

# GRA 34/20

## PRESENTATION

Water based die lubricant for copper and aluminium extrusion process.

## PROPERTIES

- ☞ **GRA 34 / 20** produces a highly thermal and mechanical resistant graphite based coating. It permanently resists to temperature exceeding 450 °C, and allows efficient lubrication in metal extrusion process.
- ☞ **GRA 34 / 20** has a specific rheology allowing a leaf effect at high temperature. This specific property makes **GRA 34 / 20** efficient in long deformations.
- ☞ **GRA 34 / 20** has a high covering power and stops metallic diffusion on die alloy.
- ☞ **GRA 34 / 20** prevents dies from thermal shocks.
- ☞ **GRA 34 / 20** can be applied on very hot metallic surfaces ( $> 450\text{ °C}$ ).
- ☞ **GRA 34 / 20** can be used as a pre-coating for die lubrication particularly for first part forming.

## ADVANTAGES

- ☞ Allows tool life increase
- ☞ Exceptional lubricant coating life : the graphite based coating allows to make long metal deformation without film break problem.
- ☞ High operating temperature capability : **GRA 34 / 20** can be applied on very hot surfaces and keeps its properties.
- ☞ **GRA 34 / 20** does not emit smoke and is not toxic.

## PHYSICAL CHARACTERISTICS

	METHODS	VALUE
Carrier	WITHOUT	Water
Appearance	WITHOUT	Black viscous fluid
pH	MCC 67	8
Specific gravity at 20°C	MCC 168	1000 - 1100 kg/m <sup>3</sup>

*MCC = Condat's Control Method*

## METHOD OF USE

**GRA 34 / 20** can be applied by spray or dipping. It is highly recommended to maintain diluted product at a temperature below 60°C, and to stir during operation.

**GRA 34/20** is a product ready for use.