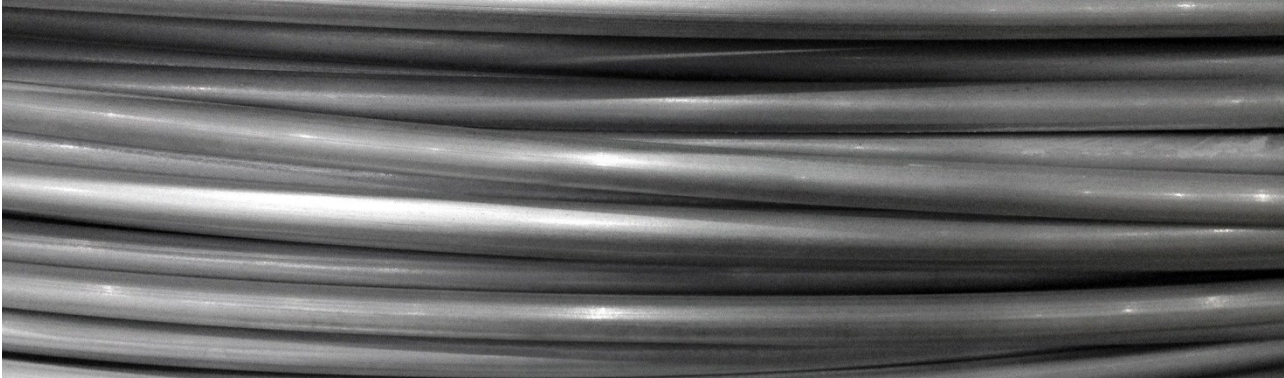




Alumol 615W

Emulsifiable drawing lubricant for aluminium and aluminium alloys



Description

Alumol 615W is a high performance, water miscible lubricant for the drawing of aluminium rod and wire. Careful selection of performance additives and the use of innovative technology delivers maximum lubrication and consistency in use to optimize die and capstan life and appearance of the drawn wire. The unique low foaming emulsifier and detergent system keeps machines clean and resists destabilization by hard water salts and dissolved aluminium ions resulting in significantly enhanced emulsion life.

Alumol 615W is recommended for drawing rod, intermediate, fine and multi-wire sizes and is suitable for both pure aluminium and aluminium alloys. Alumol 615W is also suitable for drawing copper rod and wire and can be used to optimize the capacity of the wire drawing machines by allowing both copper & aluminium to be drawn on the same machine. (as long as proper cleaning and filtration procedures are implemented)

Features and benefits

- Optimum lubrication to protect dies and capstans and deliver outstanding surface finish on drawn wire.
- Excellent emulsion stability and resistance to soap formation extends service life thereby minimizing disposal and downtime costs.
- Maintains machines and wire surface in a clean condition.
- Inherently low foaming.
- Extremely robust in use, minimal maintenance time and cost.
- Can increase machine capacity by facilitating the drawing of both copper & aluminium.
- Drawing machine is far cleaner and cooler than when using a neat oil product significantly improving the working environment

Global specialists in high-performance lubricants

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Company registration number: 2263118; Company registered in England VAT registration number GB108244927000



Cert No 2367QM8001



Alumol 615W

Recommended instructions for use

Best used in low hardness and low salt content water, but can be used in waters with up to 200 ppm CaCO₃ hardness. Ideally, use water with an initial hardness of 60-100 ppm CaCO₃ to prepare a fresh emulsion, with de-ionised water being used for subsequent replacement of evaporation losses, spillage etc. Bulk emulsion operating temperatures of 35 – 45 °C are recommended.

To prepare an emulsion always add Alumol 609W concentrate to water with adequate agitation – **never** add water to the concentrate.

For the efficient filtration of Alumol 615W emulsions FILTERMET PN100 is recommended to further extend life and maximize performance

Dilution range

Rod breakdown	14 – 20%
Multi-wire	8 – 12%
Intermediate wire	8 – 12%
Fine Wire	6 – 10%

Concentration monitoring

Emulsion concentration is generally measured using a refractometer measuring on the Brix scale.

To obtain the actual concentration multiply the refractometer reading by the correction factor 1.14

e.g. Refractometer reading	=	10.0
Correction factor	X	1.14
Actual dilution	=	11.4%

Pack sizes

Alumol 615W is available in 205 litre drums.

Storage

Store Alumol 615W out of direct sunlight and protect from frost. Storage temperature should be controlled to between 5°C and 35°C.

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Technical data (typical values)

Property	Test method	Result
Concentrate appearance	MSTM 1	Clear light brown oil
Emulsion appearance (10% in de-ionised water)	MSTM 9	Fine milky emulsion
Emulsion pH (10% in de-ionised water)	MSTM 18	8.9
Conductivity at 25°C (10% in de-ionised water)	MSTM 34	1714 µS
Density at 20°C	MSTM 23	0.96 g.cm ⁻³

The product information in this publication is based on knowledge and experience at the time of printing. There are many factors outside our control or knowledge which affect the use and performance of our products, for which reason it is given without responsibility.

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