

BONDERITE L-FG 1105M ACHESON

Known as Deltaforge 1105 M
November 2016**PRODUCT DESCRIPTION**

BONDERITE L-FG 1105M ACHESON provides the following product characteristics:

Technology	Lubricants
Product Type	Water based lubricant
Application	Forging die lubricant

BONDERITE L-FG 1105M ACHESON is a non-graphited, water based die lubricant designed particularly for the hot forging of ferrous metals on presses and hammers. It is based on unique synthetic lubricants which form an excellent lubricating film on the die and allow wetting of the dies at temperatures up to 400°C. Such optimum lubrication allows good metal movement and superior release properties for a wide variety of forgings.

Special Features:High dilution ratio:

BONDERITE L-FG 1105M ACHESON operates effectively at higher dilutions.

Temperature tolerance:

Good lubrication is assured at die temperatures up to and exceeding 400°C.

Forging quality:

With BONDERITE L-FG 1105M ACHESON there is no lubricant build up on the tooling and presses, and the finished parts are clean.

Lubricant quality:

There is no settling after dilution and BONDERITE L-FG 1105M ACHESON is not harmed by freezing.

Working environment:

BONDERITE L-FG 1105M ACHESON is unparalleled in cleanliness and is also odourless, smokeless and non-toxic.

Application Areas:

Hot forging of ferrous metals on presses and hammers.

TECHNICAL DATA**(as supplied):**

Lubricant	organic compounds
Carrier	water
Diluent/consistency	water, medium viscous liquid
Density, kg/m ³	1,100

pH-value	6.5 to 7.5
Solid content, %	18 to 19

DIRECTION OF USE**Preliminary Statement:**

Prior to use it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

Dilution:

BONDERITE L-FG 1105M ACHESON is diluted by adding water to the product.

Only mild agitation is needed to homogenize the dilution.

Once properly diluted this product requires no further stirring. For initial evaluation, particularly on difficult jobs, a ratio of one part product to five parts water is recommended.

During actual production a higher dilution will probably be found to be satisfactory, though the required dilution will vary with the severity of the job.

Application:

Diluted BONDERITE L-FG 1105M ACHESON should be applied by spray.

Storage:

While freezing will not damage BONDERITE L-FG 1105M ACHESON it is advisable to avoid excessive heat or direct sunlight and to reseal containers after use to avoid contamination.

Shelf Life

- 24 months from date of qualification under original seal.

Classification:

Please refer to the corresponding **Material Safety Data Sheets** for details on:

Hazards identification
Transport information
Regulatory information

ADDITIONAL INFORMATION**Disclaimer****Note:**

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