

# FORGING LUBRICANTS FOR STEEL, TITANIUM, YELLOW METALS

in the temperature range 700° – 1250° C

## WATER – BASED PRODUCTS

Product	Forged Metals	Remarks
GRAPHITEX 118 K	Carbon steel Copper	General purpose graphite-based forging compound containing smelt- glasses and expulsion agents. <u>Application:</u> All forgings, including crankshafts.
GRAPHITEX CR 9	Carbon steel	Forging Lubricant based on de-foliated graphite with powerful expulsion agents. <u>Application:</u> General application; also suitable for deep cavity and intricate forgings, e.g. twisted crankshafts with counterweights.
GRAPHITEX 231	Steel Copper Titanium Special alloys	Synthetic forging lubricant <u>Application:</u> All closed die forgings on hammers and presses of low to medium complexity. Highly accurate forgings can be produced.
GRAPHITEX 224	Steel Copper Titanium Special alloys	Polymeric forging lubricant.(no graphite) This product is able to substitute, with some exceptions, graphite-based products. <u>Application:</u> All closed die forgings up to medium complexity.

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**OIL- BASED PRODUCTS**

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Product	Forged Metal	Remarks
REXAL S 99	Carbon steel	Viscous oil loaded with high purity graphite of semi colloidal fineness; general purpose product. If needed, <i>Rexal S 99</i> can be diluted with thin oil in order to obtain a product that which can be applied by spray.
REXAL S 110	Steel Copper	Thin dispersion of colloidal graphite in low viscosity mineral oil; application by spray.

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**FORGING LUBRICANTS IN POWDER FORM – OR GRANULES**

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Product	Forged Metal	Properties
<b>GRAPHITEX Powder LSB</b>	Carbon steel Copper Stainless steel	Surface hardening- and lubricating compound for special bottling and extrusion operations of high alloy steels; also suitable for aluminium forgings.
<b>GRAPHITEX FP3</b>	Carbon steel Copper Stainless steel	Granulated forging compound for heavy piercing operations, e.g. railway wheels and gas bottles.