

## Castrol Iloform FN 450

Neat forming oil

### Description

Castrol Iloform™ FN 450 is a medium viscosity, chlorine and sulphur containing forming oil designed specifically for cold heading operations on high alloy steels. It is a blend of high performance extreme pressure and anti wear additives, in a fully solvent refined paraffinic mineral oil.

Iloform FN 450 is free of heavy metals such as barium.

### Application

Iloform FN 450 is specially formulated for use in high severity operations in high speed, progressive cold heading machines. It provides outstanding performance in the production of high alloy steel fasteners and in stainless steel bolt and nut forming.

Not suitable for use with yellow metals.

### Advantages

- Formulated on solvent refined mineral oil. Does not contain hazardous aromatic constituents, or heavy metals such as Barium.
- Contains high performance extreme pressure additives. Maximises die life and provides excellent surface finish. Minimises costs associated with die repolishing.
- Excellent detergency. Removes metallic fines and particles from dies, eliminating defects associated with particulates. Improved surface finish, reducing scrap and rework costs.
- Excellent wetting characteristics. Reduces drag out rate, hence reduces product consumption. Easily filtered in service, to extend service life.
- Excellent oxidation and thermal stability, extending service life.
- Low misting and fuming. Excellent operator acceptance.

## Typical Characteristics

	Test Method	Unit	Value
Appearance	Visual	Visual	Clear brown fluid
Viscosity @ 40°C	DIN 51562	mm <sup>2</sup> /s	105
Viscosity @ 100°F	ASTM D446	[SUS]	
Density @ 15°C	DIN 51757 ASTM D 1298	kg/m <sup>3</sup>	940
Density @ 60°F	Calculated	lbs/gal	7.844
Flashpoint	ISO 2592	°C	> 170
	ASTM D92	°F	> 338
Pour Point	ISO 3016	°C	
	ASTM D97	°F	
Copper corrosion	DIN51 759 T1/ASTM D130	3 h at 100°C	3

Ester	Sulphur	Phosphorous	Chlorine	Other
✓✓	✓✓		✓✓	

## User Advice

Iloform FN 450 can be easily cleaned using mild alkaline or solvent cleaners.

Iloform FN 450 is not suitable for use on yellow metals.

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