

Trust Lamson Oil
Company® to be the source
for your stamping lubricant
needs. When you choose
Lamson, you're getting an

LAMSON

extensive array of quality
products – including the
finest straight oils, speciality
oils, synthetic lubricants,
vanishing oils and water
soluble oils – along with the
expertise to make the
perfect selection for any job.
You trust a lot to a lubricant.
So why not trust the best?

"Formall®" water soluble drawing compounds contain emulsifying agents that allow the oil to form a stable mixture with water. Lamson Formall water soluble oils are divided into two categories, chlorine based lubricants and chlorine free lubricants. Both types of lubricants form a stable mixture with water. Diluting with water reduces the cost and increases the cooling power far beyond that of a straight oil. Since lubricants mix with water, cleanup of the parts and work area are much easier.

CHLORINE BASED

These oils are time proven products that have been in use since the 1940's. They are dependable, economical and the mainstay of water soluble formulas on the market today.

FORMALL 2305

Regular duty water soluble

This standard light-to-medium duty oil can be applied with mixing ratios from 2:1 to 12:1, depending on the job. Ideal for blanking, piercing, punching, and stamping.

FORMALL 2312

Medium duty water soluble

Contains more EP additives to handle medium-duty jobs. Excellent for heavy blanking and piercing as well as stamping and forming. Mixing ratios range from 2:1 up to 12:1.

FORMALL 2325

Heavy duty water soluble

For the heaviest application (including deep drawing work). Contains large quantities of EP additives, but still maintains a stable emulsion that will not separate.

CHLORINE FREE

Lamson Oil's new line of environmentally safe water soluble lubricants contain no chlorine or active sulfur. These oils are specially formulated to resist staining even in high humidity. In most cases parts can go straight to welding or annealing without pre-cleaning.

FORMALL 2280

Light duty water soluble stamping and drawing oil

Our lightest duty compound formulated to replace many light straight oils and vanishing oils in punch press operations.

FORMALL 2281

Medium duty water soluble stamping and drawing oil

Our medium duty compound heavily formulated to replace straight oils in punch press operations. Excellent for conventional stamping and drying operations.

FORMALL 2282

Heavy duty water soluble stamping and drawing oil

Our heaviest duty compound formulated to replace straight oils in punch press operations.

FORMALL 2330

Designed for aluminum stamping and welding

A water-soluble drawing compound that's exceptionally rich in lubricity agents and is specifically formulated for aluminum stamping. Abuse of chlorine and active sulphur means parts can be taken straight from the press to welding or annealing operations.

FORMALL 2340

Laminating lubricant

An oil which allows for dilution ratios up to 20:1. Provides superb lubricity, enabling laminations to come out of the annealing furnace in a loose and free condition.

WATER SOLUBLE OILS
CHLORINE BASED CHLORINE FREE

| | 2305 | 2312 | 2325 | 2330 | 2340 | 2280 | 2281 | 2282 |
|---------------------|------|------|------|------|------|------|------|------|
| METAL | | | | | | | | |
| Steel | A | A | A | A | A | A | A | A |
| Stainless Steel | A | A | A | A | A | A | A | A |
| Aluminum | A | A | A | A | A | A | A | A |
| Brass | A | A | A | A | A | A | A | A |
| Zinc | A | A | A | A | A | A | A | A |
| GAGE | | | | | | | | |
| Light .001 to .040 | A | A | A | A | A | A | A | A |
| Medium .040 to .063 | A | A | A | A | A | A | A | A |
| Heavy .085 to plate | A | A | A | A | A | A | A | A |
| OPERATION | | | | | | | | |
| Blanking | A | A | A | A | A | A | A | A |
| Drawing | A | A | A | A | A | A | A | A |
| Punching | A | A | A | A | A | A | A | A |
| Extruding | A | A | A | A | A | A | A | A |
| Perforating | A | A | A | A | A | A | A | A |
| Swaging | A | A | A | A | A | A | A | A |

WATER SOLUBLE OILS

SYNTHETIC LUBRICANTS

"Lamsyn®" Oil-Free Synthetic Lubricants are true synthetics comprised of specially developed oil free additives. This is a rapidly advancing area of lubrication and Lamson Oil is committed to producing state of the art solutions. We currently offer products that in many cases rival or even surpass the performance of a straight oil. These products minimize disposal problems, are biodegradable, and dilute with water.

CHLORINE BASED

Biodegradable chlorine based synthetics that combine versatility over a wide range of operations with easy disposal.

LAMSYN 4055

Medium duty synthetic lubricant
Covers a wide range of applications from blanking to drawing. Special EP additives lay down a strong polymer film which activates as heat is generated in the die.

LAMSYN 4060

Heavy duty synthetic lubricant
Formulated for use in heavier stamping applications. This product offers lower dilution ratios than our other synthetics because of its heavy-duty nature. For use only on ferrous metals, not recommended for use on carbide dies.

LAMSYN 4074

Heavy duty synthetic lubricant
Recommended for use in blanking heavy material and heavy forming applications.

LAMSYN 4075

Heaviest duty synthetic lubricant
Handles the toughest stamping jobs (including deep draws). Can be used for stamping and forming on metals up to .250 inches thick.

CHLORINE FREE

Our new chlorine free synthetics contain rust inhibitors, lubricity agents, biocides and safe EP additives.

LAMSYN 3000

Moderate duty semi-synthetic lubricant
Formulated for re-circulating and roller application systems. The addition of oil provides greater compatibility with tramp oils.

LAMSYN 4247

Light duty synthetic lubricant
A light duty economical synthetic drawing and blanking compound, this product can be used on light gage materials.

LAMSYN 4250

Medium to heavy duty synthetic lubricant
This product will not turn gummy and cleans up with water. In many cases Lamsyn 4250 will replace a straight oil.

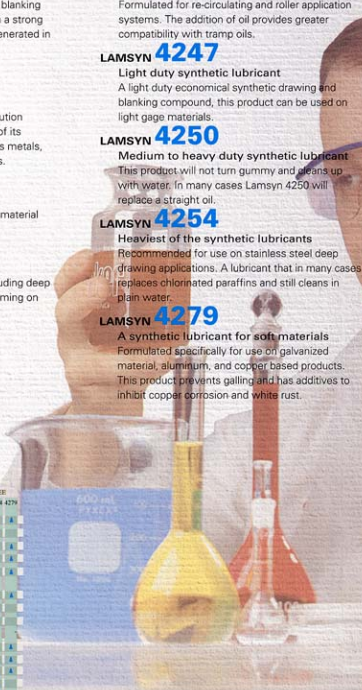
LAMSYN 4254

Heaviest of the synthetic lubricants
Recommended for use on stainless steel deep drawing applications. A lubricant that in many cases replaces chlorinated paraffins and still cleans in plain water.

LAMSYN 4279

A synthetic lubricant for soft materials
Formulated specifically for use on galvanized material, aluminum, and copper based products. This product prevents galling and has additives to inhibit copper corrosion and white rust.

| | SYNTHETIC LUBRICANTS | | | | | | | | |
|---------------------|----------------------|------|------|------|---------------|------|------|------|------|
| | CHLORINE BASED | | | | CHLORINE FREE | | | | |
| | 4055 | 4060 | 4074 | 4075 | 3000 | 4247 | 4250 | 4254 | 4279 |
| METAL | | | | | | | | | |
| Steel | A | A | A | A | A | A | A | A | A |
| Stainless Steel | A | A | A | A | A | A | A | A | A |
| Aluminum | | | | | | | | | A |
| Brass | | | | | | | | | A |
| Zinc | | | | | | | | | A |
| GAGE | | | | | | | | | |
| Light .001 to .040 | A | A | A | A | | | A | A | A |
| Medium .040 to .085 | A | A | A | A | | | A | A | A |
| Heavy .085 to plate | | | | | A | A | | | A |
| OPERATION | | | | | | | | | |
| Blanking | A | A | A | A | A | A | A | A | A |
| Drawing | A | A | A | A | A | A | A | A | A |
| Punching | A | A | A | A | A | A | A | A | A |
| Extending | A | A | A | A | A | A | A | A | A |
| Perforating | A | A | A | A | A | A | A | A | A |
| Swaging | | | | | A | | | | A |



Sometimes it is advantageous to use a lubricant that disappears after it has done its job. These materials leave a light coating of lubricant on the part during processing and then evaporate shortly thereafter. In many cases these lubricants can completely eliminate cleaning operations. Lamson Vanishing Oils will not turn tacky or gummy, have no odor, and are designed to always stay fluid. Recommended for use on virtually all metals.

CHLORINE BASED

These products are formulated to never turn tacky or gummy, to always stay fluid. They can accommodate light stamping.

VANISH 6905

Quick drying vanishing oil

Our quickest drying vanishing oil, this product is a light duty lubricant that evaporates within 15 to 30 minutes. Parts can be packaged soon after they come off the press.

VANISH 6912

Quick drying vanishing oil

Recommended for light to medium duty stamping, piercing, and blanking, this oil completely evaporates within 45 to 85 minutes.

VANISH 6916

Medium drying vanishing oil

This product is formulated with extra EP additives to accommodate slightly heavier jobs. Drying time is between 60 and 120 minutes.

VANISH 6922

Long drying vanishing oil

Our heaviest duty vanishing oil. This product is higher in EP additives, so it takes up to seven days drying time. Not recommended for use when packaging is to be done immediately after parts come off the press.



CHLORINE FREE

Lamson Oil has formulated chlorine and sulphur free vanishing oil compounds. Many products dry completely and are ideal to use when cleaning operations are not desired. Parts can go directly into annealing ovens or welding operations.

VANISH 6830

Quick drying vanishing oil

A compound specifically formulated for light gage stamping operations such as electrical contacts. Normal evaporation time is 15 to 30 minutes. This is a mild product that employees readily accept.

VANISH 6832

Medium drying vanishing oil

A low viscosity compound formulated for light stamping, blanking and forming operations. Normal evaporation time is 60 to 120 minutes.

VANISH 6833

Medium drying vanishing oil

A low viscosity compound formulated for moderate stamping, blanking and forming operations. Normal evaporation time is 60 to 120 minutes.

| | VANISHING OILS | | | | | | |
|---------------------|----------------|------|------|---------------|------|------|------|
| | CHLORINE BASED | | | CHLORINE FREE | | | |
| | 6905 | 6912 | 6916 | 6922 | 6830 | 6832 | 6833 |
| METAL | | | | | | | |
| Steel | A | A | A | A | A | A | A |
| Stainless Steel | A | A | A | A | A | A | A |
| Aluminum | A | A | A | A | A | A | A |
| Brass | A | A | A | A | A | A | A |
| Zinc | A | A | A | A | A | A | A |
| GAGE | | | | | | | |
| Light .001 to .040 | A | A | A | A | A | A | A |
| Medium .040 to .085 | | | A | A | A | A | A |
| Heavy .085 to plate | | | | | | | |
| OPERATION | | | | | | | |
| Blanking | A | A | A | A | A | A | A |
| Drawing | | | | | | | |
| Punching | A | A | A | A | A | A | A |
| Extruding | | | | | | | |
| Perforating | | | | | | | |
| Swaging | | | | | | | |

VANISHING OILS

SPECIALITY PRODUCTS

In addition to our standard product line, Lamson Oil offers several specialty products for general shop use. Like all Lamson products they are formulated in a carefully controlled environment using the finest materials available.

TAPPING LUBRICANTS

Lamson's new family of tapping compounds. Versatile enough to give excellent results on high alloy steels yet safe and effective for aluminum. Tapping lubricants can be used for reaming, drilling, milling or turning applications. No chlorinated solvents are used in any products.

TAPPER 6705

A versatile product providing excellent results on all types of metals. Recommended for tapping applications to extend tool life and improve hole finish. Tapper 6705 does not contain an emulsifying agent, therefore it is not recommended for use in coolant applications.

TAPPER 6714

The same formulation as Tapper 6705, but contains an emulsifying agent for use with existing coolant systems.

TAPPER 6715

A heavy duty compound with a high viscosity that allows the material to adhere to the tap. Completely safe to use on all metals.

NATURAL LUBRICANTS

Environmentally safe lubricants for most metal removal and metal forming applications. All of these lubricants are made from various natural products and are 100% biodegradable. Lamson MeterLube products are high in lubricity. MeterLube allows tools to function with a negligible amount of friction, creating less heat and prolonging tool life.

METERLUBE 6725

The heaviest duty, high viscosity natural lubricant. The best choice for the toughest jobs.

METERLUBE 6728

A heavy duty, low viscosity lubricant providing good flow and shedding for heavy duty jobs.

METERLUBE 6731

A medium duty, high viscosity tapping fluid.

METERLUBE 6734

A medium duty, low viscosity tapping fluid.

METERLUBE 6737

A high performance moderate viscosity lubricant ideal to use when a heat treating process follows the forming application. Provides total burn-off and ashless residue.

GUIDE LUBE 7000

Heavy duty guide post lubricant

A viscous lubricant high in antiwear and extreme pressure additives, designed especially for high-speed presses.

RUST PREVENTATIVE LUBRICANTS

Lamson has formulated oil based and synthetic oil free lubricants providing indoor rust protection for parts.

RP 7230

Petroleum based rust preventive for ferrous metals

This product is an oil based, water displacing rust preventive that leaves a thin, oily coating. RP 7230 provides long term protection of tools, dies, parts, machinery and other equipment.

RP 7240

Penetrating oil and rust preventative
RP 7240 is a light mineral oil with additives providing penetration, lubrication, and light rust prevention. Formulated to be light in viscosity, RP 7240 uses a petroleum oil and solvent to disperse its lubricating qualities.

RPW 7300

Synthetic rust preventative for ferrous metals

This product is a light viscosity synthetic rust preventative free of oil and oil derivatives. RPW 7300 can provide up to 6 months protection. Dilute with water for optimal economic benefits.

RPW 7303

Synthetic rust preventative for all metals

This product is a light viscosity synthetic rust preventative free from oils and oil derivatives. RPW 7303 provides long term protection for parts and can be used on all types of metals.

EDM-8016

Dielectric EDM fluid

A premium quality dielectric fluid. Contains antioxidants to prolong fluid life and reduce replacement costs.

CLEANER 9002**Heavy duty hot tank cleaner**

Designed to be used at different concentrations depending upon the severity of the job. Recommended for use as a cleaning agent in agitated or unagitated hot tanks. Removes mill oils, stamping compounds, coolants and other contaminants from all metals. Rinsing required on non-ferrous materials.

CLEANER 9005**Heavy duty liquid cleaner**

Formulated for heavy duty cleaning of parts in spray washers. Can be used to remove mill oils, machining oils, coolants and other types of contaminants. Rinsing required on non-ferrous materials.

CLEANER 9010**Biodegradable heavy duty cleaner and degreaser**

This product contains a citrus derivative that quickly dissolves stubborn dirt, grease and stains. Cleaner 9010 releases a pleasant fragrance that leaves the area fresh smelling for hours.

CLEANER 9025**Heavy duty cleaner**

A multi-purpose cleaner that can be diluted with water to clean a variety of surfaces depending on the severity of the application. For use on the most stubborn dirt and grease.

CLEANER 9088**A sump cleaner**

Formulated to simplify the cleaning of coolant reservoirs by loosening and dispersing bacteria, fungus and yeast buildup prior to dumping. This product contains no biocides or other dangerous ingredients.

**ACCY-1000**

Refractometer with temperature compensation (0-32 Brix). Provides an easy method to measure concentration of water soluble fluids.

**ACCY-1030**

Electronic pH meter with temperature compensation. An easy method to measure acidity or alkalinity. Recommended accessory with cleaners.

**ACCY-1010**

Oil skimmer (3 inch wide belt - pictured). 3 foot belt length is standard. Alternative lengths are available. Skimmers remove floating tramp oil from coolant reservoirs.

ACCY-1011

Oil skimmer (12 inch disc type).

**ACCY-1050**

Sump Saver Bags. A safe easy method to add biocide to a coolant system. Each bag treats 45 gallons. Bag dissolves into solution.

**ACCY-1038**

Combi dip slides (bacterial/yeast/mold) 10 per kit. Provides a simple method to test and measure biological activity of fluids

ACCESSORIES

WHICH OIL TO USE...

We've developed the chart below to help you select just the right lubricant to meet your needs. Although each Lamson Oil Product is versatile enough to handle a variety of jobs, making the right choice depends on several factors. The right lubricant must fit the severity of the operation and the type of metal in question. Consideration must also be given to gage, cleaning, application and how the lubricant is to be applied. It must accommodate economic and environmental concerns, hold up through subsequent operations and win acceptance by your employees. Custom blending for non-standard applications is no problem. For assistance in choosing the correct lubricant for your application, contact Lamson Oil at 815-226-8090 or your authorized representative.

| | STRAIGHT OILS | | | | | WATER SOLUBLE OILS | | | | | | SYNTHETIC LUBRICANTS | | | | | VANISHING OILS | | | | | | | | | | | | | | | |
|---------------------|----------------|------|------|---------------|------|--------------------|------|---------------|------|------|------|----------------------|------|---------------|------|------|----------------|------|---------------|------|------|------|------|------|------|------|------|------|------|------|------|------|
| | CHLORINE BASED | | | CHLORINE FREE | | CHLORINE BASED | | CHLORINE FREE | | | | CHLORINE BASED | | CHLORINE FREE | | | CHLORINE BASED | | CHLORINE FREE | | | | | | | | | | | | | |
| METAL | 1105 | 1110 | 1125 | 1130 | 1150 | 1219 | 1220 | 1290 | 2305 | 2312 | 2325 | 2330 | 2340 | 2280 | 2281 | 2282 | 4055 | 4060 | 4074 | 4075 | 3000 | 4247 | 4250 | 4254 | 4279 | 6905 | 6912 | 6916 | 6922 | 6830 | 6832 | 6833 |
| Steel | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A |
| Stainless Steel | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A |
| Aluminum | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A |
| Brass | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A |
| Zinc | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A |
| GAGE | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Light .001 to .040 | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A |
| Medium .040 to .085 | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A |
| Heavy .085 to plate | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A |
| OPERATION | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Blanking | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A |
| Drawing | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A |
| Punching | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A |
| Extruding | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A |
| Perforating | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A |
| Swaging | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A |
| CLEANING | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Vapor Degreaser | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A |
| Alkaline | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A |
| Anneal | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A | A |

These recommendations are Lamson Oil Company's findings but the results can vary due to circumstances beyond our control. This chart is a guide only and each application should be evaluated on its own merits.



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