

LUBRIDRAW 3305-WX

WATER EMULSIFIABLE MULTI PURPOSE DRAW LUBE

▶ PRODUCT DESCRIPTION

Lubridraw 3305-WX is medium to heavy duty completely emulsifiable drawing oil concentrate. It is very stable in hard and soft water. Lubridraw 3305-WX is designed for severe drawing and blanking operations on cold rolled steel and stainless steel along with non-ferrous metals such as copper, brass, and aluminum. Its unique sulfonate free chemistry provides bacteria resistant fluid that will not go rancid.

In heavier dilutions with water, Lubridraw 3305-WX is suitable for a variety of blanking, forming, stamping, and piercing operations on cold rolled, hot rolled, and stainless steels, particularly in high speed eyelet machine stamping operations. The product may be flooded, sprayed, brushed, or rollcoated on the blanks or coil stock entering the press. Typically, Lubridraw 3305-WX is run between 5-15% depending on the severity of the draw. Lubridraw 3305-WX emulsifies easily in tank side proportioning units and will not leave a heavy waxy buildup on the dies or parts.

▶ FEATURED BENEFITS

- Easily washed off for post machining applications
- Sulfonate free chemistry yields rancid free residues
- High level of lubricity makes the product ideal for a multi-purpose work horse in one facility
- Low foaming and easily emulsifiable for proportioning units
- Superior corrosion protection

▶ APPROVALS

- Super-compliant for California SCAQMD Rule 1144

APPLICATION



COMPATIBLE METALS

Cast Iron
Carbon Steel
Tool Steel
Stainless Steel
Aluminum
Titanium
Inconel
Bronze
Copper
Brass

MACHINING CAPABILITIES

Medium to Heavy Duty Drawing
and Stamping

ALL METAL SAFE

Yes

REFRACT INDEX

1.25



LUBRIDRAW 3305-WX

TECHNICAL DATA



TYPICAL PROPERTIES

Fluid Type	Drawing oil
Appearance	Opaque emulsion
Odor	Mild
Specific Gravity, 60°F (15.6°C)	1.01
Weight, 60°F (15.6°C)	8.40 lbs/gal.
pH (10% dilution)	9.5
Flash Point (COC)	335°F (168.3°C)
VOC, ASTM E 1868	48.7 grams/liter

PRODUCT APPLICATION / USAGE

Lubridraw 3305-WX 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 3305-WX and dried with forced warm air without losing film strength or lubricity.

MIXING DATA

Lubridraw 3305-WX may be used straight or diluted with water. Always add product concentrate to the water, not water to product concentrate. Product concentration can easily be monitored by refractometer.

Concentration	3.0%	5.0%	8.0%	10.0%	12.0%	15.0%	20.0%
Refractometer Reading	2.4	4.0	7.4	8.0	9.6	12.0	16.0

PRODUCT CODE

6027000000

HEALTH AND SAFETY

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