

STRUB Vulcan Estamp CF 9651, 9654, 9658, 9660, 9661 V4, 9661 V5 and 96/100

Chlorine-free fine punching oils, rolling oils

Description

Mineral oil-based special oils with a synergistic highly effective combination of chlorine-free high-performance additives. Due to the viscosity and high-performance additives, STRUB Vulcan Estamp CF 9658 is particularly suitable for processes with high requirements, such as stamping of high-alloy steels as well as material thicknesses up to 15 mm and more.

Application

For fine blanking of steel and high-alloy steels at material thicknesses of approx:

up to 6 mm (STRUB Vulcan Estamp CF 9660) punching parts made of steel for closing technology, also Niro up to 4mm
 up to 8 mm (STRUB Vulcan Estamp CF 96/100) for stamping parts made of C45, C55, C75, Niro
 up to 10 mm (STRUB Vulcan Estamp CF 9651
 up to 15 mm (STRUB Vulcan Estamp CF 9654, CF 9658, CF 9661 V4 and CF 9661 V5)

Features and advantages

- oxidation stable
- low evaporation
- free from solvents, PCBs and other organochlorine compounds

Technical data

| Vulcan Estamp CF | | 9651 | 9654 | 9658 | 9660 | 9661 V4 | 9661 V5 | 96/100 |
|------------------|--------------------|-------|-------|-------|-------|---------|---------|--------|
| Art. No. | | 30095 | 30119 | 30187 | 31385 | 31093 | 32476 | 31553 |
| Color | | brown | brown | brown | brown | brown | brown | brown |
| Density 20° C | g/cm ³ | 1.013 | 1.013 | 1.015 | 1.010 | 1.061 | 1.060 | 1.040 |
| Viscosity 40°C | mm ² /s | 150 | 168 | 185 | 70 | 143 | 115 | 100 |
| Flash point | °C | > 150 | > 150 | >150 | > 150 | > 150 | >150 | > 150 |
| Pour Point | °C | < -10 | < -10 | >-10 | < -10 | < -10 | < -10 | < -10 |

* Highly additive.

Satisfied customers report

60 % higher production capacity of molds with CF 9661 V4

Processing of Material Punching and deep drawing
 Chrome steel and sheet steel up to 4 mm material thickness
Tool Round punches and complete tool sets made of tool steel
Machine Eccentric press 40/70/100 to, deep drawing press 200 to
Result Deep drawing: no scoring on the workpieces, even after 2000 pcs.
 Tool does not need to be repolished. Punching: 30 % significantly higher number of pieces, considerably extended tool life.

The information in this technical data sheet is based on general knowledge and application possibilities. STRUB + Co. AG is not liable for damage resulting from improper use of the products. The industry-standard measurement and production tolerances apply to the specified characteristic. Generally, no legal binding can be derived from these data. Our products are subject to continuous further development. Therefore, STRUB + Co. AG reserves the right to change all technical data in this data sheet at any time and without prior notice.

Transport

ADR/SDR

No dangerous goods

Disposal

LVA VeVA / EAK:

12 01 07

The information in this technical data sheet is based on general knowledge and application possibilities. STRUB + Co. AG is not liable for damage resulting from improper use of the products. The industry-standard measurement and production tolerances apply to the specified characteristic. Generally, no legal binding can be derived from these data. Our products are subject to continuous further development. Therefore, STRUB + Co. AG reserves the right to change all technical data in this data sheet at any time and without prior notice.