

## **PRODUCT INFORMATION**

### **HI- FORM 181:-**

- HI-FORM 181 is highly chlorinated extreme pressure oil blended with fatty additives which give it unique drawing properties for the most severe conditions.
- HI-FORM 181 to be used as supplied. It is important to avoid contamination with water either in storage or in use.
- HI-FORM 181 to be used for COLD PILGERING OF tubes in Stainless Steel and High Nickel Alloys, also for DEEP DRAWING operation in difficult steels, such as High Nickel/chromium Alloys, Nimonics, and Titanium. Also Suitable for aluminium Alloys.

When used for Cold Pilgering HI-FORM 181 gives:

- Maximum reduction per pass.
- High internal & external finish.
- Close limits on wall thickness.
- Low wear on mandrel & dies.
- Reduction in frictional heat.

When used for Deep Drawing, HI-FORM 181 gives:

- Freedom from scoring.
- Reduction of scrap.
- Ease of application.
- Ease of removal.
- Better surface finish.

Easily degreased in either Solvent Vapor or Alkaline Bath.

### **TYPICAL DATA:**

Control Test	Unit	Method	Limit
Appearance	-	Visual	Dark Amber Fluid
Density @ 30°C	Kg/litre	ASTM D 4052	1.10 +/- 0.05
Kinematic Viscosity @ 40°C	cSt	ASTM D 445	340-400
Flash Point (PMCC)	°C	ASTM D 92	170 min
Flat Content	%	BAM 306	9.5 – 10.5
Four Ball Weld Load	Kg	ASTM D 2783	>800

*The information provided on this page is, to the best of our knowledge accurate, however, it is subject to change without prior notice.*

*We assume no liability for the completeness of it or errors in it.*

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