CT 3300 FE

WATER EMULSION DRAW COMPOUND AND NONCHLORINATED TUBE BENDING LUBRICANT

PRODUCT DESCRIPTION

CT 3300 FE is suggested as a heavy duty, deep drawing and stamping lubricant for all types of metals where the operation will not allow a chlorinated product. It is particularly suggested as a brass, copper, and aluminum tube drawing lubricant and as a drawing/stamping lubricant for all ferrous metals, including galvanized and stainless. Applied as received, CT 3300 FE will permit several operations on the same part without reapplication, provided the parts are not annealed or cleaned between operations. Its high polar attraction to metal substrates guarantees thorough wetting out over the entire surface of the blank workpiece, yet it will clean easily and can be painted or plated without concern for lack of adhesion.

FEATURED BENEFITS

- Easily washed off for post-machining applications
- High level of lubricity makes CT 3300 FE ideal for a multi-purpose work horse in one facility
- Low foaming and easily emulsifiable for proportioning units

APPLICATION

COMPATIBLE METALS

Ferrous Metals
Galvanized Steel
Stainless Steel
Copper
Brass
Aluminum

CT 3300 FE
TECHNICAL DATA

TYPICAL PROPERTIES

Fluid Type	Synthetic
Appearance	Tan liquid
Odor	Mild
Texture	Heavy oil paste
Weight, 60°F (15.6°C)	8.55 lbs/gal.
Viscosity, Brookfield, 75°F (24°C)	1,400 cps

PRODUCT APPLICATION / USAGE

For Drawing / Stamping
CT 3300 FE may be applied to the work by any conventional method, including dip, flooding, spray, roll coater, or by hand with a brush or sponge. Blanks or coils may be pre-coated with CT 3300 FE and dried with forced warm air without losing any film strength or lubricity. It can be used straight (neat) or cut back with water for less demanding applications.

For Tube Bending
CT 3300 FE may be applied neat by swabbing or brushing onto the tube and/or the mandrel. For long pieces, it may be diluted 1:1 with water and squirted inside the tube. Many tube benders, however, apply it directly through the mandrel.

MIXING DATA

CT 3300 FE may be used straight or diluted with water. In general, we suggest reducing it in proportions of one part CT 3300 FE to one part water. The most satsfactory procedure for reducing CT 3300 FE is to add the water to the CT 3300 FE a little at a time while minimizing entrainment of air bubbles until the mixture becomes quite thin. If air is whipped into product, it might take considerable time for the bubbles to break, therefore interfereing with the final film.

Concentration	20%	15%	12%	10%	8%	5%	3%
Refractometer Reading	20.0	14.4	11.0	9.0	6.5	4.0	2.4

PRODUCT CODE

60001A0000

HEALTH AND SAFETY

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

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801 W Rockton Road, Rockton, IL 61072 | Phone: 815-957-4140 | Fax: 815-624-0292
www.chemtool.com