



DURA DRAW 891 DRAWING COMPOUND

Dura Draw 891 Drawing Compound is a new generation in lubricant chemistry for copper, brass and tin-plated copper wire drawing.

It has a biostable synthetic emulsifier system with biostable and oxidation stable performance ingredients. These ingredients were chosen because of their better lubricity and overall performance over conventional fat-soap products. Non-silicone defoamers provide foam control. This product provides improved cleanliness and long coolant life.

FEATURES: The lubricity and wetting characteristics of the product reduces dry copper fines. The Capstan surfaces, die throats, and machines stay cleaner. Performance is based on total product concentration and no fat-soap content. Long solution life is built in with biostable additives. Special corrosion inhibitors prevent oxidation of the newly drawn metal surface.

RECOMMENDED USES:

Copper Rod Breakdown:	Use Dura Draw 891 at 6 – 10% concentration
Intermediate Copper Wire Drawing:	Use Dura Draw 891 at 2 – 5%.
Fine Copper Wire Drawing:	Use Dura Draw 891 at 2 – 5%.
Multi-wire (14 gauge-> 36gauge):	Use Dura Draw 891 at 7.0 – 9.0%.

TYPICAL PRODUCT SPECIFICATIONS:

Viscosity @ 100° F., S.U.S.	-450-490 seconds
Specific Gravity, @ 60° C.	-.934
Flash Point, C.O.C.	-305 F.
ASTM Color	-Clear amber liquid
Weight/gallon	-7.79
pH @ 3% concentration	-9.1
pH @ 10% concentration	-9.3
Emulsion stability, 400 ppm hard water, 5% dilution, 24 hours – NO SEPARATION	
Foam , cylinder test	-39 seconds
Refractometer factor*	

SOLUTION CONTROL: Dilutions of Dura Draw 891 can be determined using an optical refractometer such as American Optical No., 10440.

Refractometer Reading (BRIX): Each percent concentration of product reads direct on the Brix Scale. A 10% dilution would read 10 on the scale. This method is used for rapid in plant control of solution strength.

Our laboratory performs more extensive analysis, which consists of total active concentration, pH, conductivity, bacteria, yeast or mold and total metal concentration.

Dissolved solids content will gradually increase through water evaporation and make up addition. This will gradually reduce the refractometer concentration factor. The readings should be compared to a recent Babcock Test to determine a new factor for refractive index.

PRODUCT SAFETY: For complete safety and health information, consult the current Material Safety Data Sheet (MSDS).