



THE CLEAN NON-OIL PASTE



980 Series

IRMCO GEL 980 000

סדרת IRMCO GEL 980-XXX .
 המוצר הינו פולימר שמיוצר עם מים -ומכאן שנמהל במים.
 הג'ל משמש לשימון בעת עיצוב מתכות בתהליכים שונים.
 בסיום התהליך ניתן לנקות במים או בסבון אלקלי.
 לעיתים ניתן להמשיך לתהליכים כמו צביעה וריתוך ללא צורך בניקוי.
 שימוש בג'ל מפחית את השימוש בכמעט -70% בהשוואה לשמנים מקבילים.

OPERATIONS												METALS							APPROVED IN						
Bending	Blanking	Cutting	Drawing	Extruding	Forming	Grinding	Hydroforming	Ironing	Punching & Piercing	Roll forming	Spinning	Tube bending	Aluminum	Aluminized	Brass / Copper	Steel	Stainless Steel	High Strength Steel	Zinc	Carbide Tooling	US	Canada	Mexico	Europe	Australia
✓												✓	*	*	x	✓	✓		x	x	✓	✓	✓	✓	✓

Blank values indicate that this information is not currently available. Check with IRMCO for more details.
 * For more information, please request IRMCO OEM Approval list.

KEY

✓	: Recommended use
*	: Alternative use
x	: Not Recommended



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PRODUCT PROPERTIES

Appearance:	Clear, Light to dark amber				<i>Tendency</i>	<i>Stability</i>
Density:	8.244 lb/gal	61.67 lb/ft3	988.671 kg/m3	0.988 kg/L	Foam (ml):	
Viscosity (40°C):	--	--	--	--	pH:	8.01

Dilution (Water:Lubricant) Lubricant (%)	0:1	1:1	2:1	3:1	4:1	5:1	6:1	7:1	8:1	9:1	10:1	12:1	15:1	20:1	25:1	30:1
	Fluid tester (0-30):	19.9	9.9	6.6	5.0	4.0	3.3	2.8	2.5	2.2	2.0	1.8	1.5	1.2	0.9	0.8
Brix (%):	21.3	5.3	2.4	1.3	0.9	0.6	0.4	0.3	0.3	0.2	0.2	0.1	0.1	0.0	0.0	0.0

- Residue:** Viscous film requiring proper removal
- Flash point:** None.
- Container Storage:** Indoor suggested. Product will freeze at 32° F (0° C).
- Application Equipment:** IRMCO GEL Ejector assembly
 - Coverage: 7,600 - 11,000 ft2/gal 180 - 280 m2/l 400 - 600 mg/ft2 4.5 - 6.5 g/m2
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 - Dilution: Do not dilute. Use neat product.
- Parts cleaning:** Plain water rinse and/or mild alkaline cleaner 110° F (43.3° C).
- Tooling clean-up:** IRMCO 819-000, IRMCO 957-000 Cleaner-Degreaser or suitable rust inhibiting, water based cleaner.
- Disposal:** Sewer with local pre-approval.
- Press Grease:** For optimum results use recommended "Water Resistant Marine Grease" available from www.chemtool.com (815-459-1250).
- Special precautions:** This product is not compatible with acid, extreme caustic, or solvent type cleaning. Equipment should be painted with alkaline resistant epoxy paint such as Sherwin-Williams Tile Clad II (B62W101) or Devoe Coatings Devran 250.
- GUARANTEE:** Should you have a problem with any IRMCO item, notify your IRMCO representative for a replacement, credit or refund.
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