

## PRODUCT DATA



www.RichardsApex.com

Phone: 215-487-1100

## TDS-KS COMPOUND

**RichardsApex TDS-KS** - 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

### 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.

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**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
Active Lubricant Content	54% Minimum