

## **DEEP DRAWING & STAMPING COMPOUNDS**

### **FERROUS METALS**

The proper choice of lubrication for the forming of metals has become a highly specialized complicated, yet economically important decision. In order to achieve desired performance, available methods of application, protection for expensive tools, temperature limitations, compatibility with a variety of metals, finish requirements, and finally the lubricant's relation to subsequent finishing operations must be carefully considered. For a lubricant or coating to meet these requirements, there is no substitute for experience. **Richards-Apex** has more than 100 years experience in custom formulating metalworking lubricants.

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#### **Water Soluble Materials**

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| <b>D-644</b>    | Soft paste-form compound containing fatty lubricity additives and bactericide. Residual film has good weld-through properties and is easily cleaned.  |
| <b>LAT-XX2M</b> | Chlorine and sulfur free oil base compound enhanced with fatty lubricity agents. Excellent lubricant for deep drawing and forming light gauge stock.  |
| <b>LW-31SGE</b> | Viscous non-chlorinated, highly pigmented compound with excellent metal wetting for perforating and deep drawing heavy gauge stock.   |
| <b>TDS-10</b>   | A soft, paste-form product formulated for roller coating applications. Lubricity properties improve when lubricant film is dried prior to forming. Contains polar lubricity agents, antioxidants and biocide. |
| <b>S-156</b>    | Viscous soluble oil fortified with extreme pressure lubricity additives and corrosion inhibitor. Excellent for perforating and forming heavy stock.   |

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**Oil Form Materials**

- LW-31D** All-purpose, paste-form compound for perforating, blanking and drawing. Fortified with pigmented, fatty additives. May be thinned with a light spindle oil. Replaced white-lead as lubricant in heavy blanking operations.
- WDO-401TTW** Light viscosity oil containing E. P. and fatty additives, and anti-oxidants. Excellent for recirculating to tooling.
- SCO-13AR** Moderately viscous perforating oil with very effective anti-rust protection, even when sheet stock is stacked in storage.
- EPM** Moderately viscous oil fortified with extreme pressure additives for piercing heavy plate stock.

**STAINLESS & NICKEL ALLOY (Water Soluble and Oil Form)**

- VAS-25** Soft paste-form, water soluble compound used in "neat" form or thinned to 5 parts water to 1 part Compound for deep drawing stainless steel. Residual Film easily-cleaned from stock.
- NAL-40** A light viscosity, oil-form product formulated with fatty lubricity agents. May be used on all metals.
- 201** Viscous oil fortified with E. P. Additives to be used "as received" or blended with other oils for a variety of stamping and forming operations.
- 244** Light viscosity oil combined with E. P. Additives for perforating and minor forming applications.