

SUMIDERA 169

Forging lubricant for warm forming

SUMIDERA 169 is a water soluble graphite containing forging lubricant for chipless forming of metals. **SUMIDERA 169** prevents adherence of metals on mould wall and tools. **SUMIDERA 169** has especially been developed for reduction of friction and for very long flow paths.

SUMIDERA 169 is a watery dispersion of graphite in water with addition of selected raw materials. Owing to its very good wetting behaviour on hot tools it is suitable for working temperatures up to +1400°C.

Properties:

- High content of active agent (38%)
- Enables flowing of metal
- Creates high surface quality
- Low abrasion, thus long tools endurance
- Economical application

Application:

SUMIDERA 169 is usually diluted with water at ratio 1:5 up to 1:15. In particular cases like damaged, chapped surfaces, a temporary accumulation of active agent is reasonable. The lubricant-water-alloy has to be agitated constantly in order to avoid sedimentation of graphite particles.

The application of prepared mixture can be carried out using a brush, hand sprayer or automatic spraying device.

Technical Data:

Properties	Typical Value
Active agent-content:	38%
Density at 20°C:	1.200 kg/m ³
Colour:	black
pH-value	10,6

The stated values can fluctuate within commercial frame.

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