



Product Data

Iloform™ PS 158

Water extendible forming paste

Description

Castrol Iloform™ PS 158 is a water extendible forming paste, specifically developed for heavy duty deep drawing operations.

It is a blend of high performance boundary lubricants, inorganic fillers for extreme pressure lubrication, emulsifiers and corrosion inhibitors. The product is formulated without chlorinated paraffins.

Application

Iloform PS 158 is specially formulated for use in single die and progressive die presses for medium duty deep drawing applications. It is suitable for use on steels, aluminium and aluminium alloys.

Iloform PS 158 can be used as supplied or used diluted in water to a minimum concentration of 20%v/v oil to water, for less difficult operations. Forms a stable milky white emulsion in water.

Advantages

- Formulated without chlorinated paraffins which may help to fulfil aspects of legislative and waste treatment requirements that specify that these chemicals are excluded
- Contains high performance lubricity and anti wear additives, as well as inorganic fillers to provide performance under high temperature and pressure. Maximises die life and provides excellent surface finish. Reduces scrap and rework costs as well as minimising costs associated with die repolishing
- Can be used diluted in water, forming a stable milky emulsion. Economical in use and reduces product consumption
- Versatile and multi metal compatible, therefore offers potential for product consolidation

Typical Characteristics

Description	Test Method	Unit	Value
Concentrate			
Appearance @ 20 °C	Visual	-	Semi-consistent white paste
Density @ 15 °C	ASTM D1298	g/ml	1.3
Acid Number	DIN EN ISO 2114	mg KOH/g	11.6
Penetration, unworked	DIN ISO 2137	0.1mm	270
Emulsion			
Emulsion Appearance (10% in Distilled Water)	Visual	-	Stable, milky white
pH (10% Emulsion)	ASTM E70-97	pH	10

Subject to usual manufacturing tolerances.

User Advice

Iloform PS 158 contains solid filler. Depending on the working concentration cleaning immediately after pressing is preferable, particularly with copper or copper based alloys.
It can be removed by using alkaline process cleaners, also available from Castrol

Iloform PS 158 is not recommended for use on zinc coated steel.

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.

After an extended period of storage without movement the solid filler of the product can separate to a certain degree. In this case we recommend to re-homogenize the product before use!

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

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