



BEND-ALL 80

BEND-ALL 80 is a heavy duty water soluble paste developed as a lubricant for drawn over mandrel tube and pipe bending. It forms a strong barrier film with a high degree of lubricity and extreme pressure protection between the tube and the mandrel. **BEND-ALL 80** uses a solid film lubricant to reduce the coefficient of friction and improve lubricant film strength. It is safe for use on all metals. **BEND-ALL 80** was developed for use on the most difficult bending operations. It can replace straight chlorinated paraffin honey oils, and "home brews" of two or three products on tough 1 D bends. **BEND-ALL 80** has been very successful on 409 SS large diameter truck and tractor exhaust tubing. It has also been very successful at dilutions with water up to 3:1 in deep drawing stainless steel.

USAGE

BEND-ALL 80 is typically used neat for draw bending and end forming operations. It can be hand applied by brush or swab, or pumped through the mandrel. It will not harden in the mandrel or in the drum. **BEND-ALL 80** can be pumped directly out of the drum and does not require a follower plate in the drum.

BEND-ALL 80 can be removed by aqueous wash using a high quality neutral pH cleaner, such as **TOWERKLENE SAF-T-22** (for immersion), or **TOWERKLENE SAF-T-24** (for spray wash) operating at 140-160° F.

Normally **BEND-ALL 80** is best if used within six months of the manufacture date. Keep the product containers sealed when not in use.

PHYSICAL CHARACTERISTICS

Density	1.0 g/ml	8.3 lbs/gal
Appearance	Cream Colored Pourable Paste	
Odor	Faint Bland	

BENEFITS

- Contains No Hazardous Ingredients
- Improves Tool Life
- Will Not Slump Off Mandrel Under Heat
- Use on Large Diameter Tubing
- Use For The Most Difficult Bending Operations
- Does Not Harden Like Pigmented Lubricants
- Is 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. 13142