Iloform PS 364

Synthetic Forming Fluid

Description

Iloform™ PS 364 is a chlorine free, water soluble forming fluid designed to replace traditional chlorinated oils in heavy duty drawing applications. Its unique chemistry offers extreme pressure lubrication to extend die life and reduce blemished or defective parts. In addition, the versatility of Iloform PS 364 allows it to be used at a wide range of concentrations, making the product suitable for a multitude of forming operations.

Application

Iloform PS 364 is designed for medium to heavy duty forming on ferrous alloys. It can be used at 5% to 10% for light duty forming applications. Higher concentrations, up to 100%, can be used for more aggressive applications where additional lubricity is required.

	Steel		Stainless Steel		Aluminum		Yellow metal		Coated Metal	
Metal Thickness	< 0.075"	> 0.075"	< 0.075"	> 0.075"	< 0.075"	> 0.075"	< 0.075"	> 0.075"	< 0.075"	> 0.075"
Drawing	√	√	√	√						
Deep Drawing	√	√	√	√						
Stamping/Blanking	√	√	√	√						
Fine Blanking										
Punching/Piercing	√	√	√	√						
Bending	√	√	√	√						
Coining	√	√	√	√						
Ironing										
Stretching	√	√	√	√						

√ = recommended

Advantages

- Formulated with extreme pressure additives to extend die life and minimize blemished or defective parts.
- Variation of concentration allows for wide range of forming applications.
- Excellent in-process corrosion protection.
- Chlorine free to help meet environmental goals and improve operator acceptance.

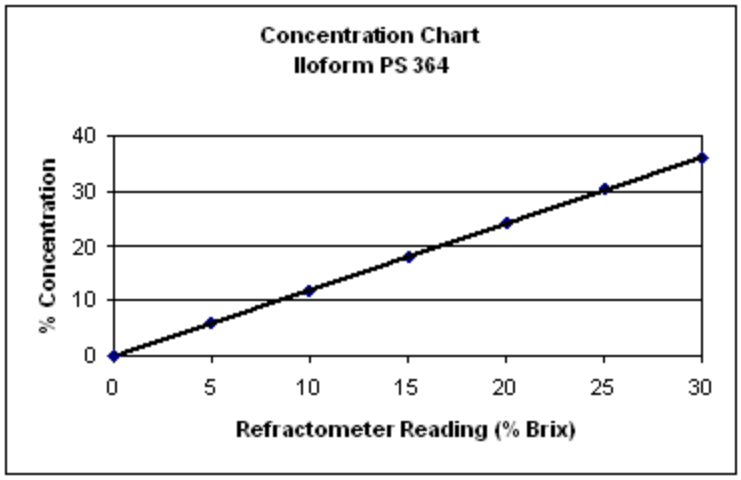
Typical Physical Characteristics

	Unit	Test Method	Value
Appearance of Concentrate	-	CN-TM-007	Slightly Hazy Amber Liquid
Appearance of Dilution (5%, 125 ppm water)	-	CN-TM-028	Clear to Slightly Hazy Liquid
pH of dilution @ 5%	-	CN-TM-069	8.9
Specific Gravity @ 60ºF	-	CN-TM-086	1.05
Bulk Density	lbs/gal	CN-TM-086	8.8

Ester	Sulphur	Phosphorous	Chlorine	Other
✓✓✓	✓	✓✓✓		

Concentration Control

The concentration of the Iloform PS 364 can be easily measured with an Atago Model N1 refractometer. The graph is a linear regression of actual readings from laboratory tests on laboratory prepared samples. It is important to realize that refractometer readings are dependent upon the type of refractometer and water used.



User Advice

Iloform PS 364 can be cleaned using mild alkaline cleaners. In many instances, warm water is sufficient.

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