

TECHNICAL DATA SHEET



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Sector: Industrial

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SOLFORM GEL

NON-OIL EXTREME TUBE BENDING LUBRICANT

Solform Gel is an oil-free, water based, tube bending gel designed to replace conventional oil and soap based lubricants, thus promoting a clean & tidy 'OIL-FREE BENDING SHOP' whilst also easing many downstream operations by removing oil from the manufacturing process. It is process friendly and environmentally compatible, requiring only a thin film compared to oils. It can be welded and can easily be removed with aqueous means, although often no removal is necessary. Waste streams are disposable via foul sewer (with permission). Significant production savings can be made through reduced lubricant consumption, elimination of intermediate cleaning processes, reduced scrap and improved tool life.

Solform Gel's non-drip formula is designed for the lubrication of severe mandrel tube bending operations on tight radii and on difficult materials. It protects mandrels from scoring under the most extreme pressures and is ideal for use on stainless steel and aluminium or aluminised materials

Application

Dilution	Use as supplied.
Application methods	Via mandrel lubrication system or can be hand applied to mandrel
Cleaning of Parts	Alkaline aqueous wash @ 60 – 70oC. Will respond to some solvents
Clean-up of Tooling	Suitable rust inhibiting water based cleaner or solvent wipe.
Special Precautions	If constant and prolonged contact with paintwork is unavoidable, equipment should be painted with epoxy or other alkaline resistant paint.
Disposal	Diluted waste streams via sewer with local approval.



MADE IN BRITAIN

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Features & Benefits

Film thickens with heat	Less product needed to do the job, better mandrel life, less rework or scrap
Non-drip gel	No drips - less mess on clothes, gloves and floor
Does not fume or adversely affect welding	Can usually be welded without cleaning
Tolerant of most paint processes	No intermediate cleaning required
Water based product	Removable in alkaline aqueous wash
Free of chlorinated-paraffin and oil	Often needs no removal.

Typical Characteristics

Specific Gravity @ 15°C	0.90 TO 1.01
Appearance	Opaque, White Gel
pH	7 (neutral)
Solubility in Water	Dispersible
Packaging	15Kg Pails
Storage Conditions	Store Indoors – Will Freeze at 32°F (0°C)

Technical & Health and Safety

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For H&S info or SDS, please visit our website www.millersoils.co.uk



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