

## **HYDROFORM DF 3192**

### **DRY FILM LUBRICANT HYDROFORMING COMPOUND**

#### **Description**

Hydroform DF 3192 is a dry film lubricant, organic hydrocarbon based, water dispersible that forms a dry-to-touch film capable of withstanding extreme deformation and multiple processing steps. Hydroform DF 3192 provides a very thin film between the part and tool. Hydroform DF 3192 can be used in numerous drawing and stamping applications and was especially designed for tube hydroforming operations.

#### **Features & Benefits**

- Solvent-free: no fumes or fire hazard associated with vapors
- Eliminates staining and corrosion problems associated with chlorine based lubricants.
- Virtually non-toxic composition with excellent operator acceptances
- Can replace messy pastes in stretch drawing applications.
- Provides rust protective film for storage
- Suitable for ferrous and non-ferrous materials including aluminum and galvanized metals
- High film strength that reduces die marks, scoring and galling on many draws

#### **Health & Safety**

See the most recent MSDS which is available directly from Precision Fluids, your local salesman, or authorized distributor. Precision Fluids uses only raw materials not listed as carcinogenic by IRAC.

#### **Physical Data**

<b>Appearance:</b>	Liquid
<b>Color:</b>	Beige
<b>Odor:</b>	Mild, Characteristic
<b>Solubility (water):</b>	Complete
<b>pH of 1:1 Solution:</b>	8.8
<b>Specific Gravity (20°C):</b>	1.03

#### **Application**

Hydroform DF 3192 may be used neat or diluted in water for stretch draws or large items or for stamping and forming of a wide range of components, including steel bathtubs. For best results the work piece should be heated to 100°F or higher and some form of drying system is required to produce a dry film; evaporate the water. May be applied by airless spray or air assisted airless spray, roller or other convenient method. A film thickness of 0.5 millimeters is sufficient.

#### **Removal**

Cleanable from parts with alkaline cleaners.

#### **Handling & Storage**

No health or safety hazards exist when Hydroform DF 3192 is stored, used and disposed of in accordance with instructions given on the Safety Data Sheet for this product. Do not allow to freeze. If frozen, thaw and mix well to make usable. Do not store above 120°F.

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