



Product Data

Iloform PS 700

Soluble Forming Fluid

Description

Castrol Iloform™ PS 700 is a specially formulated, water soluble, wax emulsion lubricant suitable for use in a variety of drawing operations. It can be diluted to achieve any desired film thickness and adheres to metals through multiple draws, minimizing the need to re-apply. Iloform PS 700 contains a special wax system developed with properties not found in other lubricants; the waxes have a unique attraction to metal surfaces due to a high degree of polarity possessed by the individual waxes. This allows up to five consecutive reductions with only one application.

Applications

Iloform PS 700 is designed for light to medium duty forming applications on ferrous and aluminum alloys. It can be used at 20% to 40% for light duty forming applications and 40% to neat for applications needing additional lubricity. Iloform PS 700 is also compatible on galvanized materials. It is not recommended for yellow metals.

	Steel		Stainless Steel		Aluminum		Yellow metal		Coated Metal	
	< 0.075"	> 0.075"	< 0.075"	> 0.075"	< 0.075"	> 0.075"	< 0.075"	> 0.075"	< 0.075"	> 0.075"
<i>Metal Thickness</i>	< 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					C	C				
Punching/Piercing	C				√	C			C	
Bending	√		√		√	√			√	
Coining	√		√		√	√			√	
Ironing					√	√				
Stretching	√		√		√	√			√	

√ - Recommended

C = Consult Castrol Application Engineering

Advantages

- Versatile - for a wide range of applications.
- Provides good in-process corrosion protection to protect the parts.
- Minimizes oily residues and keeps work areas clean.
- Contains no nitrites, heavy metals, chlorine, phenols, or phosphates to meet health and safety requirements.

Typical Technical Characteristics

	Unit	Test Method	Value
Appearance of Concentrate	-	CN-TM-007	White to Off-white Paste
pH	-	CN-TM-069	7.5 – 8.3
Specific Gravity @ 60°F	-	CN-TM-086	0.99 (Typical)
Bulk Density	lbs/gal	CN-TM-086	8.3 (Typical)

Ester	Sulfur	Phosphorous	Chlorine	Other
				✓✓✓

User Advice

Apply Iloform PS 700 in a thin, uniform film using roll coater, sponge brush, dip, or spray. For uniform dispersion, add water slowly to concentrate while mixing. The most efficient method of application is the pre-coat system. Metal stock precoated with Iloform PS 700 may be dried immediately with a forced ambient air dryer. The remaining non-hygroscopic film is ideal for parts storage; however, parts must be dried before stacking. Safety-Draw 700 is can be removed with mild alkaline cleaners.

NOTE: Always add water slowly to concentrate with mixing. Never add concentrate to water.

Castrol Iloform PS 700
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