

**Product Data****Iloform PL 6**

Chlorine free neat forming oil

Description

Castrol Iloform™ PL 6 is a low viscosity, chlorine free metal stamping fluid, specifically developed for automotive blank washing and stamping operations.

It is a blend of high performance extreme pressure and anti wear additives, in a fully solvent refined paraffinic mineral oil.

Application

Iloform PL 6 is specially formulated for use in wash-roller units, as a dual purpose washing and lubricating fluid.

It contains additives to break down and release soils, greases and particulates leaving a clean blank prior to stamping. Once in the press the product provides excellent lubricity and metal flow, resulting in clean, blemish-free skin panels.

It is of sufficiently low viscosity to allow for easy filtration through cartridge filtration units.

It is suitable for use on uncoated steels as well as zinc coated steels, aluminium alloys, and is compatible with yellow metals.

Advantages

- Excellent health, safety and environmental profile. Formulated on solvent refined mineral oil. Does not contain hazardous aromatic constituents, or chlorinated additives
- Contains high performance extreme pressure additives. Maximises punch life and provides excellent surface finish. Minimises costs associated with tool repolishing
- Contains corrosion inhibitors, which provide excellent protection under normal indoor storage conditions. Minimises rework costs due to corrosion
- Easily removed using traditional wash systems. Minimises problems associated with oil contamination such as phosphating and paint defects
- Excellent detergency. Removes soils and particles from blank, eliminating panel defects associated with particulates, hence reducing scrap and rework costs
- Phosphate, e-coat and paint compatible.
- Low viscosity. Maximises flushing effect on skin panels to aid removal of particulates. Helps eliminate panel defects, reduces dragout rate, hence reduces product consumption, and easily filtered in service, to extend service life.
- Low odour. Excellent operator acceptance.

Typical Characteristics

Description	Test Method	Unit	Value
Appearance	Visual	-	Clear amber fluid
Density @ 15°C / 59°F	ASTM D4052	g/ml	0.83
Kinematic Viscosity @ 40°C / 104°F	ASTM D445	mm²/s	4.5 - 8
Pour Point	ASTM D97	°C/°F	-12 / 10.4
Flash Point, PMCC	ASTM D93	°C/°F	150 / 302
Copper corrosion (3 hrs @100°C / 212°F)	ASTM D130	-	1a

User Advice

Pressure filters or gravity filters are recommended for best results.
Iloform PL 6 can be easily cleaned using mild alkaline or solvent cleaners.

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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