

**BONDERITE L-FG 1105 ACHESON  
SYNTHETIC FORGING LUBRICANT  
(KNOWN AS DELTAFORGE 1105)**

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**DESCRIPTION**

**BONDERITE L-FG 1105 ACHESON (known as 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**

- Non-graphited, water-based die lubricant
- Good film formation at high temperatures
- Contains water-soluble, organic salts for lubrication
- Stable in concentrate and diluted form

**BENEFITS**

- Wets dies up to 371°C (700°F)
- Excellent for hot forging
- Effective release and lubrication at high die temperatures
- Elimination of graphite overspray leads to a cleaner plant environment
- Less plugging of spray nozzles
- Not damaged by freezing
- 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	:	17.0 – 19.0 %
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**

**BONDERITE L-FG 1105 ACHESON (known as 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**

Manual or automated spray application is recommended; however, product can be successfully swabbed.



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## STORAGE/ HANDLING

If **BONDERITE L-FG 1105 ACHESON (known as 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 **BONDERITE L-FG 1105 ACHESON (known as DELTAFORGE 1105)**. For more information, visit our website at [www.henkelna.com/metals](http://www.henkelna.com/metals) for the Henkel global location nearest you.

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## HEALTH & SAFETY

Please consult Material Safety Data Sheet.

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