



Product Data

Iloform 168

Chlorine free neat forming oil

Description

Castrol Iloform™ 168 is a medium viscosity, chlorine and heavy metal free forming oil. It is a mixture of extreme pressure and anti-wear additives in a solvent refined mineral oil.

Application

Iloform 168 can be used in cold heading applications on steel and alloy steels. It is especially recommended for use in high speed, progressive cold heading machines for the production of high tensile steel nuts and bolts.

Advantages

- Chlorine and heavy metal free which may help to fulfil aspects of legislative requirements and waste treatment requirements that specify that these chemicals are excluded
- Contains high performance extreme pressure additives to provide excellent surface finish and to maximise die life, which helps to reduce the costs associated with die polishing
- Good detergency and wetting properties aid to reduce product drag-out and help to remove metal fines and particles from dies, minimising defects associated with particulates through cleaner machine tools and components
- Good filtration characteristics can increase product lifetime
- Chlorine-free formulation minimises the risk of in-process corrosion

Typical Characteristics

Description	Test Method	Unit	Value
Appearance	Visual	-	Clear brown fluid
Density @ 15 °C	ASTM D4052	g/ml	0.902
Kinematic Viscosity @ 40 °C	ASTM D445	mm ² /s	110
Flash Point, PMCC	ASTM D93	°C	> 170
Copper Corrosion, 3hrs @ 100 °C	ASTM D130	-	max. 3b

User Advice

Iloform 168 can be removed using aqueous mild alkaline cleaners or hydrocarbon solvent cleaners, also available from Castrol.

Iloform 168 is not suitable for use on yellow metals!

Additional Information

Additives	Ester	Active Sulphur	Inactive Sulphur	Phosphorous	Chlorine	Other
	√	√	√			

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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