

HEAVY-DUTY SYNTHETIC STAMPING, DRAWING AND BROACHING CONCENTRATE FOR NON- FERROUS METALS

This formulation contains a combination of three EP products, which provide outstanding performance in heavy-duty stamping, drawing and broaching applications. Depending upon the severity of the operation, a typical dilution rate is 5 – 20% in water.

<u>COMPOUND</u>	<u>Wt %</u>
Cola®Lube 3404 CI	5.0
Cola®Lube 3406 CI	10.0
Cola®Lube 3407 CI	10.0
Triethanolamine (99%)	5.0
Water	<u>70.0</u>
Total	100.0

PROCEDURE:

Add ingredients in order listed making sure each is clearly dissolved before adding next ingredient.

PROPERTIES:

Appearance	Clear liquid
pH	9.0
Surface Tension (dynes/cm)	32
Cast Iron Block Corrosion Test	Pass
Falex (Direct Scale)	2750 lbs/ 57 in-lbs

USE DILUTION:

Moderate Stamping	5 – 10% in water
Heavy Stamping	8 – 10% in water

Formula 025

Last Modified 07/27/2006

WARRANTY

Colonial Chemical guarantees that its products meet published specifications. No other warranties or guarantees are expressed or implied because the use of this material is beyond the control of Colonial Chemical.