

DATA SHEET

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## B-TECH FORGE 77

**Lubricating release agent for Aluminium  
flow forming**

<b>DESCRIPTION</b>	Water based, pigment-free premium lubricating release agent, used for flow forming of Aluminium alloys.
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<b>TECHNICAL DETAILS</b>	<i>Physical state:</i> liquid	<i>Density (20°C):</i> appr. 0.985 g/ml
	<i>Colour:</i> milky white	<i>Flammability:</i> non-flammable
	<i>Odour:</i> mild, typical	<i>Miscibility:</i> water, in all
	<i>pH (pure):</i> 9.0	proportion ratios


<b>SPECIFICATIONS</b>	TEST	METHOD	STANDARD LIMIT
	Appearance	Visual (AO/1)	milky white to yellowish liq.
	pH (pure)	Potentiom. (PM/1)	8.0 - 9.5
	Chem-phys. stability	Centrif. A (SE/4)	cream. max 5%; settl. max 1%

<b>CHARACTERISTICS</b>	<ul style="list-style-type: none"><li>✓ Elevated wetting and sticking capacity on the warm tools, by spray application.</li><li>✓ Excellent lubricating and releasing capacities at very high temperatures.</li><li>✓ It reduces at a minimum the friction between the Aluminium alloy and the rotating tools, so as to improve the plastic deformation of the metal, allowing a reduction of the die and tools wear.</li></ul>
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**HOW TO USE**

 The product can be applied both on the mandrel and on the rollers. It can be used pure or diluted in water. To dilute the product, add water to the product and stir briefly.

 The approximate usage concentration ranges between 30% (1:33) and 100% (pure) according to the spray time, tool temperature and other parameters.


The optimal concentration has to be determined by experimental tests.

 Apply the diluted/pure product by atomizing spraying system. Mandrel: spray for a time long enough to coat the entire surface of the mandrel.


Rollers: spray in frequent pulses or continuously during the flow forming process.

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**STORAGE**

 Avoid long storage under the sun. Do not store near heating sources.

 Store at temperature between +5°C and max. +40°C.

 Shelf life: not less than 12 months, in the original closed packaging. Keep closed containers.

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**PACKAGING**

Pails: 20 Kg net weight

Drums: 200 Kg net weight

IBC: 1000 Kg net weight

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**FURTHER INFORMAT.** For information regarding safety, transport and disposal refer to the Safety Data Sheet of the product.

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The data in this technical information sheet correspond to the properties of the product at the time of the sale and with regard to the specified application. It is on the responsibility of the user to make sure that the product is suitable for the use to which he intends to apply it.