



TRU-CHEM
COMPANY, INC.

CHEMICAL PROCESSES FOR INDUSTRY
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T.C. 1886-L Liqui-Draw

DESCRIPTION

T.C. 1886-L is a versatile, liquid drawing compound for deep drawing, stamping, blanking, and other forming operations for all metals. Depending upon application, it may be diluted up to 50% by volume with water. It provides excellent lubrication for working metals, and has fine coolant properties to prevent die galling and metal-to-metal contact. By minimizing die corrosion, T.C. 1886-L increases tool life. Since no gummy residues are formed, dies remain cleaner and require less polishing. If necessary, parts may be easily cleaned before subsequent operations.

Solutions of T.C. 1886-L are easy to prepare and use and will not solidify, gel, or separate upon standing. Readily pourable from the container, the compound will not clog automatic feeding equipment.

CHEMICAL CHARACTERISTICS

Chemical composition	Liquid soaps
Physical form	White liquid
Odor	Bland
Specific gravity	0.970
Bulk density	8.1 lbs/gal at 72°F (972 g/l at 22°C)
Viscosity	Approx. 13,000 cps at 68°F (20°C), Brookfield Spindle 3, 6 rpm
Flash point	None
Foaming tendency	Low
Recommended diluent	Water
Maximum solubility	Complete
Rinseability	Best with hot water
Biodegradable	Yes
Phosphate-free	Yes
Normal operating temperatures	Room temperature
Normal working concentrations	50% by volume to full strength
pH at working concentrations	8.0 at 50% by volume
Effect of working solutions on metals	Applicable on steel, stainless steel, aluminum, zinc, copper and brass; moderate attack on magnesium

APPLICATION PROCEDURE

T.C. 1886-L may be applied full strength to sheet metal through conventional equipment (roller, brush or drip-line). Adjust the applicator to provide a uniform coating. For less difficult operations, dilute up to 50% volume with water. Typical solution concentrations are as follows:

	<u>Aluminum</u>	<u>Copper or Brass</u>	<u>Steel</u>
10% Draw	1 part T.C. 1886-L to 1 part water	1 part T.C. 1886-L to 1 part water	1 – 2 parts T.C. 1886-L to 1 part water
25% Draw	full strength	3 parts T.C. 1886-L to 1 part water	full strength
50% Draw	-----	full strength	-----

Note: The percent of draw is the depth of the draw in relation to the diameter of the blank. If the diameter of the blank is 10 inches, a 50% draw would be a 5-inch cup. **Solution**

Control: There is no titration procedure to T.C. 1886-L

NOTES ON USE

Solutions of T.C. 1886-L should be removed from brass and copper after drawing to prevent discoloration.

Safety and Handling Precautions: T.C. 1886-L is a mildly alkaline material. Direct contact may cause irritation of eyes; prolonged contact may cause irritation of skin. May be harmful if swallowed.

Do not get in eyes; avoid prolonged skin contact. Wash thoroughly after handling. Do not take internally.

First Aid in Case of Contact: For eyes, flush with plenty of water for at least 15 minutes. If eyes are irritated, get medical attention. For skin, flush with water. If swallowed, drink plenty of water. Contact a physician.

KEEP OUT OF REACH OF CHILDREN.

DISPOSAL

Discharge in accordance with federal, state, or local regulations. Since product is normally depleted in use, special treatments are not generally required.

PACKAGING

Packaged in large non-returnable drums of 390 pounds net (176.9 kgs).

SHIPMENT

May be shipped by any common carrier. Freight classification is "Metal Cutting or Drawing Compound."

STORAGE

Suitable for general indoor storage. Keep container closed when not in use. Keep from freezing.

Effects of prolonged storage	None
Effects of high-temperature storage	Becomes slightly less viscous
Effects of low-temperature storage	None (if product freezes, it will return to normal upon thawing with slight loss of viscosity)