



Innovation in Metalworking Fluids



Form Rite 865

Full bodied Synthetic Drawing Lubricant

Description

Form Rite 865 is a heavy-duty synthetic paste that can be used for drawing, stamping, and bending operations on all metals. A unique water-based formulation, the product will give the same or better performance over traditional oil-based solid lubricants with improved weldability, cleanability, and corrosion protection. The protective film left by Form Rite 865 can be easily removed using only warm water.

Applications

- Deep drawing
- Bending
- Swaging
- Blanking
- Progressive die stamping
- Punching/piercing
- Stamping
- Tube expanding
- Wire and tube drawing

Performance Features and Benefits

- Maximum formability and corrosion protection ensure excellent die life, decreasing costs associated with die purchases and change out.
- Ashless making it easily annealable and weldable.
- Multi-metal lubricant that will give exceptional part finishes on aluminum while easily drawing 8-gauge steel for shops machining multiple metals with the same product.

Typical Properties

<i>Property</i>	Form Rite 865
<i>Concentrate Appearance</i>	Off white, smooth paste
<i>Odor</i>	Mild characteristic
<i>Specific Gravity, 25 °C</i>	1.001
<i>Bulk Density, 25 °C</i>	8.348

Directions for Use

Form Rite 865 is best applied onto blanks as received for drawing operations, or as a dip lubricant in end forming. For spray applications, the product can be diluted up to 10% (1:10) in water. When diluting Form Rite 865 always **add water to the lubricant** for homogeneity. A dilution of 50% (1:2) in water is effective as a stamping emulsion and can be applied by oiler or spray bottle.

Consult product SDS for complete product safety information.