray system.

SHELFLIFE & AVAILABILITY

Under normal conditions the recommended shelf life for **FENELLA F 3802-G** is a minimum of Twelve (12) months, unless otherwise specified. The product should be stored inside (5-40°C) for no more than 1 year and be protected from freezing.

FENELLA F 3802-G is available in Pail, Drum or Tote. Other sizes may be available upon request, please contact your Houghton sales representative.

01 July 2011 Version 1.0, Code: D8901L5109

RELATED PRODUCTS

- CUT-MAX®: Straight cutting oils
- GARIA™: Straight cutting oils
- MACRON™: Straight cutting and honing oils
- EXCELENE™: Straight cutting and honing oils
- DASCOLENE™: Straight OEM approved cutting oils
- HOCUT®: Water miscible metalworking fluids
- DASCOOL™: Water miscible metalworking fluids
- DROMUS™: Soluble metalworking fluids
- ADRANA™: Micro-emulsion metalworking fluids
- SITALA™: Semi-Synthetic metalworking fluids
- METALINA™: Synthetic metalworking fluids
- HOUGHTO-GRIND®: Straight and water miscible grinding fluids
- HOUGHTO-DRAW®: Straight and water miscible drawing stamping and forming fluids.
- CINDOL™: Straight and water miscible drawing and forming fluids especially for Aluminium parts.
- FENELLA™: Straight and water miscible drawing, stamping and forming fluids.
- CERFA-KLEEN®: Water miscible cleaning fluids
- VIBRA-KLEEN®: Water miscible vibrating cleaning fluids
- CALLINA™: Water miscible cleaning fluids
- RUST VETO®: Straight and water miscible rust preventive fluids.
- ENSIS™: Straight and water miscible rust preventive fluids.
- COSMOLINE®: MIL-SPEC Straight and water miscible rust preventive fluids.



HOUGHTON™

D.A. Stuart India Private Limited
Plot No. 32A. HUDA Enclave,
Jubilee Hills, Hyderabad
Andhra Pradesh 500033 India

Phone: +91 (40) 2354-1250
Fax: +91 (40) 2354-4869
info@houghtonindia.com
www.houghtonindia.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.