

BONDERITE®

CUSTOMER USE CASE

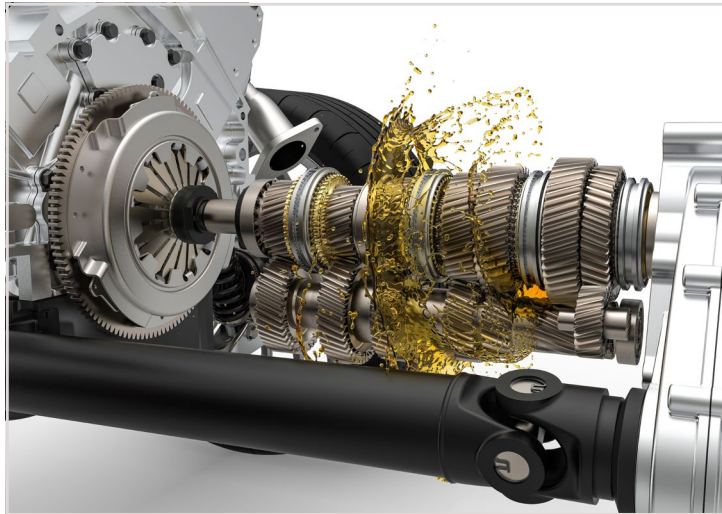
BONDERITE® L-FG F 605

Graphite-free, water-based die lubricant for hot forging of ferrous metals on presses and hammers



1 CUSTOMER CHALLENGE

- › Leading global supplier sought to decrease costs & improve employee health & safety during forging of bearing components on chassis applications.



2 RECOMMENDED TECHNOLOGY

- › Graphite-free forging lubricant, BONDERITE® L-FG F 605
- › Ideal for less strenuous forming applications

Operates effectively at higher dilution ratio

Non-toxic emissions

Optimum lubrication allows good metal movement & superior release

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Henkel Adhesive Technologies

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BONDERITE® L-FG F 605

Graphite-free & water-based die lubricant for hot ferrous forging

3 OUTCOMES

	BONDERITE® L-FG F 497 (graphite-free lubricant)	BONDERITE® L-FG F 605 (graphite-free lubricant)
Die Life	Shorter	Longer
Billet weight (kg)	2.3	1.8
Cycle time (seconds)	3.8	2.1
Billet temperature (°C)	1180 - 1280	1180 - 1280
Adjusted dilution ratio	16% = ca. 1:5 (F 497)	8% = 1:12 (mix of F 497/F 605) 7.2% = 1:13 (F 605) 6.8% = 1:14 (F 605)

Customer testing indicated an increase in die life, higher dilution ratio and savings on cost per part with BONDERITE® L-FG F 605 versus BONDERITE® L-FG F 497.

TO FIND OUT MORE ON OUR PROCESSING SOLUTIONS, VISIT:

www.henkel-adhesives.com