

Metal Forming Lubricants - keywords:

Heavy duty drawing, chlorinated, synthetic, non-chlorinated, stamping, straight oil, vanishing lube, fine blanking, low foam, OEM approval, bio stable, drawing compound, Elastomer release agent, extreme pressure, hard water stable, hydroforming, light to medium drawing, tube bending.

See products fact sheets below.

1 **Description:**

TechDraw FT 305 is a heavy – duty synthetic drawing / stamping compound concentrate is formulated with extreme pressure additives which will reduce part gulling and fracturing and increase die tooling and coating life. TechDraw FT 305's unique low-foaming formulation does not contain chlorine, sulfur, oil, or pigments and is easily removed where clean surfaces are required in subsequent operations such as welding. TechDraw FT 305 can be used neat or diluted as low as 20:1 in water depending on the substrate and severity of the application. TechDraw FT 305 will perform on CRS, HRS, HSS, HSLA, SS, Aluminum and Dual Phase substrates.

This post is also available in: Spanish

Typical Properties (Not Specifications):

Appearance	Translucent
Density	
pH	

Health & Safety

TechDraw FT 305 is available in 55-gallon drums, 330 gallon totes and pails.

Storage And Handling: See Safety Data Sheet Before Use. Product be stored at temperatures between 45°F– 90°F. Do not expose to extreme high temperature due to container rupture. Do not pressurize drum or reuse empty container. Follow all safety regulations on label.

Non-Warranty: While the information and recommendations sent forth herein are believed to be accurate as of the date thereof, Fortech Products, Inc. makes no warranty with respect thereto and disclaims all liability for reliance therein.

Features / Benefits

- Provides excellent lubricating properties that protect parts and tooling
- Imparts excellent in-process corrosion protection
- Contains no chlorine, sulfur, oil or pigment
- Easily cleaned with mild detergents
- Hard water stable
- Non-staining
- Low foaming

Mix / application & Use

Always add TechDraw FT 327 to water with agitation. Dilution range is from 5-10 parts water to 1 part TechDraw FT 327. TechDraw FT 327 can be applied using spray, roll-coater, drip or brush applications. Your Fortech Customer Sales Representative will work with you on a proper dilution and mixing approach

2 **Description:**

TechDraw FT 403 is a heavy-duty drawing compound formulated to perform a wide range of operations. TechDraw FT 403's extreme pressure additives allow forming of the most severe operations on ferrous and non-ferrous alloys, reducing part galling and cracking while increasing die tooling and coating life. TechDraw FT 403's unique formulation is easily removed with alkaline cleaners where clean surfaces are required in subsequent operations such as welding and painting. Depending on the substrate and severity of the application, TechDraw FT 403 can be used neat in severe operations such as fine blanking and extruding, or diluted from 20:1 down to 10:1 to form a stable emulsion for medium- to light-duty stamping.

This post is also available in: Spanish

Typical Properties (Not Specifications):

Appearance	Clear Amber Oil
Density	9.4
pH	8.42

Health & Safety

TechDraw FT 403 is available in 55-gallon drums, 330 gallon totes and 5 gallon pails.

Storage And Handling: See Safety Data Sheet Before Use. Use at room temperature. If frozen, allow to thaw completely prior to use. Do not expose to extreme high temperature due to container rupture. Do not pressurize drum or reuse empty container. Follow all safety regulations on label.

Non-Warranty: While the information and recommendations sent forth herein are believed to be accurate as of the date thereof, Fortech Products, Inc. makes no warranty with respect thereto and disclaims all liability for reliance therein.

Features / Benefits

- Extreme pressure additives helps eliminate part galling and cracking
- Provides excellent lubricating properties that increases life of die tooling and coatings
- Imparts in-process corrosion resistance
- Forms stable emulsion
- Offers biological control
- Part can be welded after forming

Mix / application & Use

Always add TechDraw FT 403 to water with agitation. Typical dilution range is from 10-20 parts water to 1 part oil. TechDraw FT 403 can be applied using spray, roll coating, drip or brush applications. Your Fortech sales representative will work with you on the proper dilution and mixing approach.

3 **Description:**

TechDraw FT 406 is a heavy-duty drawing/fine blanking compound formulated to perform a wide range of operations. TechDraw FT 406's extreme pressure additives allow forming of the most severe operations on ferrous and non-ferrous alloys. TechDraw FT 406 reduces part galling and cracking while increasing die tooling and coating life. TechDraw FT 406's unique formulation does not contain any phosphorus or pigments and is easily removed with alkaline cleaners. Depending on the substrate and severity of the application TechDraw FT 406 can be used neat in severe operations such as fine blanking or extruding, or diluted from 20-10 parts water to 1 part FT 406 for heavy to light stamping.

This post is also available in: Spanish

Typical Properties (Not Specifications):

Appearance	Dark Amber Oil
pH at 10%	9.9
Density (lbs./gal)	9

Health & Safety

TechDraw FT 406 is available in 55-gallon drums, 330 gallon totes and 5 gallon pails.

Storage And Handling: See Safety Data Sheet Before Use. Use at room temperature. If frozen, allow to thaw completely prior to use. Do not expose to extreme high temperature due to container rupture. Do not pressurize drum or reuse empty container. Follow all safety regulations on label.

Non-Warranty: While the information and recommendations sent forth herein are believed to be accurate as of the date thereof, Fortech Products, Inc. makes no warranty with respect thereto and disclaims all liability for reliance therein.

Features / Benefits

- OEM Approved (FCA MS 9680, Rolling, Tapping & Extrusion)
- Extreme pressure additives helps eliminate part gulling and cracking
- Provides excellent lubricating properties that increases life of die tooling and coatings
- Imparts in-process corrosion protection
- Offers Biological control
- Pigment & phosphorous free
- Easily removed with alkaline cleaner
- Parts can be welded without prior cleaning

Mix / application & Use

Always add TechDraw FT 406 to water with agitation. Typical dilution range is from 10-20 parts water to 1 part TechDraw FT 406. TechDraw FT 406 can be applied using spray, roll coater, drip or brush applications. Your Fortech Sales Representative will work with you on the proper dilution and mixing approach.

4 **Description:**

TechDraw FT 500 is a heavy-duty, non-chlorinated drawing compound that is formulated to perform a wide range of operations. TechDraw FT 500's extreme pressure additives allows forming in the most severe stamping operations, reducing part galling and cracking while increasing die tooling and coating life. TechDraw FT 500's unique formulation was developed to be used in recirculated systems and thus exhibits excellent biological control, decreasing odor and providing parts and dies with a clean, non-tacky surface. Depending on the substrate and severity of the part produced TechDraw FT 500 can typically be used at a dilution range of 20-10:1. On severe operations TechDraw FT 500 can be diluted up to 5:1. TechDraw FT 500 performs extremely well with in-die or stand alone tapping units and may be used on ferrous and non-ferrous substrates.

This post is also available in: Spanish

Typical Properties (Not Specifications):

Appearance	Clear Amber Oil
ph at 10%	9.35
Density	7.88

Health & Safety

TechDraw FT 500 is available in 55-gallon drums, 330 gallon totes and 5 gallon pails.

Storage And Handling: See Safety Data Sheet Before Use. Use at room temperature. If frozen, allow to thaw completely prior to use. Do not expose to extreme high temperature due to container rupture. Do not pressurize drum or reuse empty container. Follow all safety regulations on label.

Non-Warranty: While the information and recommendations sent forth herein are believed to be accurate as of the date thereof, Fortech Products, Inc. makes no warranty with respect thereto and disclaims all liability for reliance therein.

Features / Benefits

Non-Chlorinated

Extreme pressure additives helps eliminate part galling and cracking

Provides excellent lubricating properties that increases life of die tooling and coatings

Offers superior corrosion protection

May be recirculated

Offers biological control

No Monday morning odor

Keeps parts and dies clean and free of tacky buildups

Works tremendously well with in-die or stand alone tapping units

Mix / application & Use

Always add TechDraw FT 500 to water with agitation. Dilution range is from 5-20 parts water to 1 part TechDraw FT 500. TechDraw FT 500 can be applied using spray, roll coater, drip or brush applications. Your Fortech Customer Sales Representative will work with you on a proper dilution and mixing approach.

5 **Description:**

TechDraw FT 980 SHP is a heavy-duty, straight oil metal forming fluid formulated with hydrotreated heavy naphthenic base stock. The product has a balanced lubricity and EP for use in a variety of forming operations without promoting crack-corrosion because it forms a protective coating on the applied metal surface after processing. The lubricity and EP package includes a combination of ester and EP additive derived from vegetable oil, active and inactive sulfur to produce good part finish and exceptional tool life. TechDraw FT 980 SHP reduces fluid drag out, providing improved operating costs. TechDraw FT 980 SHP has a low odor for ease of use and disposal and does not produce a sticky residue on parts.

Typical Properties (Not Specifications):

Appearance	Clear Amber Oil
Density (lbs/gal)	7.91
Viscosity (cSt at 40°C)	172

Health & Safety

TechDraw FT 980 SHP is available in 55-gallon drums, 330 gallon totes and pails.

Storage And Handling: See Safety Data Sheet Before Use. Use at room temperature. If frozen, allow to thaw completely prior to use. Do not expose to extreme high temperature due to container rupture. Do not pressurize drum or reuse empty container. Follow all safety regulations on label.

Non-Warranty: While the information and recommendations sent forth herein are believed to be accurate as of the date thereof, Fortech Products, Inc. makes no warranty with respect thereto and disclaims all liability for reliance therein.

Features / Benefits

- High lubricant film strength
- Extreme pressure properties
- Designed for heavy duty forming operations
- Enhanced rust protection
- Easily cleaned with an alkaline cleaner
- Mild odor

Mix / application & Use

TechDraw FT 980 SHP is a straight oil and is designed to be used neat. Applications typically consist of spray, roll-coated, brush or dip. Your application method must be designed to fulfill your desired lubricant film thickness. A Fortech Customer Representative will work with your team on a correct usage and application to serve your needs.

6 **Description:**

TechDraw FT 945 is a petroleum oil based metal forming and fine blanking fluid formulated for high strength substrates. TechDraw FT 945's unique formulation of polymeric esters, and extreme pressure chemistry can provide heavy duty lubrication, yet is easily removed with alkaline cleaners where clean surfaces are required in subsequent operations such as welding, coating, and plating. TechDraw FT 945 provides superior performance with both ferrous and non-ferrous metals.

This post is also available in: Spanish

Typical Properties (Not Specifications):

Appearance	Clear Amber Liquid
Specific Gravity @ 60oF, ASTM D-1298	0.92
Pounds Per. Gallon, ASTM D-1298	7.6
Flash Point, C.O.C., ASTM D-92	400 F
Viscosity, cSt. @ 40o C, ASTM D-445	150

Health & Safety

TechDraw FT 945 is available in 55 gallon drums, 275 gallon totes, 330 gallon totes, and bulk tanker truck.

Storage And Handling: See Safety Data Sheet Before Use. Use at room temperature. If frozen, allow to thaw completely prior to use. Do not expose to extreme high temperature due to container rupture. Do not pressurize drum or reuse empty container. Follow all safety regulations on label.

Non-Warranty: While the information and recommendations sent forth herein are believed to be accurate as of the date thereof, Fortech Products, Inc. makes no warranty with respect thereto and disclaims all liability for reliance therein.

Features / Benefits

Performs in heavy-duty operations such as fine blanking and extrusions

Non-Chlorinated

Imparts "In-Process" corrosion protection

Easily removed with alkaline cleaners

Low Odor

Mix / application & Use

TechDraw FT 945 is a non-chlorinated straight oil and is designed to be used neat. Applications typically consist of spray, roll-coated, brush or dip. Your application method must be designed to fulfill your desired lubricant film thickness. A Fortech Customer Representative will work with your team on a correct usage and application to serve your needs.

7 Description:

TechDraw FT 327 is a heavy-duty drawing compound formulated to perform a wide range of drawing and stamping operations. TechDraw FT 327's unique formulation does not contain sulfur or pigments and is easily removed with alkaline cleaners where clean surfaces are required in subsequent operations such as welding. Depending on the substrate and severity of the application TechDraw FT 327 can be used neat in severe operations such as extruding, or diluted 5:1 with water to form a stable emulsion for light stamping.

This post is also available in: Spanish

Typical Properties (Not Specifications):

Appearance	White Opaque Liquid
Density (lbs/gal)	8.35
pH (concentrate)	8.5
Viscosity (cPs)	1600

Health & Safety

TechDraw FT 327 is available in 55 gallon drums, 330 gallon totes, 275 gallon totes, and bulk tanker truck.

Storage And Handling: See Safety Data Sheet Before Use. Use at room temperature. If frozen, allow to thaw completely prior to use. Do not expose to extreme high temperature due to container rupture. Do not pressurize drum or reuse empty container. Follow all safety regulations on label.

Non-Warranty: While the information and recommendations sent forth herein are believed to be accurate as of the date thereof, Fortech Products, Inc. makes no warranty with respect thereto and disclaims all liability for reliance therein.

Features / Benefits

- Imparts in process Corrosion Protection (~30 Days Indoor Storage)
- Pigment Free
- Non-Staining
- Easily Removed

Mix / application & Use

Always add TechDraw FT 327 to water with agitation. Dilution range is from 5-10 parts water to 1 part TechDraw FT 327. TechDraw FT 327 can be applied using spray, roll-coater, drip or brush applications. Your Fortech Customer Sales Representative will work with you on a proper dilution and mixing approach.

8 **Description:**

TechDraw FT 403G is a heavy-duty drawing/fine blanking compound formulated to perform a wide range of operations. TechDraw FT 403G's unique formulation does not contain pigments and is easily removed with alkaline cleaners where clean surfaces are required in subsequent operations such as welding. Depending on the substrate and severity of the application TechDraw FT 403G can be used neat in severe operations such as extruding, or diluted 20:1 with water to form a stable emulsion for light stamping.

This post is also available in: Spanish

Typical Properties (Not Specifications):

Appearance	Clear Amber Oil
Density (lbs/gal)	9.04
pH at 10%	9.9

Health & Safety

TechDraw FT 403G is available in 55-gallon drums, 330 gallon totes and pails.

Storage And Handling: See Safety Data Sheet Before Use. Use at room temperature. If frozen, allow to thaw completely prior to use. Do not expose to extreme high temperature due to container rupture. Do not pressurize drum or reuse empty container. Follow all safety regulations on label.

Non-Warranty: While the information and recommendations sent forth herein are believed to be accurate as of the date thereof, Fortech Products, Inc. makes no warranty with respect thereto and disclaims all liability for reliance therein.

Features / Benefits

- Heavy-duty
- Imparts in-process corrosion protection
- Can run on multiple substrates
- Pigment Free
- Non-Staining
- Easily Removed with alkaline cleaners

Mix / application & Use

Always add TechDraw FT 403G to water with agitation. Dilution range is from 5-20 parts water to 1 part TechDraw FT 403G. TechDraw FT 403G can be applied using spray, roll-coater, drip or brush applications. Your Fortech Customer Sales Representative will work with you on a proper dilution and mixing approach.

9 **Description:**

TechDraw FT 900 is a synthetic, heavy-duty drawing/fine blanking compound formulated to perform a wide range of operations. TechDraw FT 900's unique formulation does not contain oil, sulfur or pigments and is easily removed with alkaline cleaners where clean surfaces are required in subsequent operations such as welding. Depending on the substrate and severity of the application TechDraw FT 900 can be used neat in severe operations such as fine blanking, or diluted 20:1 with water to form a stable emulsion for light stamping.

This post is also available in: Spanish

Typical Properties (Not Specifications):

Appearance	Clear Amber Oil
Density (lbs/gal)	9.8
pH at 10%	9.9

Health & Safety

TechDraw FT 900 is available in 55-gallon drums, 330 gallon totes and pails.

Storage And Handling: See Safety Data Sheet Before Use. Use at room temperature. If frozen, allow to thaw completely prior to use. Do not expose to extreme high temperature due to container rupture. Do not pressurize drum or reuse empty container. Follow all safety regulations on label.

Non-Warranty: While the information and recommendations sent forth herein are believed to be accurate as of the date thereof, Fortech Products, Inc. makes no warranty with respect thereto and disclaims all liability for reliance therein.

Features / Benefits

- Extreme Heavy-Duty Applications
- Imparts In-Process Corrosion Protection
- Pigment, Sulfur and Oil free
- Non-Staining, may be used on multiple substrates
- Can be removed with alkaline cleaners

Mix / application & Use

Always add TechDraw FT 900 to water with agitation. Dilution range is from 5-20 parts water to 1 part TechDraw FT 900 or run neat for heavy duty applications such as fine banking. TechDraw FT 900 can be applied using spray, roll-coater, drip or brush applications. Your Fortech Customer Sales Representative will work with you on a proper dilution and mixing approach.

10 Description:

TechDraw FT 300C is a premium, heavy-duty, synthetic water based metal forming fluid that is optimal for drawing, stamping, and roll-forming of ferrous and non-ferrous alloys. The product has a balanced lubricity, EP, and biocide package for use in a variety of forming operations without promoting crack-corrosion because it forms a protective coating on the applied metal surface after processing; thus, producing good part finish and exceptional tool life. This product combines excellent rust protection with low foaming characteristics and long sump life. It was formulated to reject tramp oil that can cause smoking or misting and premature spoilage of drawing compound. The product is sulfur, triazine (formaldehyde releaser), dicyclohexylamine (DCHA) (secondary amine), and 1,2-Benzisothiazolin-3-one (BIT) free. The low viscosity of TechDraw FT 300C reduces fluid drag out, providing improved operating costs. TechDraw FT 300C has a slight translucent yellow appearance with a low odor for ease of use and disposal and does not produce a sticky residue on parts.

Typical Properties (Not Specifications):

Appearance	Pale orange
Density	1.04@60°F
pH	9.26

Health & Safety

TechDraw FT 300C is available in 55-gallon drums, 330 gallon totes and pails.

Storage And Handling: See Safety Data Sheet Before Use. Use at room temperature. If frozen, allow to thaw completely prior to use. Do not expose to extreme high temperature due to container rupture. Do not pressurize drum or reuse empty container. Follow all safety regulations on label.

Non-Warranty: While the information and recommendations sent forth herein are believed to be accurate as of the date thereof, Fortech Products, Inc. makes no warranty with respect thereto and disclaims all liability for reliance therein.

Features / Benefits

- Provides excellent lubricating properties that protect parts and tooling
- Imparts excellent in-process corrosion protection
- Contains no sulfur, oil or pigment
- Easily cleaned with mild detergents
- Hard water stable
- Non-staining
- Low foaming

Mix / application & Use

Always add TechDraw FT 300C to water with agitation. Dilution range is from 5-10 parts water to 1 part TechDraw FT 300C. TechDraw FT 300C can be applied using spray, roll-coater, drip or brush applications. Your Fortech Customer Sales Representative will work with you on a proper dilution and mixing approach.

11 Description:

TechDraw FT 300 is a premium, heavy-duty, synthetic water based metal forming fluid that is optimal for drawing, stamping, and roll-forming of ferrous and non-ferrous alloys. The product has a balanced lubricity, EP, and biocide package for use in a variety of forming operations without promoting crack-corrosion because it forms a protective coating on the applied metal surface after processing; thus, producing good part finish and exceptional tool life. This product combines excellent rust protection with low foaming characteristics and long sump life. It was formulated to reject tramp oil that can cause smoking or misting and premature spoilage of drawing compound. The product is sulfur, chlorine, triazine (formaldehyde releaser), dicyclohexylamine (DCHA) (secondary amine), and 1,2-Benzisothiazolin-3-one (BIT) free. The low viscosity of TechDraw FT 300 reduces fluid drag out, providing improved operating costs. TechDraw FT 300 has a slight translucent yellow appearance with a low odor for ease of use and disposal and does not produce a sticky residue on parts.

Typical Properties (Not Specifications):

Appearance	Pale orange
Density	1.04@60°F
pH	9.26

Health & Safety

TechDraw FT 300 is available in 55-gallon drums, 330 gallon totes and pails.

Storage And Handling: See Safety Data Sheet Before Use. Use at room temperature. If frozen, allow to thaw completely prior to use. Do not expose to extreme high temperature due to container rupture. Do not pressurize drum or reuse empty container. Follow all safety regulations on label.

Non-Warranty: While the information and recommendations sent forth herein are believed to be accurate as of the date thereof, Fortech Products, Inc. makes no warranty with respect thereto and disclaims all liability for reliance therein.

Features / Benefits

- Provides excellent lubricating properties that protect parts and tooling
- Imparts excellent in-process corrosion protection
- Contains no sulfur, chlorine, oil or pigment
- Easily cleaned with mild detergents
- Hard water stable
- Non-staining
- Low foaming

Mix / application & Use

Always add TechDraw FT 300 to water with agitation. Dilution range is from 5-10 parts water to 1 part TechDraw FT 300. TechDraw FT 300 can be applied using spray, roll-coater, drip or brush applications. Your Fortech Customer Sales Representative will work with you on a proper dilution and mixing approach.

12 Description:

TechDraw FT RA-2 is a synthetic elastomer lubricant used in a variety of applications in the automotive and appliance segments as a mandrel release agent. TechDraw FT RA-2 provides excellent thermal stability through its additive package, while being free of nitrites, chlorinated additives or heavy metals. TechDraw FT RA-2 can be used directly or diluted pending on the application, while being easily removable in water even at room temperature.

Typical Properties (Not Specifications):

Appearance	Hazy light-yellow liquid
Density (g/ml)	1.10 @25C
pH	9.5-11.5
Viscosity	38 – 47 cSt @ 40°C
Water Solubility	Soluble

Health & Safety

TechDraw FT RA-2 is available in 55-gallon drums, 330 gallon totes and pails.

Storage And Handling: See Safety Data Sheet Before Use. Use at room temperature. If frozen, allow to thaw completely prior to use. Do not expose to extreme high temperature due to container rupture. Do not pressurize drum or reuse empty container. Follow all safety regulations on label.

Non-Warranty: While the information and recommendations sent forth herein are believed to be accurate as of the date thereof, Fortech Products, Inc. makes no warranty with respect thereto and disclaims all liability for reliance therein.

Features / Benefits

Excellent thermal stability
Operator friendly, does not produce irritating fumes
Little to no residue, easily cleaned with room temperature water

Mix / application & Use

TechDraw FT RA-2 can be diluted or used in its concentrate form, applied directly to the mandrels. TechDraw FT RA-2 can be applied using spray, dip, rollers or brush applications. Your Fortech Customer Sales Representative will work with you on a proper dilution and application set up.

13 **Description:**

TechDraw FT 400 series is an OEM approved Body-in-White drawing compound. TechDraw FT 400's unique formulation is used where clean surfaces are required for subsequent operations such as welding, painting or plating. TechDraw FT 400's extreme pressure properties will extend die tool and coating life. TechDraw FT 400 can be used neat in severe operations (such as extruding) or diluted up to 20:1 with water for lighter duty operations. OEM approvals run at a dilution range of 5-10%. TechDraw FT 400 may be applied to all coated or non-coated CRS, HRS, HSS, HSLA, SS, Aluminum and Dual Phase substrates.

Typical Properties (Not Specifications):

Appearance	Translucent Amber Oil
Density (lbs/gal)	7.8
pH at 10%	8.5

Health & Safety

TechDraw FT 400 is available in 55-gallon drums, 330 gallon totes and 5 gallon pails.

Storage And Handling: See Safety Data Sheet Before Use. Use at room temperature. If frozen, allow to thaw completely prior to use. Do not expose to extreme high temperature due to container rupture. Do not pressurize drum or reuse empty container. Follow all safety regulations on label.

Non-Warranty: While the information and recommendations sent forth herein are believed to be accurate as of the date thereof, Fortech Products, Inc. makes no warranty with respect thereto and disclaims all liability for reliance therein.

Features / Benefits

OEM Body-in-White approved

Provides excellent lubricating properties that protect parts and tooling

May be applied to all coated or non-coated substrates

Imparts in-process corrosion protection

Non-pigmented, no chlorine or sulfur

Parts can go from stamping to welding or paint pre-treatment without supplemental washing

For ease of mixing and application, TechDraw FT 400 can be offered pre-diluted.

Mix / application & Use

TechDraw FT 400 is OEM approved for use at a range of 5% (19:1 dilution) to 10% (9:1 dilution) concentration. TechDraw FT 400 can be used at higher mix ratios up to 100% concentration for parts that are not Body-in-White. When mixing, add TechDraw FT 400 to water. TechDraw FT 400 will easily emulsify into solution with agitation. Apply to substrate using spray, roll coater, brush, drip or flood methods. A Fortech Sales Representative will work with your team to ensure proper mixing and dilution percentage.

14 Description:

TechDraw FT 925 CHP is a heavy-duty, straight oil metal forming fluid formulated with hydrotreated heavy naphthenic base stock. The product has a balanced lubricity and EP for use in a variety of forming operations without promoting crack-corrosion because it forms a protective coating on the applied metal surface after processing. The lubricity and EP package includes a combination of ester and EP additive derived from chlorine, vegetable oil, active and inactive sulfur to produce good part finish and exceptional tool life. TechDraw FT 925 CHP reduces fluid drag out, providing improved operating costs. TechDraw FT 925 CHP has a low odor for ease of use and disposal and does not produce a sticky residue on parts.

Typical Properties (Not Specifications):

Appearance	Dark Amber Oil
Density (lbs/gal)	8.98
Viscosity (cSt at 40°C)	199

Health & Safety

TechDraw FT 925 CHP is available in 55-gallon drums, 330 gallon totes and pails.

Storage And Handling: See Safety Data Sheet Before Use. Use at room temperature. If frozen, allow to thaw completely prior to use. Do not expose to extreme high temperature due to container rupture. Do not pressurize drum or reuse empty container. Follow all safety regulations on label.

Non-Warranty: While the information and recommendations sent forth herein are believed to be accurate as of the date thereof, Fortech Products, Inc. makes no warranty with respect thereto and disclaims all liability for reliance therein.

Features / Benefits

- High lubricant film strength
- Extreme pressure properties
- Designed for heavy duty Fine Blanking operations
- Enhanced rust protection
- Easily cleaned with an alkaline cleaner
- Mild odor

Mix / application & Use

TechDraw FT 925 CHP is a straight oil and is designed to be used neat. Applications typically consist of spray, roll-coated, brush or dip. Your application method must be designed to fulfill your desired lubricant film thickness. A Fortech Customer Representative will work with your team on a correct usage and application to serve your needs.

15 Description:

TechDraw FT 902 CHP is a heavy-duty, chlorinated, straight oil metal forming fluid formulated with hydrotreated heavy naphthenic base stock. The product has a balanced lubricity and EP for use in a variety of forming operations without promoting crack-corrosion because it forms a protective coating on the applied metal surface after processing. The lubricity and EP package includes a combination of ester and EP additive derived from chlorine, vegetable oil, active and inactive sulfur to produce good part finish and exceptional tool life. TechDraw FT 902 CHP reduces fluid drag out, providing improved operating costs. TechDraw FT 902 CHP has a low odor for ease of use and disposal and does not produce a sticky residue on parts.

Typical Properties (Not Specifications):

Appearance	Dark Amber Oil
Density (lbs/gal)	7.88
Viscosity (cSt at 40°C)	125

Health & Safety

TechDraw FT 902 CHP is available in 55-gallon drums, 330 gallon totes and pails.

Storage And Handling: See Safety Data Sheet Before Use. Use at room temperature. If frozen, allow to thaw completely prior to use. Do not expose to extreme high temperature due to container rupture. Do not pressurize drum or reuse empty container. Follow all safety regulations on label.

Non-Warranty: While the information and recommendations sent forth herein are believed to be accurate as of the date thereof, Fortech Products, Inc. makes no warranty with respect thereto and disclaims all liability for reliance therein.

Features / Benefits

- High lubricant film strength
- Extreme pressure properties
- Designed for heavy duty forming operations
- Enhanced rust protection
- Easily cleaned with an alkaline cleaner
- Mild odor

Mix / application & Use

TechDraw FT 902 CHP is a straight oil and is designed to be used neat. Applications typically consist of spray, roll-coated, brush or dip. Your application method must be designed to fulfill your desired lubricant film thickness. A Fortech Customer Representative will work with your team on a correct usage and application to serve your needs.

16 Description:

Hi-Lite Vanishing Oil is a solvent-based lubricant that is applied to Body-in-White panels by placing a thin film that facilitates a bright surface exposing any surface finish defects. Hi-Lite will evaporate from the panel shortly after application, providing the panel with a clean, dry surface.

This post is also available in: Spanish

Typical Properties (Not Specifications):

Appearance	Transparent Water White
Specific Gravity @ 60oF, ASTM D-1298	0.81
Pounds Per. Gallon, ASTM D-1298	6.72
Flash Point, ASTM D-93	~230°F
Viscosity, SSU @ 100°F, ASTM D-445	~2 cSt

Health & Safety

Hi-Lite Vanishing Oil is available in 55-gallon drums, 330 gallon totes and 5 gallon pails.

Storage And Handling: See Safety Data Sheet Before Use. Use at room temperature. If frozen, allow to thaw completely prior to use. Do not expose to extreme high temperature due to container rupture. Do not pressurize drum or reuse empty container. Follow all safety regulations on label.

Non-Warranty: While the information and recommendations sent forth herein are believed to be accurate as of the date thereof, Fortech Products, Inc. makes no warranty with respect thereto and disclaims all liability for reliance therein.

Features / Benefits

- Non-Staining
- Easily Applied
- Easily Removed

17 Description:

TechDraw FT 410VL Vanishing Oil is a solvent-based lubricant with an additional lubricant additive that imparts a thin, imperceptible film of lubricant that facilitates a clean die release on both thin sheet and roll stock. The product may be applied by brush, roller, spray, dip tank, slush or flow coat and generally dries in one to four hours depending on film thickness.

Typical Properties (Not Specifications):

Appearance	Clear Liquid
Specific Gravity @ 60oF, ASTM D-1298	0.8
Pounds Per. Gallon, ASTM D-1298	6.67@60°F
Flash Point, ASTM D-93	>83C

Health & Safety

TechDraw FT 410VL Vanishing Oil is available in 55-gallon drums, 330 gallon totes and 5 gallon pails.

Storage And Handling: See Safety Data Sheet Before Use. Use at room temperature. If frozen, allow to thaw completely prior to use. Do not expose to extreme high temperature due to container rupture. Do not pressurize drum or reuse empty container. Follow all safety regulations on label.

Non-Warranty: While the information and recommendations sent forth herein are believed to be accurate as of the date thereof, Fortech Products, Inc. makes no warranty with respect thereto and disclaims all liability for reliance therein.

Features / Benefits

- Non-Staining
- Easily Applied
- Easily Removed
- Additional Lubrication

18 Description:

TechDraw FT 413VL Vanishing Oil is a solvent-based lubricant with an additional lubricant additive that imparts a thin, imperceptible film of lubricant that facilitates a clean die release on both thin sheet and roll stock. The product may be applied by brush, roller, spray, dip tank, slush or flow coat and generally dries in one to four hours depending on film thickness.

Typical Properties (Not Specifications):

Appearance	Clear Liquid
Specific Gravity @ 60oF, ASTM D-1298	0.76
Pounds Per. Gallon, ASTM D-1298	6.5 @ 60°F
Flash Point, ASTM D-93	>130°F

Health & Safety

TechDraw FT 413VL Vanishing Oil is available in 55-gallon drums, 330 gallon totes and 5 gallon pails.

Storage And Handling: See Safety Data Sheet Before Use. Use at room temperature. If frozen, allow to thaw completely prior to use. Do not expose to extreme high temperature due to container rupture. Do not pressurize drum or reuse empty container. Follow all safety regulations on label.

Non-Warranty: While the information and recommendations sent forth herein are believed to be accurate as of the date thereof, Fortech Products, Inc. makes no warranty with respect thereto and disclaims all liability for reliance therein.

Features / Benefits

- Non-Staining
- Easily Applied
- Easily Removed
- Additional Lubrication

19 Description:

TechDraw FT 910 LC is a medium to heavy-duty chlorinated petroleum-based metal forming lubricant. The highly compounded formulation provides superior performance on stainless steel, hastelloy, alloy steels, and high strength ferrous metals for both drawing and stamping operations. TechDraw FT 910 LC is designed for fine blanking as well as multi-stage forming, drawing and deep drawing. TechDraw FT 910 LC exhibits enhanced rust preventative properties for more demanding environments.

Typical Properties (Not Specifications):

Appearance	Clear Amber Oil
Density	0.98@60°F
Viscosity (cSt at 40°C)	80-110

Health & Safety

TechDraw FT 910 LC is available in 55-gallon drums, 330 gallon totes and pails.

Storage And Handling: See Safety Data Sheet Before Use. Use at room temperature. If frozen, allow to thaw completely prior to use. Do not expose to extreme high temperature due to container rupture. Do not pressurize drum or reuse empty container. Follow all safety regulations on label.

Non-Warranty: While the information and recommendations sent forth herein are believed to be accurate as of the date thereof, Fortech Products, Inc. makes no warranty with respect thereto and disclaims all liability for reliance therein.

Features / Benefits

- High lubricant film strength
- Extreme pressure properties including Chlorine and Sulfur
- Designed for medium to heavy duty Fine Blanking operations
- Enhanced rust protection
- Easily cleaned with an alkaline cleaner

Mix / application & Use

TechDraw FT 910 LC is a straight oil and is designed to be used neat. Applications typically consist of spray, roll-coated, brush or dip. Your application method must be designed to fulfill your desired lubricant film thickness. A Fortech Customer Representative will work with your team on a correct usage and application to serve your needs.

20 Description:

TechKleen FT170 is a versatile, highly concentrated, hard-water stable, multi-purpose, mildly alkaline cleaner. The product's unique formulation can be diluted to desired concentration in water to clean a myriad of soils and surfaces such as steel, aluminum, brick, ceramic tile and wood flooring. TechKleen FT170 is extremely low-foaming to non-foaming, making it the recommended product for high pressure and spray systems.

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Typical Properties (Not Specifications):

Appearance	Clear Liquid
Density (lbs/gal)	8.84
pH Neat	9.72
Odor	Mild

Health & Safety

TechKleen FT170 is available in pails, 55 gallon drums, 275 gallon totes and 330 gallon totes.

Storage And Handling: See Safety Data Sheet Before Use. Use at room temperature. If frozen, allow to thaw completely prior to use. Do not expose to extreme high temperature due to container rupture. Do not pressurize drum or reuse empty container. Follow all safety regulations on label.

Non-Warranty: While the information and recommendations sent forth herein are believed to be accurate as of the date thereof, Fortech Products, Inc. makes no warranty with respect thereto and disclaims all liability for reliance therein.

Mix / application & Use

Recommended Uses

- Automatic Floor Scrubbers 50:1
- General Maintenance 40:1
- Spay cleaning systems 30:1
- Machine Cleaner/Degreaser 5:1
- Conveyors 10:1

21 Description:

TechKleen FT175 is a versatile, highly concentrated, hard-water stable, multi-purpose liquid mildly alkaline cleaner. The product's unique formulation can be diluted to desired concentration in water to clean a myriad of soils and surfaces such as steel, aluminum, brick, ceramic tile, wood flooring. TechKleen FT175 is extremely low foaming to non-foaming making it the recommended product for high pressure and spray systems.

This post is also available in: Spanish

Typical Properties (Not Specifications):

Appearance	Clear Liquid
Density (lbs/gal)	9.3
pH Neat	10
Odor	Mild

Health & Safety

TechKleen FT175 is available in pails, 55 gallon drums, 275 gallon totes and 330 gallon totes.

Storage And Handling: See Safety Data Sheet Before Use. Use at room temperature. If frozen, allow to thaw completely prior to use. Do not expose to extreme high temperature due to container rupture. Do not pressurize drum or reuse empty container. Follow all safety regulations on label.

Non-Warranty: While the information and recommendations sent forth herein are believed to be accurate as of the date thereof, Fortech Products, Inc. makes no warranty with respect thereto and disclaims all liability for reliance therein.

Mix / application & Use

Recommended Uses

- Automatic Floor Scrubbers 50:1
- General Maintenance 40:1
- Spay cleaning systems 30:1
- Machine Cleaner/Degreaser 5:1
- Conveyors 10:1

22 Description:

TechDraw FT 410VL Vanishing Oil is a solvent-based lubricant with an additional lubricant additive that imparts a thin, imperceptible film of lubricant that facilitates a clean die release on both thin sheet and roll stock. The product may be applied by brush, roller, spray, dip tank, slush or flow coat and generally dries in one to four hours depending on film thickness.

Typical Properties (Not Specifications):

Appearance	Clear Liquid
Specific Gravity @ 60oF, ASTM D-1298	0.8
Pounds Per. Gallon, ASTM D-1298	6.67@60°F
Flash Point, ASTM D-93	>83C

Health & Safety

TechDraw FT 410VL Vanishing Oil is available in 55-gallon drums, 330 gallon totes and 5 gallon pails.

Storage And Handling: See Safety Data Sheet Before Use. Use at room temperature. If frozen, allow to thaw completely prior to use. Do not expose to extreme high temperature due to container rupture. Do not pressurize drum or reuse empty container. Follow all safety regulations on label.

Non-Warranty: While the information and recommendations sent forth herein are believed to be accurate as of the date thereof, Fortech Products, Inc. makes no warranty with respect thereto and disclaims all liability for reliance therein.

Features / Benefits

- Non-Staining
- Easily Applied
- Easily Removed
- Additional Lubrication

23 Description:

TechDraw FT HF-09 is a metal forming fluid that is optimal for hydroforming and tube bending of ferrous and non-ferrous alloys. The product has a balanced lubricity for use in a variety of forming operations without promoting crack-corrosion because it forms a high strength protective film on the applied metal surface; thus, producing good part finish and exceptional tool life. The product is chlorine, sulfur, triazine (formaldehyde releaser), dicyclohexylamine (DCHA) (secondary amine) free.

Typical Properties (Not Specifications):

Appearance	Amber translucent liquid
Density	0.93@60°F
pH	9.26

Health & Safety

TechDraw FT HF-09 is available in 55-gallon drums, 330 gallon totes and pails.

Storage And Handling: See Safety Data Sheet Before Use. Use at room temperature. If frozen, allow 1 thaw completely prior to use. Do not expose to extreme high temperature due to container rupture. Do not pressurize drum or reuse empty container. Follow all safety regulations on label.

Non-Warranty: While the information and recommendations sent forth herein are believed to be accurate as of the date thereof, Fortech Products, Inc. makes no warranty with respect thereto and disclaims all liability for reliance therein.

Features / Benefits

- Provides excellent lubricating properties that protect parts and tooling
- Imparts excellent in-process corrosion protection
- Contains no chlorine, sulfur, oil or pigment
- Easily cleaned with mild detergents

Mix / application & Use

TechDraw FT HF-09 is pre-emulsified, ready-to-use. TechDraw FT HF-09 can be applied using spray, drip or brush applications. Your Fortech Customer Sales Representative will work with you on a proper application set up.