



HDP 970-40

Severe-Duty Stamping Lubricant

Metal Mates HDP 970-40 is a severe-duty lubricant for stamping, forming, drawing, piercing, punching, and flanging of heavy gauge steel, ultra high strength steel, or stainless steel.

This semi-synthetic lubricant combines extreme pressure, barrier, and anti-wear additives in a formulation that is ideal for difficult forming, stamping, and drawing operations. HDP offers all the advantages of soluble oils and synthetics without their disadvantages in heavy-duty applications. Provides excellent physical and chemical lubricity without leaving a heavy oil residue (unlike soluble oils and synthetics). Won't turn sticky or gummy on parts and dies.

Easy clean-up with no pre-weld wash needed. Recommended for use with 0.200" - 0.330" thick cold-rolled, electro-galvanized (galvanneal), hot-dip galvanized, stainless, high-strength steel (HSS), and ultra-high-strength steels (UHSS). Can be diluted for use with materials down to 0.035"

FEATURES

- No cleaning required before welding
- Improves die life
- Excellent rust protection
- Reduces scoring and cracking on UHSS & other materials
- No sticky residue
- Won't build up on dies
- Cleaner, safer work environment

APPLICATIONS

- Heavy & Severe-Duty Stamping including:
- Heavy gauge steel
- Ultra high strength steel
- Stainless steel
- Good on multiple substrates, please call for consultation on specific applications.

DIRECTIONS

Dilute Metal Mates HDP with water to suit the specific application. Slowly add water to lubricant while mixing. Water quality enhances the performance of all water-dilutable lubricants.



PROPERTIES

Appearance / Physical State	liquid
Odor	mild odor
pH Value	7.7-8.7
Specific Gravity	1.03
Flash Point	>200F (>93C)
Boiling Point / Range	212F (100C)
Vapor Density	Heavier than air
Refractometer Readings	6-10 RI
Prop 65 Warning	No
Vapor Pressure	<1
Dilution Ratio	Typical Dilution: 3:1 to 6:1 (33-17%)
Total Chlorine	Y



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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.

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

DISPOSAL

Absorb on 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	Color
MM3002	5 gal	pail	1	creamy tan
MM3003	55 gal	drum	1	creamy tan
MM3006	330 gal	tote	1	creamy tan



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