

ALDRAW® J-2E, J-1E, J-4E, J-50E *Forming Compounds, Water Cleanable*

GENERAL DESCRIPTION

Hangsterfer's Aldraw forming and fabricating compounds deliver excellent results on a broad range of metalforming applications. From stamping and blanking of carbon steel to the drawing of high nickel tubing, Aldraw products provide extended die life, improved surface finishes and reduced scrap material. **The Aldraw "E" series provides all the benefits of the regular Aldraw products, while being easier to clean with water and water based cleaning systems.** The *non-hazardous* formulation provides for a safe work environment and easy waste disposal.

APPLICATION

J-2E - The heaviest of the Aldraw series, J-2E provides the maximum adherence and shear resistance for the most severe forming operations. The physical film characteristics and EP additives in the J-2E provide unparalleled performance in the severe reduction and/or expansion of difficult materials.

J-1E - Slightly lower in viscosity than the J-2E, J-1E provides excellent results on tube drawing, deep drawing of blanks, forming and stamping of stainless steel, titanium and other exotic materials. Because of its high viscosity, J-1E clings to the die, reducing application steps, while increasing die life in severe operations.

J-4E - This medium weight compound is ideal for drip, roller and brush applications on stamping, forming, deep drawing and wire drawing operations.

J-50E - Unlike the other "E" Series products, which have much lower viscosity's than their respective non-"E" cousins, J-50E offers nearly the same performance as J-50. It can be used for stamping, mild forming and drawing, broaching, tapping and a variety of other applications.

Materials & Forms

Stainless Steels, <i>tube, bar, rod, wire, blanks</i>	Nickel Alloys, <i>tube, bar, rod, wire, blanks</i>
Titanium, <i>blanks</i>	Carbon Steels, <i>tube, bar, rod, wire, blanks</i>

Operations

Stamping & Forming – Progressive and Transfer	Deep Drawing, Progressive and Transfer
Swaging, Pointing	Fine Blanking and Coining
Heavy Duty Tapping and Threading	Spinning
Broaching	

MAINTENANCE & CLEANING

Maintenance: When in use, the Aldraw products should be kept free of metal particulate, solvents, water and cleaners, which may interfere with the performance of the product. When thinning down any of the Aldraw products for specific applications, we recommended the use of our Hard Cut 541 (formerly known as J-1 Thinning Oil). The use of mineral spirits, kerosene or other items is not recommended. All products should be stored in a sealed container, in a cool, dry place.

Cleaning: The Aldraw "E" series is formulated to be totally water cleanable. For best results, a hot alkaline wash, utilizing Hangsterfer's AC Cleaner at 10% is recommended. Because of their extreme viscosity, the J-1E and J-2 E require pressure and agitation for complete removal. The "E" series products may also be removed in a hot or cold solvent wash or with vapor degreasing.

PRODUCT CHARACTERISTICS				
Aldraw	J-2E	J-1E	J-4E	J-50E
Form	Liquid	Liquid	Liquid	Liquid
Color	Red	Red	Red	Amber
Odor	Mild	Mild	Mild	Mild
Specific Gravity	1.25	1.20	1.20	1.05
Viscosity: SUS @ 100°F	18,800	4,800	2,570	815
cSt @ 40°C	4,060	1,040	555	176
Flash Point, COC, °F/°C	480 / 248	480 / 248	480 / 248	390 / 198
Fire Point, COC, °F/°C	480 / 248	480 / 248	480 / 248	415 / 212
Pour Point, °F/°C	36 / 2	36 / 2	36 / 2	10 / -12
Solubility in Water	80%	80%	80%	80%
Boiling Point, °F/°C	478 / 248	478 / 248	478 / 248	478 / 238
Vapor Pressure, mm Hg @ 25°	<0.01	<0.01	<0.01	<0.01
pH @ 10%	7.3	7.3	7.3	7.3
Chlorine	Added as EP additive	Added as EP additive	Added as EP additive	Added as EP additive

SHIPPING UNITS

Aldraw's J-2E, J-1E, J-4E and J-50E are available in 5 gallon, 55 gallon and Bulk Container (275 or 330 gallons). All products are distributed worldwide.

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