



FS LUBRIDRAW 3472 SYNTHETIC DRAWING LUBRICANT

FS Lubridraw 3472 is a concentrated synthetic vegetable oil–based drawing and stamping fluid. It is used for medium to severe metalworking applications such as deep drawing, forming, roll forming, stamping, tube drawing, and bending of hot rolled and cold rolled steels and stainless steels.

FS Lubridraw 3472 can be diluted with water at a 10% concentration for less severe applications.

For more demanding processes, the EP package will provide excellent lubricating properties for applications normally reserved for traditional chlorinated soluble oils.

FS Lubridraw 3472 is stable over a wide range of ratios and not affected by hard water up to an initial hardness of 25 gpg (grains per gallon). It is resistant to hard-water emulsion split, which occurs even when water starts out soft but its hardness increases due to water evaporation.

Due to the vegetable oil content of the product, residual films of FS Lubridraw 3472 left on the part will wash off easily. In addition, the buildup of sticky residues in progressive stamping applications will be eliminated due to the water-soluble, oil-like film that the product leaves behind.

Features:

- Exceptional longevity — FS Lubridraw 3472 is usable longer than soluble oils because it resists rancidity.
- The non-phenolic bactericide system, with a proper maintenance schedule, gives a long-lasting fluid that keeps equipment running longer and work areas cleaner.
- Operator acceptance — FS Lubridraw 3472 is a very stable true solution that can be used in hard water. The operators and plant personnel like the pleasant odor and clean stable fluid that promotes cleaner conditions in the plant.
- FS Lubridraw 3472 is nonflammable and contains no toxic ingredients.



Features continued:

- It may be welded through without removal. Cleaning is easy even at room temperature.
- Applications may be made by spray, dip, roll coat, swab, or flooding.

Typical Specifications and Performance Data:

Appearance	Clear Amber Liquid
Viscosity SUS @ 100°F	1165
Specific Gravity	1.054
pH	8.74
Flash Point	None

Recommended Refractive Reading:

Dilution (%)	Refractometer Reading	Drops 0.5-N HCL
20	15.3	44
15	11.4	35
10	7.6	24
5	4.0	13
2	1.6	7

Product Availability:

- 5-gal. Pails
- 55-gal. Drums
- 265-gal. Mini-bulk