



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

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

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

**KEY**  
✓ : 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

<b>Appearance:</b>	Clear to slight haze, Light to dark amber	<u>Tendency</u>	<u>Stability</u>
<b>Density:</b>	8.097 lb/gal    60.57 lb/ft3    971.028 kg/m3 0.971 kg/L	<b>Foam (ml):</b>	
<b>Viscosity (40 °C)</b>	--                      --                      --                      --	<b>pH:</b>	8.06
<b>Residue:</b>	Viscous film requiring proper removal		
<b>Flash point:</b>	None.		
<b>Container Storage:</b>	Indoor suggested. Product will freeze at 32° F (0° C).		
<b>Application Equipment:</b>	IRMCO GEL Ball Valve assembly		
<b>Coverage:</b>	7,600 - 11,000 ft2/gal    180 - 280 m2/l    400 - 600 mg/ft2    4.5 - 6.5 g/m2		
<b>Dilution:</b>	Do not dilute. Use neat product.		
<b>Parts cleaning:</b>	Plain water rinse and/or mild alkaline cleaner 110° F (43.3° C).		
<b>Tooling clean-up:</b>	IRMCO 819-000, IRMCO 950-000 Clean-A-Tank or suitable rust inhibiting, water based cleaner.		
<b>Disposal:</b>	See SDS. Follow local, state and federal disposal regulations.		
<b>Press Grease:</b>	For optimum results use "Water Resistant Marine Grease" available from <a href="http://www.chemtool.com">www.chemtool.com</a> (815-459-1250).		
<b>Special precautions:</b>	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 Devco Coatings Devran 250.		
<b>GUARANTEE:</b>	Should you have a problem with any IRMCO item, notify your IRMCO representative for a replacement, credit or refund.		

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