



HD 1100-83

Severe-Duty Soluble Oil Stamping Fluid

FEATURES

- Excellent Lubricity
- Water-Soluble
- Good corrosion protection
- Stands up well to extreme pressure applications
- Compatible with carbide tooling

APPLICATIONS

- Heavy & Severe-Duty Stamping Applications including:
- Excellent for all heavy-gauge components
- Hole punching through SS, UHSS, etc.
- Please call for consultation on specific applications

DIRECTIONS

Dilute Metal Mates HD with water to suit the specific application.

Heavy-Duty: 3:1 to 8:1 (25-11%)

NOTE: These dilution ratios should only be used as general guidelines and are not exact specifications. Please contact your Metal Mates Regional Sales Manager for an application specific recommendation. Slowly add water to lubricant while mixing. Water quality enhances the performance of all water-dilutable lubricants.

HANDLING

Use appropriate safety equipment. Use with adequate ventilation. Avoid contact with eyes, skin and clothing. Keep away from extreme heat. Keep container closed when not in use.

STORAGE

Store away from extreme heat, flame, or ignition sources. Pressure buildup may occur due to heat exposure or temperature change. Release pressure by slowly opening container.

DISPOSAL

Absorb with suitable material and follow procedures shown on SDS. Dispose of in a manner that is recommended by local, state, provincial, and federal laws and regulations.

AVAILABLE PRODUCTS

Part No.	Net Contents	Container Type	Units/Case
MM3202	5 gal	pail	1
MM3203	55 gal	drum	1
MM3206	330 gal	tote	1



PROPERTIES

Odor	typical, mild
pH Value	8.7-9.7
Specific Gravity	1.03
Flash Point	>200F (>93C)
Boiling Point / Range	212F (100C)
Vapor Pressure	<1
Vapor Density	Heavier than air
Prop 65 Warning	No
Total Chlorine	Y
Refractometer Readings	7-24 RI
Dilution Ratio	Typical Dilution: 3:1 to 8:1 (25 to 11%)



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