



**980
Series**

IRMCO GEL ® 980 301

The 980 Series IRMCO GEL ® products are designed for tube bending applications where it is critical that the lubricant remains on the surface where it is applied.

IRMCO 980 301 is a mandrel tube bending gel lubricant with consistency between NLGI 0 and 00. Light amber in color and clear. For use on carbon and some stainless steels. Do not dilute. Higher performance version of 980 000.

Former Designation: 980 301

OPERATIONS						
	Hydroforming	Grinding	Ironing	Spinning	Tube Bending	
Punching / Piercing						
Roll Forming						
Bending	✓					
Blanking						
Cutting						
Extruding						
Forming						

METALS						
	Carbide Tooling	Galvannealed	Galvanized	High Strength Steel	Stainless Steel	Steel
Brass / Copper						
Aluminized	*	*	x	✓	✓	
Aluminum	*					

APPROVED IN						
	Australia	Korea	Japan	Europe	Mexico	Canada
USA	✓	✓	✓	✓	✓	✓

✓ : Recommended use

* : Alternative use

x : Not Recommended

Blank values indicate that this information is not currently available. Check with IRMCO for more details.

PRODUCT PROPERTIES

Appearance:	Clear to slight haze, Light to dark amber	<i>Tendency</i>	<i>Stability</i>
Density:	8.097 lb/gal 60.57 lb/ft ³ 971.028 kg/m ³ 0.971 kg/L	Foam (ml):	
Viscosity (40 °C)	-- -- -- --	pH:	8.06
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 Ball Valve assembly		
Coverage:	7,600 - 11,000 ft ² /gal 180 - 280 m ² /l 400 - 600 mg/ft ² 4.5 - 6.5 g/m ²		
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 950-000 Clean-A-Tank or suitable rust inhibiting, water based cleaner.		
Disposal:	See SDS. Follow local, state and federal disposal regulations.		
Press Grease:	For optimum results use "Water Resistant Marine Grease" available from www.chemtool.com (815-459-1250).		
Special precautions:	See SDS. This product is not compatible with extreme acid or extreme base. 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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