



# TECHNICAL DATA SHEET

## GRODAL FORM DE 68

### NEAT FORMING OIL

#### DESCRIPTION

GRODAL FORM DE 68 is a medium viscosity, chlorine and heavy metal free forming oil designed specifically for cold heading operations on steel and alloy steels. It is a blend of high performance extreme pressure and anti wear additives, in a fully solvent refined paraffinic mineral oil.

#### APPLICATION

GRODAL FORM DE 68 is specially formulated for use in high speed, progressive cold heading machines. GRODAL FORM DE 68 provides outstanding performance in the production of high tensile steel nuts and bolts.

#### BENEFITS

- Formulated on solvent refined mineral oil. Does not contain hazardous aromatic constituents, chlorine or heavy metals such as Barium.
- Contains high performance extreme pressure additives. Maximises die life and provides excellent surface finish. Minimises costs associated with die repolishing.
- Excellent detergency. Removes metallic fines and particles from dies, eliminating defects associated with particulates. Improved surface finish, reducing scrap and rework costs.
- Excellent wetting characteristics. Reduces drag out rate, hence reduces product consumption. Easily filtered in service, to extend service life.
- Low misting and fuming. Excellent operator acceptance
- Provides excellent inter process rust protection.

#### TYPICAL TECHNICAL DATA

Appearance	:	Clear brown liquid
Specific gravity	:	0.90
Kinematic viscosity @ 40°C, cSt	:	75
Copper Corrosion	:	3a
Flash Point CoC °C	:	210°C min
Ester	:	Present
Sulphur	:	Present

#### ADVICES

Store in a cool dry, well ventilated area out of direct sunlight. Avoid Sparks, flames and other ignition sources. Store away from incompatible materials such as material that support combustion.

#### SAFETY

This oil is unlikely to present any significant health or safety hazard when properly used in the recommended application as well as good standards of industrial and personal hygiene is maintained.

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Supersedes all earlier

**GRAUER & WEIL (INDIA) LTD. (Lube Division)**

**Registered Office : 'Growel House' , Akurli Road, Kandivli (E), Mumbai - 400 101, India**

**Tel. : 91 - 22 - 66993000 , Fax : 91 - 22 - 669930101/11,**

**E-mail : lubricants@growel.com, Website : www.growel.com**