



Neldraw GM-2 Lube (200#)

Powder Soap Lube

GM-2 is a soap and polymer based dry film lubricant. It is diluted in warm to hot water and roll coated onto sheet stock or applied in barrels to small parts. GM-2 provides a dry film coating that provides exceptional lubrication to metal during deep drawing and forming operations.

Product is easily removed for finishing with alkaline based cleaners: removal from steel with a zinc phosphate: soak tanks: use #CQ-2400, spray wash use #3705, removal from steel with galvanize and zinc phosphate: soak or spray wash use #RWS 567

GM-2 provides a low cost mill applied lube that performs exceptionally well and in most cases eliminates the need for subsequent press applied costly lubes and feeding equipment. Eliminates many housekeeping issues also.

Features & Benefits

- The dry film coating can eliminate the need for press applied oils and lube coatings
- Lowest cost method of providing lube for metal forming
- Extremely high quality lube coatings with repeatable performance
- The process usually includes a grain refiner when phosphate coatings are applied

Physical Data

pH	< 10
Product Type	Powder
Spec. Gravity	0.00
lbs./gal.	0.00
Foam, 0 = Low, 9 = High	9
Shelf-Life Years	10 Years
Freeze Information	Not damaged by freezing

Typical Processing

GM-2 is applied to metal surfaces in roll coating applications or in barrel / basket processes from a hot water bath. GM-2 is typically applied over phosphate coat of zinc or iron. Coatings are typically applied at 100-250 mg/ft².



Coatings in some applications can also be applied to clean bare steel. Coatings less than 100 mg/ft² are not recommended for deep metal drawing. Lubricant film at low levels can cause die failure and metal scratching.

Typical Process:

1. Power clean PFG-3
2. Rinse
3. Rinse
4. Light zinc phosphate coating @ 150 - 300 mg/ft²
5. Rinse
6. Rinse
7. GM-2, 20 oz/gal, 160 F.(Typically 100-250 MG/FT²)
8. Roll coat or barrel dip
9. Warm air dry

Packaging

Container Type	Fiber
Net Units	200
Tare Wt.	10
Gross Wt.	210
DOT_Name	Not regulated by DOT
DOT Hazard	Not regulated by DOT
Tarriff ID	

Use Parameters

Concentration Range	8 - 36 oz/gallon
Temperature Range	160 - 190 deg. F.
Time Range	Per process ½ - 20 min
Agitation	Light circulation of bath

Waste Disposal

Sweep up spills and place in trash.

Holding Tank Materials of Construction

Steel, stainless or poly.



Other Information

It is important that the OSHA DATA, "Material Safety Data Sheet" be carefully read and reviewed with the users of this product. OSHA data is required to be posted in the work area by law.

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