

# PRODUCT DATA SHEET



## WIRE DRAWING OILS

### PAL DRAW -ST,ST-2, EP

These products are non-staining, high performance mineral oil based lubricant, having good cooling abilities. They are specially developed for high speed and deep drawing application of metals. They provide optimum film strength, lubricity and good metal wetting characteristics.

The products meet the highest demands of resistance to heat and stress generated during the process of wire drawing operation, thereby helps in smooth drawing, provides high degree of finish and extends the drawing equipment's life.

**PAL DRAW - ST** is, blended with fatty oil to improve wetting characteristics. It is stable, non-staining, mineral oil based lubricant, recommended for Aluminium wire drawing operation.

**PAL DRAW ST - 2** is blended by using high performance base oils and fortified with a combination of Anti wear and Extreme Pressure additives to sustain higher loads during the drawing operations. Besides having the good cooling characteristics, the oil also provides a stable oil film between the metal surfaces and prevents the metals from breakages, rupture etc.

**PAL DRAW - EP** is chlorinated extreme pressure (EP) type, blended with fatty oils and free sulphur making it ideally suited for most severe drawing conditions. It offers high degree of finish of the tube bar both internally and externally. It is widely used for deep drawing and cold rolling of Stainless Steel tubes.

**Not recommended for cuprous metals. Staining may occur on high nickel alloys.**

CHARACTERISTICS				
S. NO.	PROPERTIES	PAL DRAW		
		ST	ST-2	EP
1.	Appearance	Dark Colour liquid		
2.	Kinematic Viscosity, cSt @40°C	280-300	280-300	280-300
3.	Kinematic Viscosity, cSt @100°C	21-24	21-24	31-32
4.	Flash Point, COC,°C, min.	255	260	150
5.	Copper Strip Corrosion, @100°C, max.	1(3hr.)	1(3hr.)	4(1hr)
6.	Saponification Value	20-25	25-30	-
7.	Neutralization No. mg KOH/gm	0.40	0.20	-
8.	Four Ball weld load, kg	-	>200	-
9.	Timken OK Load, 1bs min,	-	40	-
10.	Four ball WSD @ 40kg mm max.	-	0.60	-

\* The specifications are subject to variations/ development / customization.

**PACKING:** 210L, 50L