

## Stamping Oils

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### OTHERS :

Degreasers

Phosphating  
Agent

Stamping oils are used to protect and prolong the working life-span of toolings. They are graded into different types by their viscosities, oil thickness. Thicker stamping oils are used for heavy duty stamping on hard or thick metal pieces. Often these thick oil is incorporated with EP (Extreme Pressure) additives for extra protections to the toolings or punches. Degreasing is tougher as the residual oils on stamped parts are thick and tenacious which requires longer degreasing. In better stamping oils, anti-wear and lubricity enhancers are also added to improve performance. For stamping of ferrous components, the oil is blended with rust inhibitors.

boiling points to be more evaporative so that cooling can be effected. As liquid vaporizes, it carries with it the heat of vaporization. This feature is important as high speed stamping generates intense heat on both the stamped parts and the punches. Since the stamping is thin, residual oil on the substrate will dwindle. This can make degreasing easier than thick oils. As most evaporative stamping oils are flammable, extra care must be taken to avoid fire. Some evaporative oil manufacturers have come out with oil that have high Ignition points to avert fire hazards. The other common complaints faced by evaporative oil is its unpleasant odour. In some discerning factories, specialty odourless stamping oils can only be approved and acceptable for use. This can jack up productions cost. For less stringent requirements, degreasing can be omitted altogether if a properly selected evaporative stamping oil is used.



Stamping Machine

Thinner grade oils are used for high speed stamping. Frequently the thinner oil will have low

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