



Product Data

Castrol Iloform TDN 86™

Heavy Duty Drawing Oil

Description

Castrol Iloform TDN 86 is a highly chlorinated Extreme Pressure (EP) type oil with fatty oils and free sulphur making it ideally suited for most severe drawing conditions. At the drawing periphery when the surface of the tube bar is in contact with the die, there is a chemical reactivity on the metal surfaces whereby a nascent metallic chloride layer of molecular thickness is formed. This feature is important in high speed drawing of steel for extending the die life and improving the surface finish.

Application

Castrol Iloform TDN 86 is ideally suited for cold pilgering.

The high percentage of stabilized chlorine incorporated in the blend enables maximum reduction per pass, simultaneously offering a high degree of finish both internally and externally. It also ensures low wear on mandrel and dies. Iloform TDN 86 is also widely used for deep drawing and cold rolling of stainless steel tubes.

Advantages

Product Features	Operational Advantage	Customer Benefit
High amount of Chlorinated fats	Economy of use	Maximum reduction per pass
Enhanced lubricity package	High degree of internal and external finish. Reduction in frictional heat	Lesser rejection rate
Excellent EP package	Very low mandrel and die wear	Closer tolerances in improved mandrel and die life hence reduced costs.

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Characteristics

Characteristics	Typical Value
Appearance	Smooth, brown viscous liquid
S. gravity @ 15 deg c	1.35
Stability at room temp.	Okay
Stability at 70 deg c	Okay
Viscosity @ 30 deg c (Glass cup)	30
Flash point (PMCC)	> 210 deg c

Characteristics	Method	Control Value	Typical Values
APPEARANCE	BAM 300	SMOOTH	HOMOGENOUS
VISOCOSITY @ 30 deg C	GLASS TUBE	25-35	32

The above are typical figures and do not constitute a specification.

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