

Keller-Heartt Oil

Oil solutions for today and tomorrow...



TRUEGARD #3694 DRAWING OIL

TRUEGARD #3694 DRAWING OIL is a petroleum oil concentrate designed for a broad range of heavy duty stamping, punching, piercing, and forming operations on steel, copper, and aluminum alloys. **TRUEGARD #3694 DRAWING OIL** can be used either straight or diluted with water.

TRUEGARD #3694 DRAWING OIL utilizes several types of additives in order to provide the necessary lubricity and cooling to improve productivity and improve part finish. A blend of soaps, fats, and chlorinated compounds work synergistically to reduce the friction and heat associated with drawing and forming processes.

TRUEGARD #3694 DRAWING OIL may be diluted with water to form an economical emulsion. The suggested concentration is between 5-30%. Concentrations above 30% in water may be too thick to allow easy application. Within the suggested concentration range, a minimum of mixing is required to form a stable, milky white emulsion. The emulsion is stable in both hard and soft water and exhibits a balanced Ph to minimize irritation risk to workers.

TRUEGARD #3694 DRAWING OIL may be applied by spray, dip, brush, drip, roller, or recirculating flood systems. Due to the water soluble nature of this product, removal may be readily achieved with water.

TRUEGARD #3694 DRAWING OIL provides mild rust prevention characteristics for short term indoor storage. However, a rust preventive should be applied if extended storage is anticipated.

Typical Properties:

Viscosity, SUS @ 100 F	300
Color	Amber
Odor	Mild
Flash Point, F	380
Pounds/Gallon	8.0

4411 S. Tripp Avenue, Chicago, Illinois 60632

Phone: 773 247-7606 ■ Toll free: 800 423-7513 ■ Fax: 773 247-7969

www.kellerheartt.com