

Drawing and Stamping Compounds



Shaping metal requires premium chemistry to assure reproducible results day in and day out. The proper balance of lubricity, viscosity, and corrosion resistance achieved by a systematic approach assures clean dies and reduced maintenance while producing precise parts with exact tolerances. Chemetall is proud to supply a complete line of premium drawing and stamping compounds, including full synthetic, emulsion forming, and straight oil fluids designed to improve the quality of your production while reducing the cost of the operation.

Advantages of Chemetall Forming Technology

- ⊕ Superior lubricity.
- ⊕ Exceptional detergency for cleanliness in operation and subsequent cleaning processes.
- ⊕ Multi-metal compatible.
- ⊕ Outstanding corrosion resistance.
- ⊕ Versatile product line: light to heavy duty operations.

BASF
We create chemistry

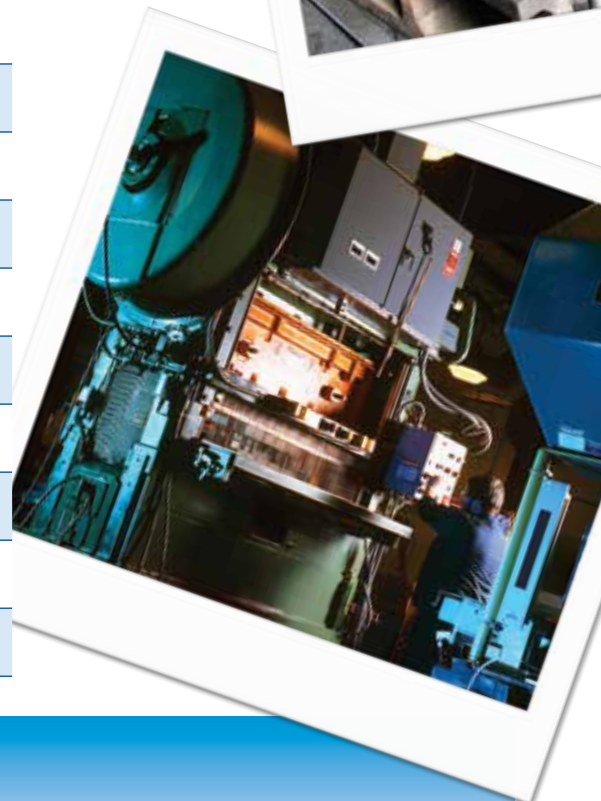
Chemetall
expect more ⊕

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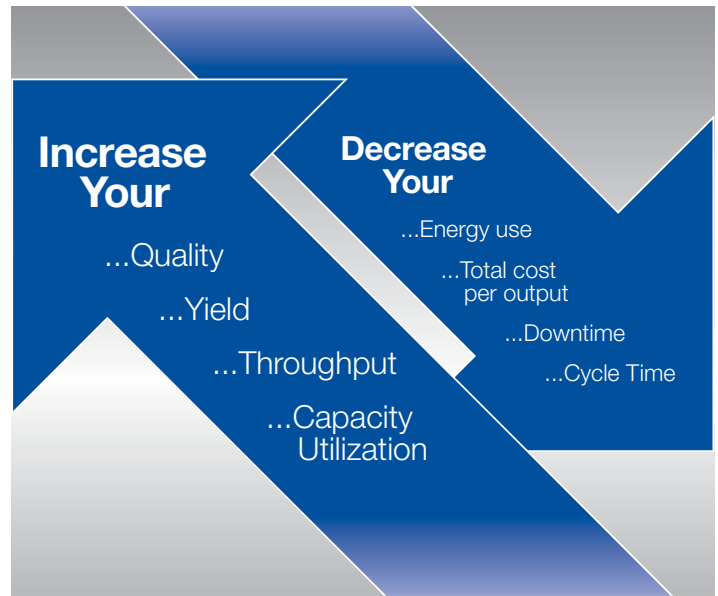
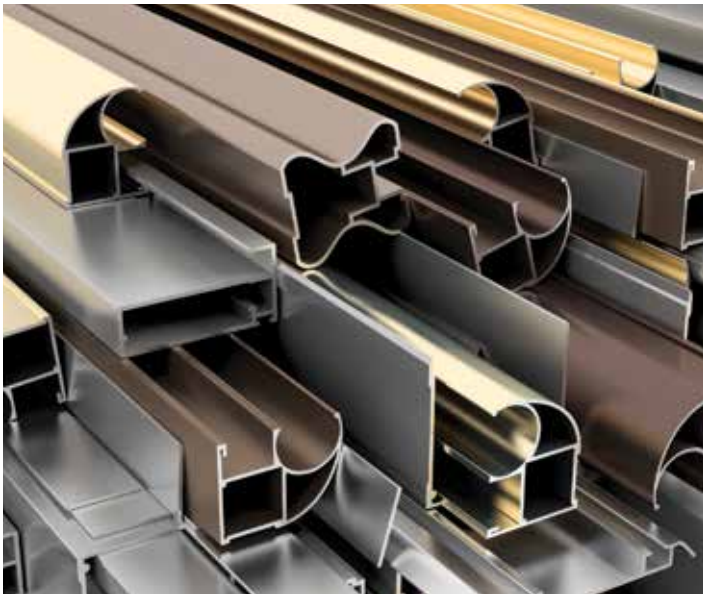
Product	Characteristics			
	Chemistry Type	Lubricity Agent	Viscosity (centiStokes @ 40°C)	Typical Concentrations
Gardolube® O 35 SCP	Straight oil	Chlorine, oil, and sulfur	35	100%
Gardolube O 85 CP	Straight oil	Chlorine and oil	85	100%
Gardolube O 100 SP	Straight oil	Esters, phosphorous, and sulfur	100	100%
Gardolube O 150 P	Straight oil	Esters and phosphorous	150	100%
Gardolube O 200 CP	Straight oil	Chlorine	200	100%
Gardolube O 280 SP	Straight oil	Esters, phosphorous, and sulfur	280	100%
Gardolube O 1700 CP	Straight oil	Chlorine and oil	1700	100%
Gardolube V 1	Vanishing oil	Sulfur	Very low	100%
Gardolube V 2	Vanishing oil	—	Very low	100%
Gardolube V 3	Vanishing oil	Stearate	Very low	100%
Gardolube V 4	Vanishing oil	Stearate	Very low	100%
Gardolube W 38023	Macro-emulsion	Fatty acid soaps	Low, varies	5–25%
Gardolube W 38036	Emulsion	Fatty acid soaps	Low, varies	10–100%
Gardolube W 38066 CP	Emulsion	Chlorine	Low, varies	10–50%
Gardolube W 38067 CP	Emulsion	Chlorine and oil	Low, varies	10–100%
Gardolube W 38074 CP	Emulsion	Chlorine	Low, varies	10–50%
Gardolube W 38080 SCP	Macro-emulsion	Chlorine, oil, sulfur, and vegetable esters	Low, varies	5–25%
Gardolube W 38502	Preformed synthetic emulsion	Surfactants and vegetable esters	Low, varies	7–100%
Gardolube W 38550	Water-soluble synthetic	Esters and surfactants	Low, varies	10–100%
Gardolube W 38560*	Water-soluble synthetic	Esters and surfactants	Low, varies	10–100%
Tech Cool® 35049 CP	Macro-emulsion	Chlorine and oil	Low, varies	2.5–10%

*Not for sale in Canada.

	Metals					Primary Applications				Severity
	Steel	Aluminum	Galvanized	Copper	Bronze	Spray	Roll Coat	Dip	Flood	
	+	+	+			+	+	+	+	Medium
	+	+		+	+	+	+	+	+	Medium to heavy-duty
	+	+	+			+	+	+	+	Very heavy-duty
	+	+	+			+	+	+	+	Medium to heavy-duty
	+						+	+	+	Very heavy-duty
	+	+	+			+	+	+	+	Heavy-duty
	+						+	+		Very heavy-duty
	+	+		+	+	+		+		Medium to heavy-duty
	+	+	+	+	+	+	+	+		Light-duty
	+	+	+	+	+	+	+	+		Light-duty
	+	+	+	+	+	+	+	+		Light-duty
	+	+		+	+	+	+		+	Rolling oil
	+	+	+	+	+	+	+	+	+	Heavy-duty
	+	+				+	+	+	+	Medium to heavy-duty
	+	+	+	+	+	+	+	+	+	Heavy-duty
	+	+	+	+	+		+	+		Heavy-duty
	+	+	+	+	+	+	+	+		Heavy-duty
	+	+	+			+	+	+	+	Medium to heavy-duty
	+	+	+	+		+	+	+	+	Light to medium-duty
	+	+	+			+	+	+	+	Medium-duty
	+					+	+	+		Medium to heavy-duty



Cut it. Clean it. Coat it. Control it. Conserve it.® with us!



Our focus is you, our metalworking customer!

At Chemetall, we are dedicated, so you can expect more. Our global specialists are locally available. Our experts provide focused, passionate, and accountable support. You can expect the highest quality from our integrated portfolio of innovative products. Our labs are fast and accurate. We will collaborate with you to increase the efficiency of your process performance.

We are the Surface Treatment global business unit of the Coatings division of BASF, operating under the Chemetall brand, a leading supplier of applied surface treatments and services for metal, plastic, and glass substrates in a vast range of industries and end markets. As process innovators, fully dedicated to your success, we develop, manufacture, and provide best-in-class technologies, systems, and expertise.

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