



Dura Draw 1540 & Dura Draw 4500

DURA DRAW 1540 was developed specifically for the difficult machining and forming operations that cannot be performed satisfactorily with ordinary forming and cutting fluids. It was designed for use in the neat form, with no dilution of any kind.

DURA DRAW 1540 is particularly effective for all normal fine blanking, perforating and punching operations. When stainless or high tensile steels of heavy gauge are to be fine blanked, **DURA DRAW 4500** may be mixed with **DURA DRAW 1540** to produce the desired results.

DURA DRAW 1540 excels at machining austenitic, ferritic and martinitic steels as well as the exotic high temperature alloys used in the manufacture of jet engines and gas turbine. Where extremely close tolerances and fine finish are required in fine blanking, broaching, hobbing, milling and threading, **DURA DRAW 1540** cannot be excelled. Threads cut with **DURA DRAW 1540** often have the appearance of being polished. The product is stable and will not attack or corrode any metals. It is harmless to skin and eyes.

DURA DRAW 4500 is a high performance cutting and drawing compound developed for use in operations involving very heavy deformations such as fine-blanking and thread or spline rolling. It is also excellent for use on the very hard, heat resistant alloys like beryllium copper, discaloy and inconel X.

DURA DRAW 4500 is too viscous for most pumps. It is brush applied to the part being formed or the tool. It is used to aid difficult tapping jobs by brushing it on the tap and then flooding the work zone with an emulsion of our **MACSON** water miscible coolants. This gives the most desirable combination of cooling and maximum film strength and virtually assures longer life for expensive taps, broaches etc.

Contact us for the specific recommendations regarding your most difficult operations. The chances are that we can help you increase your profits.

<u>PHYSICAL PROPERTIES</u>	<u>DURA DRAW 1540</u>	<u>DURADRAW 4500</u>
Specific Gravity	1.01	1.18
Weight (lbs./gal)	8.40	10.1
Viscosity @ 100° F., S.U.S.	424 Min	4165
Viscosity @ 210° F., S.U.S.	50.2	160
Pour Point, ° F.	-20	----
Flash Point, C.O.C.	365	495
Fire Point, C.O.C.	405	555
Shelf Life	Excellent	Excellent
Color	Clear Red	Clear /Yellow /Amber