



## DURADRAW 305 SOLUBLE OIL DRAWING FLUID

### PRODUCT DESCRIPTION

Drawing Fluid 305 is an extra heavy-duty chlorinated high performance, water dilutable soluble oil for deep drawing, stamping, punching, and blanking applications. Provides exceptional extreme pressure and anti-weld characteristics. Use on steel and stainless steel.

Parts should be cleaned and coated with a rust preventative to prevent rusting.

### BENEFITS

- Formulated for the most severe forming applications.
- High film strength reduces die marks, scoring and galling on many draws
- Resists rancidity and tolerates hard water for longer sump life in recirculating systems
- Flexible – excellent for use in deep drawing and heavy punching operations, or for light and medium-duty forming by diluting further with water

### APPLICATION

**Do not add water to Drawing Fluid 305.** Always add Drawing Fluid 305 to water and mix thoroughly to prevent an inverse emulsion from occurring. Drawing Fluid 305 is an extra heavy duty concentrate liquid. Pre-blend mechanically for best results.

### CLEANABILITY

Remove from parts with an alkaline parts cleaner like Dura-Klean NRC.

### RECOMMENDED CONCENTRATIONS

Drawing & Stamping	Dilution
Light	10 to 20 to 1
Medium	5 to 10 to 1
Heavy	1 to 5 to 1
Extra Heavy	Neat to 5 to 1

### TYPICAL PHYSICAL PROPERTIES

Appearance (undiluted) (Diluted)	Liquid, clear/dark Liquid, milky
Odor	Mild, chemical
Pounds per Gallon	8.38
pH (10:1 mix by volume with water)	9.2
Flash point	380°F
Residue	Liquid film
Effect of freeze-thaw cycle	Stable
Sulfur, mercury, phenols, nitrites, nitrates, DEA,	None

### TOXICITY & PRECAUTIONS IN HANDLING

Drawing Fluid 305 is safe to handle in concentrated or diluted form. Keep concentrate away from sparks and open flame. Exercise care consistent with good industrial practices. Adhere to prevailing OSHA safety regulations, guidelines and/or procedures for this class of product. Refer to Drawing Fluid 305 MSDS for additional information. Material Safety Data Sheet for additional information. MSDS can be requested by email to: [CustomerService@FalconIndustrialinc.com](mailto:CustomerService@FalconIndustrialinc.com)

### FOR INDUSTRIAL USE ONLY

#### AVAILABILITY

- 5 gallon pails
- 55 gallon drums
- Tote Tanks
- Bulk shipments