



# TECHNICAL DATA SHEET

## GRODAL STCUT TDN 250 N

### NEAT DRAWING / PILGERING OIL

#### DESCRIPTION

**GRODAL STCUT TDN 250 N** is highly chlorinated Extreme Pressure (EP) type oil with combination of top quality ester, fatty oils and active sulphur making it ideally suited for most severe drawing/pilgering conditions. At the drawing process when the surface of the tube bar is in contact with the die, there is a chemical reactivity on the metal surfaces whereby a nascent metallic chloride layer of molecular thickness is formed. This feature is important in high speed drawing of steel for extending the die life and improving the surface finish.

#### APPLICATION

**GRODAL ST CUT TDN 250 N** is ideally suited for cold pilgering. The high percentage of stabilized chlorine incorporated in the blend enables maximum reduction per pass, simultaneously offering a high degree of finish both internally and externally. It also ensures low wear on mandrel and dies. **GRODAL ST CUT TDN 250 N** is also widely used for deep drawing and cold rolling of stainless steel tubes.

#### BENEFITS

- High amount of Chlorinated so economy of use fats.
- Enhanced lubricity package, High degree of internal and external finish so lesser rejection rate.
- Reduction in frictional heat hence closer tolerances in manufacturing.
- Excellent EP package so very low mandrel and die wear improved mandrel and die life hence reduced costs.

#### TYPICAL TECHNICAL DATA

Appearance	: Yellow to brown liquid
Sp. Gravity @30°C	: 1.150 – 1.300
Viscosity @40°C	: 250 - 300 cSt.
Flash Point COC°C	: Above 150
Cu corrosion@100°C	: 4
Additives Present	: Chlorine, Ester, Fats & Sulphur
Saponification value	: Approx 20

#### ADVICE

Not recommended for cuprous metals as it may cause staining. Staining may also occur on high nickel alloys during storage and subsequent heat treatment.

Store at ambient temperature and away from direct contact of fire. Avoid contact with water.

#### 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.

Issued on : 30.12.2014

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](mailto:lubricants@growel.com), Website : [www.growel.com](http://www.growel.com)