



Metalworking Fluids

Drawing/Stamping Fluid Application Chart

Product	Form	Dilution	Application	R.P.	Chlorinated	Comments
VANISHING OIL 3	Petroleum	As Is	Stamp/Roll Form	Fair	No	Vanishing Oil
WOCODRAW 10	Petroleum	As Is	Cold Heading	Good	No	Low Viscosity
WOCODRAW 20	Petroleum	As Is	Cold Heading	Good	No	Heavy Duty
POSI-DRAW 309	Petroleum	As Is	Fine Blanking	Good	Yes	Long Die Life
W-373 EXTRUDE	Petroleum	As Is	Extruding	Good	Yes	Heavy Duty
PRODRAW 100	Petroleum	As Is	Stamp/Draw	Excellent	No	Excellent R.P.
PRODRAW 125	Petroleum	As Is	Medium Draw	Good	Yes	Medium Draw
PRODRAW 150	Petroleum	As Is	Heavy Draw	Good	Yes	Heavy Draw
PRODRAW 200	Soluble	10% to 50%	Medium Draw	Fair	Yes	Excellent General Purpose
PRODRAW 220	Soluble	10% to 50%	Medium Draw	Fair	No	Medium Draw
WOCODRAW 34	Soluble	10% to 50%	Heavy Draw	Fair	Yes	Neat or Diluted
PRODRAW 365	Synthetic	As Is/Diluted	Medium Draw	Excellent	No	Full Synthetic

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VANISHING OIL 3

The wetting and mild E.P. characteristics of VANISHING OIL 3 make it an excellent choice for light duty stamping or roll forming when low residue is critical. It is suitable for both ferrous and nonferrous metals.

WOCODRAW 10

A low viscosity chlorine free cold heading oil formulated with the latest in synthetic additive technology. It can be used as a stamping oil and as an additive to boost performance of most cutting oils.

WOCODRAW 20

A heavy duty chlorine free cold heading oil that can perform the most severe heading operations and still give excellent die life.

POSI-DRAW 309

A heavily fortified stamping fluid for medium to heavy duty stamping and fine blanking. It uses a combination of fats, sulfur, and chlorine to achieve excellent wetting and superior E.P. characteristics to produce burr free edges and long tool life.

W-373 EXTRUDE

A dark colored, heavy duty extruding oil compounded with sulfur, chlorine and fatty oils.

PRODRAW 100

For light duty drawing, PRODRAW 100 displays excellent wetting and lubricity characteristics combined with built in rust protection. This product is sulfur free and the right choice for both ferrous and nonferrous metals.

PRODRAW 125

An oil based product, PRODRAW 125 displays good flow characteristics with a combination wetting /E.P. package to handle any medium duty draw. A sulfur free package makes it ferrous and nonferrous friendly.

PRODRAW 150

If you are looking for an oil based, viscous drawing compound to handle the toughest of draws, PRODRAW 150 will do the job. This product is heavily fortified with a combination of sulfur, chlorine, and fat.

PRODRAW 200

A water soluble drawing compound, can be used in concentrations of 10% to 50%, depending on the severity of the draw. Excellent wetting and E.P. properties.

PRODRAW 220

This is a chlorine free version of our PRODRAW 200. For light to medium drawing applications, where chlorine is an issue, PRODRAW 220 will stand up to the test.

WOCODRAW 34

A highly compounded soluble drawing lubricant formulated for maximum severity press operations requiring high chemical E.P., metal-wetting and "anti-wipe" properties. Can be used neat or diluted.

PRODRAW 365

A full synthetic, water based product, PRODRAW 365 can be used from straight to a 10% concentration depending on the severity of the draw. This product displays great flow characteristics and is chlorine free.