LUBRICATE

TECHNICAL DATA SHEET

METFORM O.F GEL

D4237

Oil Free Synthetic Tube Bending Lubricant



DESCRIPTION

METFORM O.F Gel is a multi-purpose, mineral oil free, synthetic lubricating gel, specially formulated for mandrel tube bending operations. It incorporates a highly effective blend of extreme pressure additives and lubricity additives that provide lubrication when bending both ferrous and non-ferrous materials. The gel consistency keeps the product where it is required during the bending operation providing maximum performance for improved component quality and reduced tool wear. Product residues are easily removed using neutral or mildly alkaline aqueous cleaners.

METFORM O.F Gel has been specially designed to allow application through the mandrel reducing wastage and ensuring the lubricant is applied to the correct areas. This eliminates the potential for components to be bent without sufficient lubricant which can damage components and place additional stresses on tools and equipment.

METFORM O.F Gel is used extensively in the manufacture of motorcycle components and automotive exhaust systems. It is also used in the production of the specialist internal pipework required for new buildings and maritime vessels. The versatile formulation can also be used in the production of tubular furniture and any other applications where tube bending is required.

FEATURES & BENEFITS

Non-drip gel formulation	Reduced wastage
Non-fuming	Eliminates the need for cleaning prior to welding
Contains extreme pressure & lubricity additives	Highly effective in most bending applications
Water washable	Easy residue removal
Versatile formulation	Suitable for use on ferrous and non-ferrous metals

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ORAPI MAINTENANCE UK Ltd, Unit 8, Britannia Park, Patent Drive,
Wednesbury, West Midlands, WS10 7XD

Tel: +44 121 525 4000 Web: www.orapi.uk Email: info.uk@orapi.com

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CHARACTERISTICS

Appearance:	Orange gel
Odour:	Mild
Concentrated pH:	9.0
Solubility:	Miscible in water
Flashpoint:	Non-flammable

STORAGE

Store in original containers away from direct sunlight. Protect from freezing.

DIRECTIONS FOR USE

METFORM O.F Gel is supplied ready for use and should not be diluted or blended prior to use. For best results it is recommended that the product be applied via the mandrel lubrication system, alternatively manual application to the wiper dies and mandrel balls prior to bending can be employed. Where liquid lubricants have been used previously alterations to the machines pressure settings will most likely have to be made.

After bending tubes can be heat treated or welded without the need to remove remaining residue. Where complete removal of the lubricant is required, it is recommended that components be rinsed using a mildly alkaline cleaner applied by spray wash or immersion cleaning systems. **METSPRAY AK3806** is a corrosion inhibited aqueous cleaner that will effectively remove lubricant residues without damaging components. Its use for removing lubricant residue is recommended.

METFORM O.F Gel is not compatible with highly acidic, highly caustic, or solvent type cleaning systems.

HEALTH & SAFETY

Refer to separate Material Safety Data Sheet (MSDS) for further information.

PACKAGING

METFORM O.F Gel is available in the following pack sizes:

D4237-20 20L Bucket

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