

BERUFORM

***Lubricants for
Sheet Forming Processes***

– Evaporating Blanking Lubricants

BERUFORM VSM 9

Production of “dry” construction parts which are processed or stored without degreasing, e.g. electrical contacts.

BERUFORM VSM 41

Production of small parts of steel, copper, aluminium and plated materials, bent and pressed parts, spring material up to approx. 1 mm. Evaporates quickly and nearly residue free.

BERUFORM VSM 101

Processing of electrical contacts, blanking of fins for heat exchangers, bent and pressed parts in the kitchen industry, spring material. Evaporates quickly and nearly residue free.

BERUFORM VSM 106

Stain-free processing of aluminium. Production of small parts of steel, copper and plated materials up to approx. 1,5 mm.

BERUFORM VSM 218

Processing of brittle alloys, bending and drawing of parts, perforated metal plate production, coining operations. High forming performance. Coating media for hydroforming-processes with copper tubes.

BERUFORM VSM 2125

Blanking, bending, rolling and coining of steel, stainless steel and aluminium up to approx. 2 mm; catalytic converters and exhaust systems. Evaporates quickly and nearly residue free.

Special Products for Stain-free Forming of Aluminium

Viscosity
(mm²/s; 40° C)

ALUFORM 22 22

ALUFORM 32 32

ALUFORM 46 46

Especially developed for residue-free blanking, bending, stamping and deep drawing of aluminium. These products can be applied in very small amounts. Residues will evaporate stain-free in a following heat treatment.



Emulsifiable blanking, deep drawing and forming lubricants – chlorine free

BERUFORM STE 32 15
5-30%.
Milky white, metastable emulsion with good lubricating performance. Blanking, bending and drawing parts of copper, brass and aluminium at medium forming performance. Finning of copper tubes up to height of 15 mm. Service concentration 5-30%.

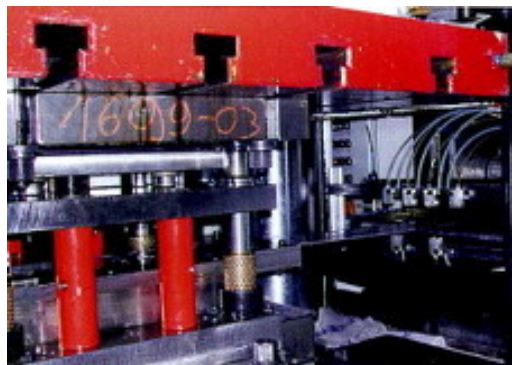
BERUFORM STE/K 58
Blanking, bending, stamping, deep drawing and rolling of thin sheets of aluminium, non-ferrous metals as well as easily formable, low alloyed steels. Drawing of bars and profiles of brass. Applied undiluted. Can be washed off with water.

BERUFORM STE 3023 8-35%.
Blanking, bending and deep drawing of fine sheets of normal deep drawing qualities. Hot rolling and drawing of wires and profiles of zinc and aluminium. Service concentration 8-35%.

BERUFORM STE/K 2723
Blanking and deep drawing of fine sheets of normal deep drawing qualities, galvanized steels and aluminium. Production of rivets. Applied undiluted. Can be washed off with water.

BERUFORM STE 4023 8-35%.
Blanking and deep drawing of unalloyed and alloyed steels. Medium to severe forming operations. Service concentration 8-35%. Good corrosion protection.

BERUFORM STE 5023 8-25%.
Blanking and deep drawing of unalloyed and alloyed steels. Cold forming of copper and warm forming of brass (fitting production). Service concentration 8-25%.



Non water miscible chlorine free blanking and deep drawing oils

		Viscosity (mm ² /s; 40° C)	
BERUFORM STO	333	30	
BERUFORM STO	533	50	Blanking, bending and deep drawing of fine sheets of deep drawing qualities, auto body sheets, catalyst sheets and aluminium; punching of stainless steels. Remaining oil films offer excellent corrosion protection.
BERUFORM STO	532	45	
BERUFORM STO	732	68	Blanking, bending, coining and rolling of thin sheets of aluminium, non-ferrous metals as well as ductile, low-alloy steels. Deep drawing of bushes. Extrusion of semi-hollow rivets. Drawing of steel wires and profiles.
BERUFORM STO	544	45	
BERUFORM STO	844	80	Blanking and deep drawing of fine sheets of deep drawing qualities, galvanized steels and stainless steels as well as aluminium. Easy to medium severe forming operations on multiple stage transfer presses.
BERUFORM STO	856	75	Blanking, deep drawing and fine blanking of C-steels with strengths of up to 900 N/mm ² , bending and rolling of stainless steel hinges. Severe forming operations.
BERUFORM STO	847	80	Fine blanking, blanking and deep drawing of stainless and acid resistant steels and austenitic steels. Automotive body shells, production of kitchen appliances. Medium severe to severe forming operations.



Chlorine containing forming oils

Viscosity
(mm²/s; 40° C)

BERUFORM STO 32 C 30

Fine blanking of cold, warm and stainless steel belt. Production of chain clips, door lock parts, appliances and fine mechanics, automotive accessories, safety belts. Suitable for machining high-alloyed stainless steels, e.g. thread cutting. Drawing of medium and fine wire of stainless steel.

BERUFORM STO 72 C 70

BERUFORM STO 355 C 350

Deep drawing, fine blanking, tube and profile bending, pressing and rolling of stainless steel and other high-alloyed steels. Suitable for demanding machining of high-alloyed steels, e.g. broaching and thread cutting.

BERUFORM STO 155 C 150

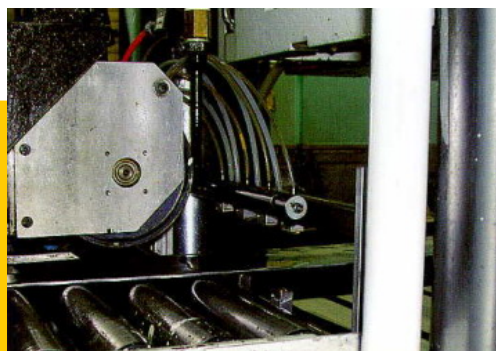
Cold pilger rolling of seamless reactor tubes and stainless steel tubes (external and internal lubrication); deep drawing, fine blanking and tube bending of stainless steel. Suitable for stainless steel metal removal operations. High level of chlorinated additives.

BERUFORM STO 223 C 220

Drawing and bending of bars, tubes, profiles and thick wires of stainless steel; fine blanking, piercing and deep drawing of stainless steel and very thick sheets.

BERUFORM STO 705 C 700

Winding of chromium-nickel steels; deep drawing, piercing and fine blanking of stainless and acid resistant steels, austenitic steels and very thick sheets; bending of stainless steel tubes with internal mandrel (even with very narrow bending radii).





Lubricants Sheet Forming Processes

Deep drawing pastes – Chlorine free

/ efflux time
5
Ford-Cup 5 mm

BERUFORM STP 18 B 18 c

Deep drawing of auto body parts with complex geometry as well as for high drawing depths, deep drawing and ironing of all types of sheets with high wall thicknesses and severe forming degree. Production of stainless steel sinks. Contains anorganic pigments. Good corrosion protection.

BERUFORM STP 50 CA 40-60 c

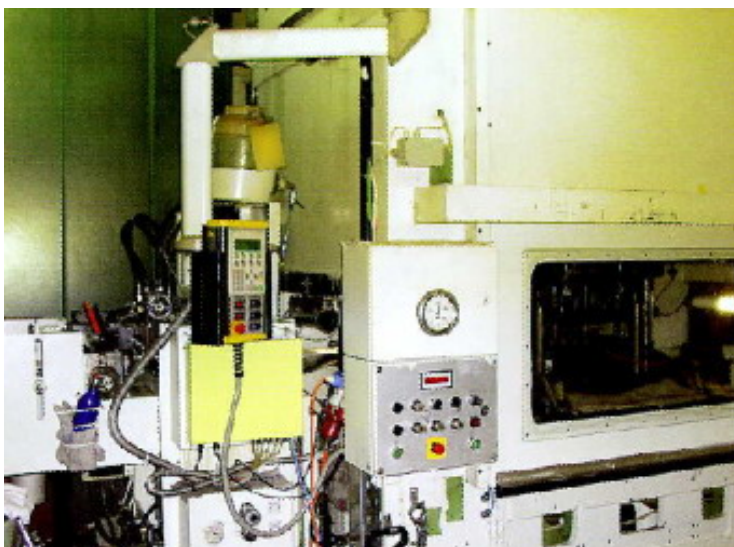
Deep drawing of auto body sheets with complex geometry as well as for high drawing depths, sheets of normal deep drawing qualities and aluminium with high wall thickness. Drawing of steel and precious steel wires. Contains anorganic pigments. Can be washed of with water.

unworked penetration
/10

BERUFORM STP 290S 290

30 -50 %.

Aqueous protective soap-based film for low demanding deep drawing operations;
can be easily washed off.
Service concentration 30 - 50%.





Special Lubricants Made by BECHEM



Высоко- и низкотемпературные смазочные материалы
Смазочные материалы с длительным сроком службы
Смазочные материалы для пластмасс
Смазочные материалы для электроконтактов
Смазочные материалы для пищевой промышленности
Смазочные материалы для арматур

Special Lubricants

Lubricants for high and low temperature
Lubricants for lifetime
Lubricants for plastics
Lubricants for electrical contacts
Lubricants for the food industry
Valve lubricants



Высокоэффективные универсальные смазки
Специальные смазочные материалы с EP-присадками
Гидравлические масла
Трансмиссионные смазочные материалы
Экологические смазочные материалы
Разделительные жидкости для опалубки

Lubricants for the Industry

High performance multipurpose greases
Special EP-greases
Hydraulic oils
Gear lubricants (Open Gear)
Biodegradable lubricants
Release agents



Смазочно-охлаждающие жидкости
Масла для смазки и охлаждения режущего инструмента
Масла для глубокого сверления
Антикоррозийные масла
Масла для закалки
Среды для очистки

Metal Working Mediums

Coolants
Cutting oils
Deep drilling oils
Anti corrosion oils
Quenching oils
Cleaning fluids



Масла для холодной обработки давлением
Полугорячая и горячая обработка давлением
Среды для волочения проволоки
Среды для глубокой вытяжки
Волочение труб

Metal Forming Fluids

Cold forging oils
Release agents for semi-hot and hot forging
Wire drawing lubricants
Deep drawing oils
Tube drawing

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