

BONDERITE L-FG 658 ACHESON

GRAPHITE FORGING LUBRICANT

(KNOWN AS DELTAFORGE 658)

Issued 6/5/2013

DESCRIPTION

BONDERITE L-FG 658 ACHESON (known as DELTAFORGE 658) is a high performance, water-based, die lubricant designed specifically for the hot forging of ferrous metals on presses. It excels where metal movement is severe, such as extrude-type operations, and is capable of wetting dies at temperatures up to 371°C (700°F).

BONDERITE L-FG 658 ACHESON (known as DELTAFORGE 658) is formulated to assure excellent lubricity and efficient die filling while providing a smoke-free, more profitable shop operation.

FEATURES

- Water-based die lubricant
- Graphite provides high lubricity for extreme high metal movement
- Excellent stability

BENEFITS

- Wets dies up to 371°C (700°F)
- Excellent for hot forging
- Excellent for extrude type operations
- No build up in die cavity
- Improved part quality
- Reduced press downtime due to stickers
- Increased die life
- Reduced scrap and rework
- No separation or settling in concentrate resulting in consistent forging performance

TYPICAL APPLICATIONS

- Mechanical and hydraulic press work; particularly extrusions

PHYSICAL PROPERTIES (as supplied)	Lubricants :	graphite
	Carrier/diluent :	water
	Solids content :	21.3 – 22.7%
	Density :	9.5 lb/gal
	Freezing point :	0°C (32°C)
	Shelf life :	12 months from date of qualification under original seal

METHOD OF USE

BONDERITE L-FG 658 ACHESON (known as DELTAFORGE 658) is supplied as a concentrate and should be diluted with water before use. It is particularly easy to handle due to its low viscosity. For initial evaluation, a dilution ratio of 1:4 (concentrate:water) is recommended. However, dilution ratios will vary according to job severity.

To achieve best results, **BONDERITE L-FG 658 ACHESON (known as DELTAFORGE 658)** should be spray applied.

STORAGE/ HANDLING

Store **BONDERITE L-FG 658 ACHESON (known as DELTAFORGE 658)** in a cool place, but do not allow product to



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freeze. Product should not be used once frozen. Always tightly reseal the container to prevent evaporation or contamination.

APPLICATION ASSISTANCE

Henkel representatives are available to assist you in production start-up with **BONDERITE L-FG 658 ACHESON (known as DELTAFORGE 658)**. For more information, visit our website at www.henkelna.com/metals for the Henkel global location nearest you.

HEALTH & SAFETY

Please consult Material Safety Data Sheet.

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