

## WATER EMULSIFIABLE HEAVY DUTY DRAW LUBE

### PRODUCT DESCRIPTION

**Lubridraw 3320** is heavy duty completely emulsifiable drawing oil concentrate. It is very stable in hard and soft water. Lubridraw 3320 is designed for the most severe drawing and blanking operations on cold rolled steel and stainless steel along with non-ferrous metals such as copper, brass, and aluminum.

In heavier dilutions with water, Lubridraw 3320 is suitable for the most severe blanking, forming, stamping, and piercing operations on cold rolled, hot rolled, and stainless steels particularly in high speed eyelet machine stamping operations. It may be flooded, sprayed, brushed, or roll-coated on the blanks or coil stock entering the press. Typically Lubridraw 3320 is run between 5-15% depending on the severity of the draw. Lubridraw 3320 emulsifies easily in tank side proportioning units and will not leave a heavy waxy buildup on the dies or your parts. Lubridraw 3320 may be diluted with any lower viscosity diluent oil such as hydraulic oil, spindle oil, EDM oil, or solvent for less severe drawing or stamping requirements.

### FEATURED BENEFITS

- Easily washed off for post machining applications.
- High level of lubricity makes it ideal for a multi-purpose work horse in one facility.
- Low foaming and easily emulsifiable for proportioning units.

### PRODUCT APPLICATION



### COMPATIBLE METALS

Cold Rolled Steel  
Hot Rolled Steel  
Stainless Steel  
Copper  
Brass  
Aluminum

## PRODUCT SPECIFICATIONS

Fluid Type	Drawing Oil
Appearance	Amber
Odor	Mild petroleum
Specific Gravity, 60°F (15.6°C)	1.14
Weight, lb/gal., 60°F (15.6°C)	9.49
pH (10% dilution)	9.5
Flash Point (COC)	335°F (168.3°C)

## PRODUCT APPLICATION / USAGE

Lubridraw 3320 may be applied to the work by any conventional method (by dip, spray, roll coater, or proportioning unit). Blanks or coils may be pre-coated with Lubridraw 3320 and dried with forced warm air without losing its film strength or lubricity.

## MIXING DATA

For use, Lubridraw 3320 may be used straight or diluted with water. Always add Lubridraw 3320 to water to avoid inverting the solution.

Concentration	3.0%	5.0%	8.0%	10.0%	12.0%	15.0%	20.0%
Refractometer Reading	3.0	5.0	8.0	10.0	12.0	15.0	20.0

## AVAILABILITY

275 Gallon Tote  
55 Gallon Drum  
Bulk Quantity

6005900000-CT2021  
6005900000-CT3B38

For health and safety guidance, please refer to the Chemtool SDS (Safety Data Sheets).



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