

DRAWLUB S 27/1

FORMING EMULSION

DRAWLUB S 27/1 is a water miscible coolant which is free from mineral oil and is mainly used for non-cutting metal forming operations.

DRAWLUB S 27/1 is used for punching and deep drawing operations on steel and non-ferrous materials with different material strengths. The emulsion is also suitable as coolant for sheet forming operations when the sheets have been pre-lubricated with **DRAWLUB TDV**-oils. **DRAWLUB S 27/1** can be used as supplied but also diluted with water. Usage concentration depends on the forming operation and has to be determined by preliminary trials.

DRAWLUB S 27/1 is free from chlorine, PCB and PCT.

Residual films of **DRAWLUB S 27/1** can be easily removed by using conventional degreasing media without leaving residues.

Emulsion Preparation

It is recommended to prepare a base emulsion of **DRAWLUB S 27/1** due to the pasty character of the concentrate. Add product with good agitation to half of the water quantity required - use warm water if possible. Then, dilute emulsion with the necessary quantity of water to obtain the required concentration.

Physical Data:

Concentrate

Appearance	white, pasty	
Density 20°C	approx. 0.95 g/cm ³	DIN 51 757

Emulsion

pH (10 % in demin. water)	9.2 - 9.4	
Conductivity 10 %	430	µS

Handling and Storage

DRAWLUB S 27/1 should not be exposed to extremes of temperature. The product should have ambient temperature before use. Emulsions of **DRAWLUB S 27/1** are prepared by adding the product to the water with good agitation.

Only valid in combination with corresponding EC-Material Safety Data Sheet.

Warranty

The information given here is considered to be correct and is offered for your consideration, investigation and verification. No warranties are expressed or implied since the use of our products is beyond our control. Statements concerning the use of PETROFER-products are not to be construed as recommending the infringement of any patent.