



DEEP DRAWING & STAMPING FERROUS METALS

The proper choice of lubrication for the forming of metals has become a highly specialized complicated, yet economically important decision. 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 the requirements, there is no substitute for experience RichardsApex has more than 100 years of experience in custom formulating metalworking lubricants.

Recommended Uses

Water Soluble Materials

D644 Soft paste-form compound containing fatty lubricity additives and bactericide. Residual film has good weld-through properties and is easily cleaned.

DS17 Viscous liquid material combining lubricity additives and corrosion inhibitor. Excellent lubricant for deep drawing light gauge stock and for metal spinning.

LW31SGE Viscous non-chlorinated, highly pigmented compound with excellent metal wetting for perforating and deep drawing heavy gauge stock.

DS81 Synthetic compound fortified with E. P. Additives, polymers, inhibitors and bactericide.

TDS10 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.

S156 Viscous soluble oil fortified with extreme pressure lubricity additives and corrosion inhibitor. Excellent for perforating and forming heavy stock.



Oil Form Materials

LW31D 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.

WDO401TTW Light viscosity oil containing E. P. and fatty additives, and anti-oxidants. Excellent for recirculating to tooling.

SCO13AR 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 & Oils)

VAS25 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.

DS61 Soft paste-form compound containing a pigmented additive. To be used "as received" or thinned with water for deep drawing and blanking.

NAL40 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.

TDEPHSBL A soft pigmented oil containing E. P. Additives recommended for use "as received" for the most severe forming applications.