



INDUSTRIAL
LUBRICANTS &
SERVICES LIMITED

Technical Data sheet

ILS DRAWFORM TDN81

Chlorinated High EP Neat Forming Oil

Description

ILS DRAWFORM TDN81 is a viscous neat oil blended from solvent refined mineral oil with highly chlorinated, EP and fatty additives.

Typical Applications

ILS DRAWFORM TDN81 is recommended for the following:

- Tube drawing and extruding of stainless steel and high nickel alloys.
- Cold-forming of “hard to handle” materials such as stainless steels and nickel/chrome alloys.
- Deep drawing of difficult steels such as high nickel/chromium alloys, titanium alloys and nimonics, and also suitable for aluminium alloys.
- May also be used as an EP additive booster for neat cutting oils.

Advantages

***When used in tube drawing, provides:**

- Maximum reduction per pass
- High internal and external finish due to high welding resistance
- Close wall tolerances
- Low wear on mandrel and dies
- Reduction in frictional wear

***When used on deep drawing, provides:**

- Freedom from scoring due to high welding resistance
- Reduction of scrap
- Ease of application
- Ease of removal
- Better surface finish

***When used in cold heading, provides:**

- Excellent EP properties
- Improved die life
- Reduction in temperature
- Reduced pick-up and scoring
- Good surface finish due to high welding resistance

***Easily degreased in either solvent vapour or alkaline bath.**

Typical Properties

Parameter	Test Method	Specification
Appearance	Visual	Clear, pale brown fluid
Density @ 15 °C	ASTM D1298	1.154
Flash Point, COC	ASTM D92	>220°C
Kinematic Viscosity @ 40°C	ASTN D445	105 cSt

Note: Data is typical and does not constitute a specification

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