

FINADRAW-WDL

Lubricant for RBD, Intermediate and Ultra-fine Wire Drawing of Copper.

FINADRAW-WDL is a unique combination of vegetable oils, synthetic lubricants, tarnish inhibitors & anticorrosive compounds. **FINADRAW-WDL** gives translucent green solution at all dilutions & is known to keep the machine interior & operational areas free of fatty deposits owing to its cleaning characteristic. A combination of corrosion & tarnish inhibitors protects the machine parts from corrosion & the drawn wire from acquiring tarnish especially during storage. Superior quench characteristics keep the drawn wire cool. Fully organic nature of the compounds eliminates the possibility of ash formation on annealed wire. **FINADRAW-WDL** solutions can tolerate up to 350 ppm Calcium hardness & even 90 ppm of Chloride hardness. Wire surface is remarkably brighter when drawn with **FINADRAW-WDL**. Fine, suspended dust whenever formed on an appreciable scale can be removed by in-line gravity bed filter or hydro-cyclone.

APPLICATION :

FINADRAW-WDL is recommended at definite range of concentration from shaving & RBD up to ultra-fine wire drawing of copper wire. Specialized applications of **FINADRAW-WDL** include slow speed single-stage finish drawing of stainless steel wire.

FEATURE

Blend of soluble synthetic lubricants & emulsifiers

Incorporates modified vegetable oil coolants

Translucent solution nature

BENEFITS

- * *Reduces copper dust generation remarkably.*
- * *Keeps operational mechanisms free of fatty deposits & sludge.*
- * *Easy to prepare & maintain, stable solutions.*
- * *Virtually unaffected by water hardness.*
- * *Higher lubricity levels & better die life*
- * *Prevents splitting of lubricants.*
- * *Ease of maintenance of lube by refracto-meter.*

RECOMMENDED CONCENTRATIONS:

Stage of Drawing	Reduction	% Vol. Concentration
Rod shaving	9mm – 14 mm	14 – 16
Rod Break Down	2.5 mm – 9 mm	11 – 14
Intermediate	0.5 mm – 2.5 mm	5 – 9
Fine wire	0.1 mm – 0.5 mm	2 – 4
Ultra-fine	0.06 mm – 0.1 mm	2.2

Actual concentration may be determined by the user depending on machine speed, reduction ratio, solution vol, cooling etc.



MAINTENANCE & REPLENISHMENTS

1. Pre-cleaning of bath with 1% **FINADRAW-WDL** for 10-12 hrs is recommended in order to wash off dust impregnated fatty deposits due to earlier lubricants.
2. Freshly prepared solution of **FINADRAW-WDL** should have a pH between 9.5-10. Any change in pH can be adjusted by **FINABUFF** according the procedure outlined in the Manual.
3. Fat content or the Total Dissolved Solid (TDS) content of **FINADRAW-WDL** is critical for smooth operation. The same can be maintained using refracto-meters according to the chart incorporated in the Manual.

TECHNICAL DATA

Appearance	:	Viscous Amber Liquid
Sp. Gravity	:	0.997
pH 2% Solution	:	10 ± 0.5
BRIX factor	=	1.61

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