

HYDROFORM WS 3194

INTERNAL/EXTERNAL HYDROFORMING LUBRICANT

Description

Hydroform WS 3194 is a synthetic; high film strength, water extendable lubricant concentrate, designed to perform in a variety of hydroforming processes. Hydroform WS 3194 can be used as an internal lubricant in high-pressure hydroforming. It may be used for tube bending and cut-off, and as an internal/external lubricant in some low and pressure – sequence hydroforming. Hydroform WS 3194 is highly fortified with water – soluble lubricity and EP additives thus making it capable of performing at the high pressures required in hydroforming. It provides excellent cleanability, oil rejection and stability of the fluid. Hydroform WS 3194 is highly operator friendly. This product is free of carcinogens, phenols, nitrates, chromates, sulfur or chlorines.

Features & Benefits

- Provides the hydroforming operation with long life, excellent pump life and oil rejection. Product allows consolidation of lubricants.
- Provides excellent rust protection on the part, and the machine and does not stain galvanized steel
- Does not emulsify hydroforming compounds used on outside of tube, hydraulic, gear or way oils
- Extends the life of cylinder packing and die components. Resists foaming for positive hydraulic activation.
- Designed to reject tramp oils and other contaminants thus extending life and making it easily recyclable thus drastically reduces disposal costs.

Physical Data

Appearance:	Clear, Liquid
Color:	Blue
Odor:	Mild, Characteristic
Viscosity (40°C):	125-200 cSt
pH of 5 % Solution:	8.8
Specific Gravity (20°C):	1.05

Applications & Dilutions

As an internal lubricant, a 10:1 to 20:1 dilution is suggested. For tube bending, a 1:1 to 5:1 dilution is suggested. Solutions should be delivered to internal support tooling by means of a precision metering pump and to wiper dies, if desired. For tube cut-off, a dilution of 5:1 to 10:1 can be sprayed or dipped on cross cut and severing shear blades. For low- pressure hydroforming and pressure-sequence hydroforming a dilution between 10: and 20:1 is suggested.

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.

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