

## Product information

### AirForge 4028

#### Water based, transparent die lubricant for warm forging

#### Description

AirForge 4028 is a synthetic, graphite-free, high performance die lubricant with excellent lubricating properties. After it was applied it forms a white homogeneous spray film insulating drastically the heat in the work piece from the die. AirForge 4028 can be used at higher temperatures e.g. 900 to 1300°C.

The excellent lubrication properties ensure less development of adhesive residue in the forging die or presses, which leads to clean gravures.

#### Appliance

AirForge 4028 is supplied as a concentrate and can be depleted with water in user-defined concentrations. The mixture has to be stirred to obtain a homogeneous solution. At high concentration it is recommended to stir the solution continuously. The mixture can be used in every common automatic sprayer or hand-held spraying equipment. The degree of dilution is based upon complexity of forming processes and should be determined in a field test. We will be pleased to support you to determining the concentration and to adapt the method to your specific requirements. Our R&D department could also supply you with concentration curves if needed.

#### Operating conditions

AirForge 4028 can be used in every forging application for steel alloys, where use of graphite-based products is not appreciated out of hygienic reasons.

#### Technical data

Appearance	Transparent, high viscous fluid	
Solid lubricant	none	
Density @ 20°C	1.2g/cm <sup>3</sup>	ASTM D 1298
pH-value (neat)	~ 7.6	
Viscosity @ 20°C	~ 4500 cP	Brookfield-Viscosity

AirForge 4028 does not contain any toxic chemicals. It is free of organic solvents and non-flammable. The shelf life of AirForge4028 is 12 month in the closed pail. The product should be stored at 5 - 25°C and should be protected from frost. AirForge 4028 needs to be stirred up before use.

For further information please see our Material Safety Data Sheet.

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