



Product Data Sheet

Iloform™ PN 403

Chlorine free vanishing oil

Description

Castrol Iloform™ PN 403 is a low viscosity, chlorine and heavy metal free, metal stamping fluid. It is a blend of high lubricity boundary lubrication additives and wetting agents, in low odour isoparaaffinic hydrocarbon.

Application

Iloform PN 403 is specially formulated for use in light duty sheet metal stamping operations where very low residues are required, in most cases eliminating the need for inter process cleaning.

It is specifically suitable for stamping of low to medium collar height aluminium fins, in the refrigeration industry and shows excellent compatibility with the industries special requirements.

Advantages

- Excellent health, safety and environmental profile. Formulated on mild odour, very low aromatic isoparaaffinic hydrocarbon, and free from chlorinated and heavy metal containing constituents such as Barium.
- Contains high performance boundary lubricants which maximise punch life and provide excellent surface finish. Minimises costs associated with tool repolishing.
- Quick drying, low residue characteristics can eliminate requirements for inter process cleaning.
- Superior wetting provides thin, homogenous lubricating film.
- Low viscosity. Maximises flushing effect to aid removal of particulates from punches and dies, minimising component defects. Reduces drag out rates hence reduces product consumption.
- Low odour and improved working environment. Excellent operator acceptability.

Typical Characteristics

Description	Test Method	Unit	Value
Appearance	Visual	-	Clear, light yellow to yellow fluid
Density @ 15°C	ASTM D1298	g/ml	0.775
Kinematic Viscosity @ 40°C	ASTM D445	mm ² /s	1.6
Flash Point, PMCC	ASTM D93	°C	65
Copper corrosion (3 hrs @100°C / 212°F)	ASTM D130	-	1a

Subject to usual manufacturing tolerances.

Additional Information

Additives	Ester	Active Sulphur	Inactive Sulphur	Phosphorous	Chlorine	Other
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Storage

To avoid product deterioration always keep the container/drum tightly sealed. Store the product in a cool, dry place away from direct sunlight. Prevent exposure to frost and avoid water ingress. For optimum product stability, it is preferable to store the product indoors between 5°C and 45 °C / 41°F and 113°F.

For more details, please refer the product safety data sheet.

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