



TDS-KS COMPOUND

RichardsApex TDS-KS CPD is a water soluble paste form product formulated for drawing both ferrous and nonferrous metals. This product's combination of saponifiable fats and oils, fortified with mild extreme pressure additives, afford excellent lubricity.

BENEFITS:

- **Forms extremely stable emulsion**
 - **High versatility for multiple metals and applications**
 - **Excellent lubricity properties**
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RECOMMENDED USES:

STEEL TUBE DRAWING

TDS-KS is recommended to be used over a phosphate surface for best results.

When using **TDS-KS** as a dry film lubricant use at 1 part of **TDS-KS** with 3 to 5 parts of water. For dip application, maintain the emulsion at a temperature of approximately 135°F (57°C) for faster drying.

DRAWING COPPER & BRASS TUBING

Mix 1 part of **TDS-KS** with 8 parts of water. Apply the emulsion by pumping. For dip tank application, use a leaner dilution.

STEEL, BRASS AND COPPER SHEET STOCK

Mix 1 part of **TDS-KS** with 4 parts of water. For light draws of thin gauge metal for heat exchangers, mix 1 part of **TDS-KS** with 15 parts of water. The concentration of the **TDS-KS** can be varied according to the severity of the drawing operation.

PRODUCT DATA

RICHARDSAPEX

INC

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TUBE ROLLING

For rolling tube ends into tube sheets.

APPLICATION:

May be accomplished by dipping the expander itself into the **TDS-KS** (for small size expanders) or may be applied directly to the inside of the tube ends by hand or by means of a small grease gun.

REMOVAL

Any excess of **TDS-KS** is easily removed by hand wiping or the residue will be completely removed during boil-out operations before the boiler is placed in service.

ADVANTAGE

Equally effective for rolling condenser tubes, boiler tubes and heavy wall cracking-still tubes in refining equipment.

TYPICAL SPECIFICATIONS

Specific Gravity - 0.96 kg/l (8.0 lbs / gal)

Active Lubricant Content - 54% Minimum