

Technical data

MOLYFORM 3055

The logo for MOLYSLIP, featuring the brand name in a bold, italicized, sans-serif font with a registered trademark symbol, set against a red rectangular background.

High Performance metal forming lubricant

Description

MOLYFORM 3055 is a specially formulated high performance chlorine free cold metal forming lubricant, suitable for use on a wide range of ferrous and non-ferrous metals – including aluminium, high carbon and stainless steels.

MOLYFORM 3055 is designed for use both neat and diluted with water depending on the severity of operation. The product contains highly effective extreme pressure additives which prevent metal pick up between the work piece and tool – as a result it can be used on many deep drawing, stamping, bending and blanking applications, providing a cost effective route to improved product quality and tool life and increased productivity.

MOLYFORM 3055 will form highly stable emulsions with inherently low foaming characteristics when diluted at concentrations of 4 – 50%. As MOLYFORM 3055 is water-miscible it is easily removed to leave components with a noticeably cleaner finish and the wide dilution range offers superb economy in use.

Features and benefits

- Chlorine free
- Suitable for use on a wide range of metals and forming processes
- Outstanding extreme pressure and anti-wear properties - extends tool life
- Reduces metal pick-up and scoring
- Can be used neat or diluted with water
- Suitable for high speed progressive pierce, form and drawing operations
- Offers improved cleanliness on finished components

Packaging

20ltr & 205ltr

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Instructions for use

MOLYFORM 3055 is supplied ready for use or alternatively diluted with water.

To prepare an emulsion always add MOLYFORM 3055 concentrate to water with adequate agitation – **never** add water to the concentrate.

MOLYFORM 3055 can be applied by brush, drip, roller or spray applied by either airless or air assisted spray systems.

Recommended concentration (%)

Deep drawing	-	30 – 100(neat)
Stamping	-	10 – 50
Pressing	-	30 – 50
Punching	-	5 – 30

Emulsion concentration is generally measured using a refractometer measuring on the Brix scale. To obtain the actual dilution multiply the refractometer reading by the correction factor 0.97.

Note: Where absolute freedom from surface discolouration is essential, it is recommended that compatibility trials are conducted prior to use.

Technical data (typical values)

Property	Test method	Result
Appearance	MSTM 1	Clear brown liquid
Odour	-	Mild
Density @ 20°C	MSTM 23	0.95 g.cm ³
Emulsion pH (10% concentration)	MSTM 18	8.3
Kinematic viscosity @ 40°C	MSTM 27	100 cSt
4-Ball weld load (neat)	IP 239	620kg

Storage

Store MOLYFORM 3055 out of direct sunlight.

Storage temperature should be controlled to between 5°C and 35°C.

The product information in this publication is based on knowledge and experience at the time of printing. There are many factors outside our control or knowledge which affect the use and performance of our products, for which reason it is given without responsibility.
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Molyslip Atlantic Limited, 4 Huntsman Drive, Northbank Industrial Park, Irlam, Manchester, M44 5EG, UK
Tel: +44 (0)161 804 4700 Fax: +44 (0)161 804 4701 enquiries@molyslip.co.uk www.molyslip.co.uk

Company registration number: 02664511; Company registered in England VAT registration number GB578295191