

Condorlube DF 18

Polymeric lubricant for cold forming steels and non ferrous alloys

Physical Chemical properties

Physical state	: White viscous liquid
pH	: 9,8 +/- 0,5
Chemical composition	: Synthetic lubricants and polymers

Typical application

Condorlube DF 18 is a water based non reactive polymeric lubricant, for the cold forming, moulding and threading of bolts of steel, stainless steel and non ferrous metals

Condorlube DF 18 finds application as lubricating carrier in substitution of traditional conversion processes (phosphatation, non reactive salts, oxalation); the balanced formulation allows to use the layer of Condorlube DF 18 without any additional soap deposition and without using oils.

The working cycle results considerably simplified:

- Mechanical or chemical pickling
- Immersion in demineralized water at 60°C
- Treatment with Condorlube DF 18 between 40 and 60°C
- Warm drying (T=100°C)

In order to guarantee the efficiency of the product Condorlube DF 18 it is necessary to treat the material for the next operations as soon as possible, since product tends to hydrate when there is humidity in the air.

In case of high humidity environments or long time warehousing could be necessary to repeat the drying operation.

Condition of use

Condorlube DF 18 is used both in line or by batch immersion system. It is necessary a good mixing of the bath in order to avoid problems due to a stratification of the product.

Tanks, pipes and stirrers could be in AISI 304 or carbon steels covered with FRP or PP.

Condorlube DF 18 could be diluted with demineralized water prior to use, and the concentration of the product depends of the severity of the operation and the material to treat. The concentration is usually between 60 % and 90 % for the cold forming and threading; for the drawing operation the concentration is in function of the reduction ratio of the operation.

Treatment temperature	: T=40-60°C
Time of treatment	: depends on type of application and varies between seconds (in line application) to minutes (1 to 5 for batch application)
Concentration	: usually 60-90%, depending upon application