

## Forging Lubricants - keywords:

Graphite free, water based.

### 1 Description:

TechForge 616 is a water miscible lubricant, free of graphite and oil, for dies and tools used in hot and warm forging. TechForge 616 delivers excellent lubrication and wetting properties with minimal residue for outstanding release.

### Typical Properties (Not Specifications):

Appearance	Slight Yellow
Boiling Point	212 deg F
Density	1.14 g/ml
pH	11-Oct

### Health & Safety

TechForge 616 is available in 55-gallon drums, 330 gallon totes and pails.

Storage And Handling: See Safety Data Sheet Before Use. Use at room temperature. If frozen, allow to thaw completely prior to use. Do not expose to extreme high temperature due to container rupture. Do not pressurize drum or reuse empty container. Follow all safety regulations on label.

Non-Warranty: While the information and recommendations sent forth herein are believed to be accurate as of the date thereof, Fortech Products, Inc. makes no warranty with respect thereto and disclaims all liability for reliance therein.

### Features / Benefits

Can be applied by spray, flood, flushing or swabbing  
Improved work environment  
Reduced corrosion  
Excellent wetting

### Mix / application & Use

Mix and dilute TechForge 616 with water before use to the required concentration for the specific operation.

Guidelines for Dilution

Difficult operations ⇒ 20-50%

Standard operations ⇒ 10-20%

Simple parts/Shallow cavities or rib sections ⇒ 5-10%