

LUBRIDRAW 3320

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

▶ APPROVALS

- Compliant for California SCAQMD Rule 1144

APPLICATION



COMPATIBLE METALS

Cold Rolled Steel
Hot Rolled Steel
Stainless Steel
Copper
Brass
Aluminum



TYPICAL PROPERTIES

Fluid Type	Drawing oil
Appearance	Amber
Odor	Mild petroleum
Specific Gravity, 60°F (15.6°C)	1.14
Weight, 60°F (15.6°C)	9.49 lbs/gal.
pH (10% dilution)	9.5
Flash Point (COC)	335°F (168.3°C)
VOC, ASTM E 1868	69.7 grams/liter

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

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

PRODUCT CODE

6005900000

HEALTH AND SAFETY

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