

# Twin Draw 1599

## HEAVY-DUTY TUBE DRAWING LUBRICANT

### TWIN DRAW 1599

Twin Draw 1599 is a water-based and heavy-duty synthetic lubricant engineered for operations such as piercing, blanking, perforating, forming, drawing and stamping of carbon steel, galvanized steel, stainless steel, brass and aluminum. The high film strength reduces friction and heat, and provides anti-wear protection.

Twin Draw 1599 is non-staining and non-corrosive. When left on parts, the residual lubricant can be welded through without excessive smoking or interference with the integrity of the weld. The residual film also provides excellent protection from rust and oxidation.

### OPERATIONAL DATA

Light Forming, Stamping & Blanking	5 - 15%
Moderate Drawing, Perforating & Piercing	15 - 30%
Heavy Forming, Drawing & Stamping	30 - 100%

### TYPICAL PHYSICAL PROPERTIES

Appearance	Transparent, Amber Liquid
Bulk Density	8.89
pH, Concentrate	8.2 - 8.4
Flash Point	None
Viscosity, cPs, 40 C	140 - 160
Viscosity, SUS, 104 F	695

### FEATURES AND BENEFITS

- Totally Synthetic, No Mineral Oils
- Non-Chlorinated
- Sulfur-Free
- Hard Water Tolerant
- Reduces Burrs
- Environmentally Sound Formulation
- Cleans with Water or Mild Detergent
- Clean and Low-Foaming
- Weld Through Residual Film
- True Solution, Will Not Bind Filters
- Superior Wetting and Detergency
- Eliminates Many Disposal Problems
- Inhibits Corrosion and Oxidation
- Provides Excellent Tool Life
- Cool Operating Temperatures
- Very Effective Combination of Extreme Pressure Additives

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