

# MAK FORM CB

High quality forming oil for stamping application

MAK Form CB has been specially designed for stamping application. It is blended from highly refined, hydro-processed base stocks and multifunctional additives. Select additive system impart good antiwear and inactive type extreme pressure characteristics. Excellent load carrying ability of can withstand high and shock load. The oil allows easy cleaning of the work piece before it is further processed. The chosen additive system ensures better surface finish, extended die life and reduction in oil consumption. It also provides rust and corrosion protection to the metal. The formulation is based on non-active chemistry.

### Applications:

MAK Form CB is a neat stamping oil for all grades of steel. This low viscosity oil is recommended for car or cab body drawing applications. It is suitable for non-ferrous metals also.

Recommended Use	Cast Iron	Alloy Steel	Carbon Steel	Al. Alloy	Yellow Metals
Forging	--	--	--	--	--
Drawing	--	√√	√√	√	√

√√ Main applications, √ Check with supplier

### Performance/ Benefits:

**Outstanding Thermal and Oxidation Resistance** – prevents the formation of sludge and residue. Enhances the life and reduces the cost of operation.

**Excellent EP and Antiwear properties** – inactive sulphur provides excellent ability to withstand higher loads and shock loads encountered in the stamping applications. It provides protection to die and also ensures superior surface finish to the job.

**Good Surface Finish** – superior quality oiliness and wear protection additives along with the ability to block environment moisture provide very good surface finish.

**Excellent Lubricity** – contains fatty oil to provide excellent lubricity and to reduce friction. It improves the surface finish and extends tool life.

**Low Deposit Formation** – leaves little or no deposit on the work piece and the die. Ensures dimensional geometry and cleaner work piece.

### Specification:

- Proprietary Grade

### Typical Physico-Chemical Data: MAK Form CB

Characteristics	Method	Value
Appearance	Visual	Clear & Bright
Density, g/cc @15°C	ASTM D1298	0.864
Copper Corrosion, 100°C, 3 hrs.	ASTM D130	1a
Flash Point, COC, °C	ASTM D92	246
Kinematic Viscosity @40°C, cSt	ASTM D445	62.5
Kinematic Viscosity @100°C, cSt	ASTM D445	9.29
Viscosity Index	ASTM D2270	128
Weld Load, kg	ASTM D2783	300

### Additive:

Ester	Fatty Oil	Zinc	Sulphur	EP	Phosphorus
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### Storage & Handling:

The product should be stored inside. Keep it properly sealed to avoid contamination. Avoid freezing. Shelf life is 3 yrs. under protected storage conditions.

### Health & Safety:

It is unlikely to be hazardous when properly used in recommended applications. Contamination of the oil from other oils, greases, chemicals, dirty water etc. can occur during the use. It should be avoided. Regular monitoring of the in-use product is recommended.