Product Data Sheet

Deltaforge® 1105

Water based synthetic forging die lubricant

DESCRIPTION

Deltaforge® 1105 is a non-graphited, water-based die lubricant formulated to provide effective lubrication and release when hot forging on presses, upsetters and hammers. It is capable of wetting dies at temperatures as high as 371°C (700°F), and provides good metal flow.

FEATURES	BENEFITS
• Non-graphited, water-based die lubricant	• Wets dies up to 371°C (700°F)
	• Excellent for hot forging
• Good film formation at high temperatures	• Effective release and lubrication at high die temperatures
• Contains water-soluble, organic salts for lubrication	• Elimination of graphite overspray leads to a cleaner plant environment
	• Less plugging of spray nozzles
	• Not damaged by freezing
• Stable in concentrate and diluted form	• No separation or settling in concentrate resulting in consistent forging performance

TYPICAL APPLICATIONS

- Hot forging of ferrous metals
- Mechanical presses, upsetters and hammers

PHYSICAL PROPERTIES
(as supplied)

Lubricants	:	soluble synthetic
Carrier/diluent	:	water
Solids content	:	19.5 – 20.5%
Density	:	9.1 lb/gal
Freezing point	:	-2°C (28°F)
Shelf life	:	12 months from date of qualification under original seal

METHOD OF USE

Dilution

Deltaforge® 1105 is diluted by adding water to the product prior to application on forging dies. A typical dilution ratio of 1:5 (concentrate:water) is suggested for initial evaluation. Actual dilution ratios vary depending on part complexity and application technique.

Application

Spray application is recommended; however, product can be successfully swabbed. Manual and automatic spray systems especially designed for application of die lubricants are available from Acheson Colloids Company. Consult your local Acheson representative for additional lubricant and Dag® application equipment information.

STORAGE/ HANDLING

If **Deltaforge® 1105** freezes, allow to completely thaw before proceeding with the described method of use. Always tightly reseal the container to prevent evaporation or contamination.

APPLICATION ASSISTANCE

Henkel representatives are available to assist you in production start-up with **Deltaforge® 1105**. 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.
NOTES	The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

Henkel
32100 Stephenson Highway
Madison Heights, MI 48071
866.332.7024