

Metalworking fluids – copper wire drawing

ISO L-MAB

FAMCUPROL® 10 N

FAMCUPROL® 10 N is mineral water-soluble mineral oil based metalworking fluid with emulsifiers and suitable additives which provide excellent anticorrosion protection, lubricating properties with reduced friction and biostability ensures long-lasting application.

ADVANTAGES

- Excellent lubricating and anticorrosion properties,
- High precision and quality of treated surfaces,
- Long life,
- Mild odour,
- High microbiological resistance,
- Excellent stability and anticorrosion protection in hard water,
- Low foaming in soft water,
- Economical,
- It does not irritate or dry out the skin.

QUALITY LEVEL

ISO 6743-7, L-MAB,
ISO/TS 12927

APPLICATION

FAMCUPROL® 10 N is recommended for rough, medium and fine drawing of copper and brass wire at drawing speeds up to 30 m/s. In the process of drawing on the matrix, there is no adhesion of copper particles, so there is no unwanted reduction of wire diameter and the interior of the machine remains clean. The surface of the treated wire is light colored, smooth and of prescribed quality.

RECOMMENDED APPLICATION CONCENTRATIONS

Super fine drawing for the inlet diameter 0,4 - 0,6 mm	2 - 3%
Fine drawing for the inlet diameter 1,2 - 2,6 mm	4 - 6%
Medium drawing for the inlet diameter 2,4 - 6,0 mm	6 - 8%
Rough drawing for the inlet diameter 6,0 - 8,0 mm	8 - 10%

ADDITIVE CONTENT

Oil type and content:		Mineral oil (max 40%)				
Additive content						
EP	AW	Esters	Amines	Chlorine	Boron	Nitrites
-	+	+	+	-	-	-
Stability in hard water		20°dH (360 ppm CaCO ₃)				

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TYPICAL CHARACTERISTICS

CONCENTRATE			
CHARACTERISTICS	METHOD	UNITS	VALUE
Appearance	visual	-	clear
Density at 20°C	EN ISO 3675	g/ml	0,930
Kinematic viscosity at 40°C	ISO 3104	mm ² /s	35
EMULSION			
CHARACTERISTICS	METHOD	UNITS	VALUE
Appearance	visual	-	milky
pH value at 4% concentration	ISO 4316	-	9,3
Corrosion on grey iron (shavings/paper) 4%	DIN 51361/2	degree	0/0
Cu corrosion (3h, 50°C) 4%	EN ISO 2160	-	1a
Factor for refractometer		1,01	

Friction coefficient in the cutting zone: $\mu = 0,105 - 0,125$

STORAGE

Store in covered area. If stored outdoors, it is necessary to place the drums in a horizontal position to prevent the accumulation of water on the surface of the drum. Do not store at elevated temperatures or in locations exposed to direct sunlight, nor at temperatures below 0°C.

All necessary instructions can be found in the product SDS. It contains the details of possible hazards, warnings and first aid measures, as well as the impact on the environment and the necessary measures for the storage and handling.

PACKING

Plastic containers of 20 L and tin drums of 180 kg.

Data are orientational, manufacturer reserves the right to make changes in order to improve product quality.