



Product Data

Iloform PS 326 Synthetic Forming Fluid

Description

Iloform™ PS 326 is a chlorine and sulfur free, water soluble forming fluid designed to replace traditional chlorinated oils in medium to heavy duty drawing applications. Its unique chemistry offers extreme pressure lubrication to extend die life and reduce blemished or defective parts. In addition, the versatility of Iloform PS 326 allows it to be used at a wide range of concentrations, making the product suitable for a multitude of forming operations.

Applications

Iloform PS 326 is designed for medium to heavy duty forming on ferrous alloys. It can be used at 5% to 10% for less aggressive forming applications and 25% to 50% for applications needing higher levels of lubricity. Please consult Castrol prior to use on aluminum.

	Steel		Stainless Steel		Aluminum		Yellow metal		Coated Metal	
<i>Metal Thickness</i>	< 0.075"	> 0.075"	< 0.075"	> 0.075"	< 0.075"	> 0.075"	< 0.075"	> 0.075"	< 0.075"	> 0.075"
Drawing	√	√	√		C				√	√
Deep Drawing	√	√	√		C				√	√
Stamping/Blanking	√	√	√	√	C				√	√
Fine Blanking										
Punching/Piercing	√		√		C				√	√
Bending	√	√	√		C				√	√
Coining	√	√	√		C				√	√
Ironing										
Stretching	√	√	√		C				√	

√ = recommended

C = consult application engineer/product management

Advantages

- Formulated with extreme pressure additives to extend die life and minimize blemished or defective parts.
- Variation of concentration allows for wide range of forming applications.
- Excellent in-process corrosion protection.
- Chlorine and sulfur free to help meet environmental goals and improve operator acceptance.

Typical Technical Characteristics

	Unit	Test Method	Value
Appearance of Concentrate	-	CN-TM-007	Clear to Slightly Hazy Yellow Liquid
Appearance of Dilution (10%, 125 ppm water)	-	CN-TM-007	Clear to Slightly Hazy Liquid
pH of dilution @ 10%	-	CN-TM-069	9.2
Specific Gravity @ 60°F	-	CN-TM-086	1.05
Bulk Density	lbs/gal	CN-TM-086	8.8

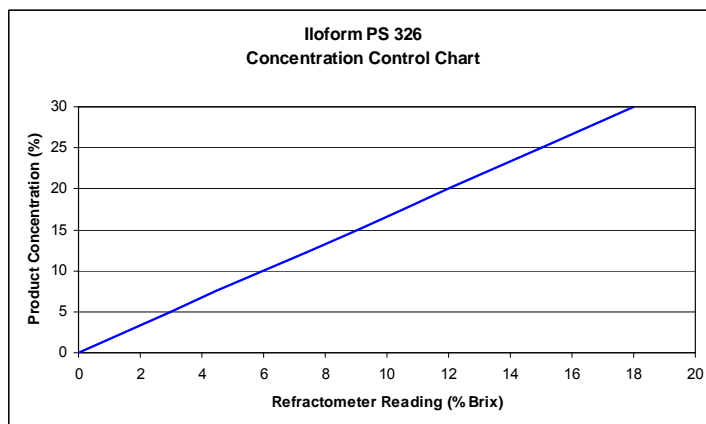
Ester	Sulphur	Phosphorous	Chlorine	Other
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User Advice

Iloform PS 326 can be cleaned using mild alkaline cleaners. In many instances, warm water is sufficient.

Concentration Control

The concentration of the Iloform PS 326 can be easily measured with an Atago Model N1 refractometer. The graph is a linear regression of actual readings from laboratory tests on laboratory prepared samples. It is important to realize that refractometer readings are dependent upon the type of refractometer and water used. Atago Model N1 refractometers are available through Castrol Industrial North America Inc



Castrol Iloform PS 326
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