



BEND-ALL 004 TUBE BENDING GEL

BEND-ALL 004 (formerly LS-R-433) is a synthetic gel formulated as a lubricant for draw bending 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** was developed for bending and end-forming automotive exhaust tubing. It is recommended for steel, stainless steel, and aluminized tubing. For bending aluminum mix one part of petroleum oil based drawing compound 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 up to 3 to 1 with water. It can be applied through automatic mandrel rod lubrication systems capable of pumping higher viscosity fluids or greases. **BEND-ALL 004** is easy to clean in a mild 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 Easily in Low Temperature Water Base 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. 08095