



## **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.

### **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 mandrel rod lubricators that are capable of pumping light grease.

**BEND-ALL 80** can be removed by aqueous wash using a high quality alkaline cleaner, such as **TOWERKLENE 40-A**, operating at 120 - 140° F.

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

### **PHYSICAL CHARACTERISTICS**

Appearance	Cream Colored Pourable Paste
Odor	Faint Bland

### **BENEFITS**

- **Contains No Hazardous Ingredients**
- **Improves Tool Life**
- **Will Not Run Off Mandrel or Out of Tube**
- **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.

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