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Deltaforge™ 1105

Synthetic, Water-Based Die Lubricant

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DESCRIPTION

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

Deltaforge 1105 is formulated for application by spray, but can also be successfully swab applied. Regardless of the application method chosen, **Deltaforge 1105** allows economical dilution ratios. **Deltaforge 1105** is odorless, nontoxic, smokeless, and provides for a cleaner plant environment.

ADVANTAGES

- Will not settle
- Reduced buildup on tooling and presses
- Not damaged by freezing
- Lessens plugging of spray nozzles

TYPICAL APPLICATIONS

Lubricant	: soluble synthetic
Carrier/diluent	: water
Consistency	: pale green liquid
Density	: 9.1 lb/gal
Flash point	: none
Freezing point	: 28°F (-2°C)
Shelf life	: 6 months under original seal

APPLICATION

Dilution

Deltaforge 1105 is normally diluted by adding water to the product (not vice versa) prior to application on forging dies. A typical dilution ratio of 1:5 (product: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 swab applied. Manual and automatic spray systems especially designed for application of die lubricants are available from Acheson Colloids Company under the Dag® Lubrimate name. Please contact Acheson Colloids Company for more information.

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APPLICATION
ASSISTANCE

Acheson's **Application Specialists** are available to assist you in production start-up with **Deltaforge 1105**. For more information, please contact Acheson Colloids Company, (800) 255-1908, fax (810) 984-1446, web.mail@nstarch.com, or visit our website at www.achesonindustries.com.

HEALTH & SAFETY

Harmful if swallowed, inhaled, or absorbed through skin. May cause eye irritation. Wash thoroughly after handling. Keep away from heat, sparks, or flame. Keep container tightly closed when not in use. Use with adequate ventilation. Avoid breathing vapor. Empty containers may retain hazardous properties. Follow all MSDS/label warnings even after container is emptied.

STORAGE/SHIPPING/
HANDLING

If product freezes, allow to completely thaw before proceeding with the described method of use. Always tightly reseal the container to prevent evaporation or contamination. See Acheson Material Safety Data Sheet for further safety and first aid instructions.

NOTE

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