



Tower Oil & Technology Co.

BEND-ALL 004 TUBE BENDING GEL

BEND-ALL 004 is a synthetic, pour-able gel, formulated as a lubricant for draw bending and end-forming tube and pipe. It forms a high strength lubricating film on the mandrel and ID of the tube that will not slump or run off, even under high temperatures. **BEND-ALL 004** is recommended for use on a wide variety of metals. For bending aluminum mix one part of petroleum oil or vegetable oil to 2-3 parts **BEND-ALL 004**.

USAGE

BEND-ALL 004 should be used as a concentrate for difficult bending operations. For lighter duty bending, it may be diluted with one or two parts water. It can be applied by hand or through automatic mandrel rod lubrication systems capable of pumping higher viscosity liquids or greases. It is important to use sufficient lubricant on the tool and inside the tube or pipe to maintain a fluid film and prevent the lubricant from “drying-out”. **BEND-ALL 004** can be cleaned in an aqueous wash using an alkaline cleaner such as **TOWERKLENE 42-A**.

PHYSICAL CHARACTERISTICS

Density	1.1 g/ml 9.2 lbs/gal
Appearance	Light Green Colored Gel
Odor	Bland

BENEFITS

- **Contains No Hazardous Ingredients**
- **Contains No Petroleum Oil**
- **Does Not Contain Chlorine or Sulfur**
- **Spreads Evenly and Does Not Run From High Temperatures**
- **Cleans in Water Based Alkaline Solutions**
- **Can be Welded Through Without Cleaning**
- **Is Environmentally and Operator Friendly**

TECHNICAL SUPPORT

TOWER wants to assist you in evaluation and selection of suitable products. We urge you to take advantage of this service. This information sheet and **TOWER's** assistance, however, are not a substitute for your own testing and evaluation. 11084