



HOT FORGING

WATER BASE							
Product	Specific gravity (gms/cc)	Lubricant	Particle size Microns	Viscosity (cps at 25°C)	Diluents	Application	Packing (kgs)
Lubricote-Z 12	1.15–1.20	Graphite	10-15	Creamy paste	Water	Hot closed die forging /upsetting. <u>Area of Application:</u> Forging dies	200
Lubricote – Z 12A	1.18–1.20	Graphite	<10	Creamy paste	Water	Hot closed die forging / upsetting <u>Area of application:</u> Forging dies	200
Lubricote – Z 31	1.04–1.10	Graphite	15 – 20	Paste	Water	General forging lubricantfor steel & alloys <u>Area of application:</u> On dies	200
Lubricote – Z 52	1.28–1.30	Graphite	1 – 3	Paste	Water	For hot press forging of heavy, intricate, high quality forgings for smooth surface finish. <u>Area of application:</u> On dies with proper spraying system	25 200
Lubricote – Z 63	1.16–1.19	Graphite	1 – 2	Semi-paste	Water	For hot press forging of heavy intricate, high quality forgings for smooth surface finish. <u>Area of application:</u> On dies with proper spray system .	20 25 200



OIL BASE

Product	Lubricant	Viscosity (CPS at 25°C)	Particle size Microns	Specific Gravity (gms/cc)	Diluent	Flash Point °C	Application	Packing (kgs)
Lubricote – X 21	Graphite	1100-1300	110-120	0.90-1.00	Oil	120-130	Hammer forging lubricant for punch & die.	25 200
Lubricote- X 21	Graphite	1000-1200	35–40	0.97-1.00	Oil	>200	Hammer forging lubricant for punch & die. <u>Application:</u> Swabbing	25
Lubricote – X 22	Graphite	1600-2000	35–40	0.90-1.00	Oil	120-130	Lubrication of dies in Nosing operation.	25
Lubricote – X 108	Graphite	Semi liquid	10	1.00-1.10	Mineral	>240	ERFB bomb shell forging.	25
Lubricote – X 126	Graphite	Semi paste	<35	0.94-0.98	Mineral	>200	Hot forging lubricantfor punch & die.	25



WARM FORGING

WATER BASE							
PRODUCT	Specific gravity (gms/cc)	Lubricant	Particle size microns	Viscosity (cps at 25°C)	Diluent	Application	Packing (kgs)
Lubricote – Z 27	1.20 - 1.24	Graphite	8-10	Creamy paste	Water	Hot forging and billet coating in warm forging. <u>Area of application:</u> Forging dies/Billet coating.	200
Lubricote – Z 54	1.00 - 1.07	Graphite	1-3	Paste	Water	For continuous sheet castings of aluminum. <u>Area of application:</u> On the upper and lower caster rolls by continuous automatic spray system.	25 200
Lubricote – Z 57	1.14 - 1.17	Graphite	1-2	Semi-paste	Water	Hot/warm press forging, extrusion of steel & alloys. <u>Area of application:</u> On dies with proper spray system.	25 200
Lubricote – Z 99	1.15- 1.17	Graphite	1-3	Semi liquid	Water	Hot press forging, half heavy intricate by high quality forgings for smooth surface finish. <u>Area of application:</u> On dies with proper spray system.	20
Lubricote – Z 504	1.15- 1.18	Graphite	1-3	Semi liquid	Water	For billet coating by dipping method	200



PRECISION FORGING

WATER BASE							
PRODUCT	Specific gravity (gms/cc)	Lubricant	Particle size microns	Viscosity (cps at 25°C)	Diluent	Application	Packing (kgs)
Lubricote – Z 51	1.10-1.12	Graphite	< 5	Semi-liquid	Water	Hot precision forging. Apply on dies with proper spray system	25 200
Lubricote – Z 513	1.14-1.16	Graphite	< 10	Semi liquid	Water	Hot precision forging. Apply on dies with proper spray system	25 200



COLD FORGING

WATER BASE							
PRODUCT	Specific Gravity (gms/cc)	Lubricant	Particle size Microns	Viscosity (CPS at 25 Deg.C)	Diluent	Application	Packing (Kgs)
LUBRICOTE – Z 28	1.15-1.25	GRAPHITE	<10	SEMI-PASTE	WATER	Apply with Spray System	20