

Oil for metal processing by deformation – deep drawing

ISO L-MHE

PRES® 509 EP

PRES® 509 SB

PRES® 509 EP / 509 SB is inactive emulsifiable oil produced from refined mineral oil. It contains high-pressure (EP) additives, corrosion inhibitors, anti-wear (AW) additives for deep drawing.

ADVANTAGES

- Easy to apply,
- Good adhesion to metal surfaces,
- Good shear resistance,
- Good degreasing after long storage of items,
- Good protection against corrosion,
- It emulsifies in water creating pseudoemulsion,
- Blanks welding is possible without previous degreasing.

QUALITY LEVEL

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

APPLICATION

PRES® 509 EP / 509 SB:

- In complex operations of deep drawing and drawing down of steel and brass sheets of different thickness,
- In car industry it is used in making vehicle chassis blanks, fuel reservoirs, oil baths, cylinder head covers in internal combustion engines, wheel rims of the vehicles,
- For deep drawing of the household appliances parts, containers, bath tubs, boilers and other,
- It can be used in concentrate form or diluted as pseudoemulsion, i.e. diluted with other oils, even with lamp oil in case of necessity during operation with sliding brake,
- For smaller steel thickness pseudoemulsion is used, most often at a concentration of 30-50%, water is gradually added into oil with intense stirring up to the desired concentration,
- It is applied by brush, sponge, roller or by spray gun to treated objects,
- At the end, it is removed from the blanks by water solution of industrial washing products and by organic solvents.

ADDITIVE CONTENT

Esters	Sulphur		P	K	Na	Zn	Cl
	active	inactive					
+	-	+	+	+	+	+	-

TYPICAL CHARACTERISTICS

CHARACTERISTICS	UNITS	PRES® 509 EP	PRES® 509 SB	METHODS
Appearance	-	clear	clear	visual
Density at 15°C	g/ml	0,960	0,950	EN ISO 3675
Kinematic viscosity at 40°C	mm²/s	170	140	ISO 3104
Flash point	°C	min 180	min 180	EN ISO 2592
Copper corrosion (100°C/3h)	degree	1a	1a	EN ISO 2160
Corrosion on steel	-	no	no	ISO 7120
Appearance of 50% pseudoemulsion	-	milky	milky	visual

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 the 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 pails of 20 L, tin drums of 180 kg and plastic container of 850 kg.

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

