



## Iloform TRS 104

Synthetic Forming Fluid

### Description

Castrol Iloform™ TRS 104 is a versatile roll forming coolant containing an advanced synthetic lubrication package, synthetic corrosion inhibitors and special soaps to provide an oil-free synthetic with excellent lubrication, cooling and performance properties. It is free of formaldehyde release biocides.

### Application

Iloform TRS 104 is formulated to meet the requirements of structural tube forming of stainless and carbon steels. It has been designed to continuously clean the forming rolls of mill scale buildup.

Iloform TRS 104's clean running nature, in both hard and soft water, allows mill scale and dirt to drop quickly and split tramp oil.

Iloform TRS 104 works well in central systems as well as in single sump systems. The product's corrosion inhibitor package provides extended indoor protection.

Iloform TRS 104 can also be used for tube cutting and as calibration fluid.

### Conditions of Use

Concentration Range: 3 - 7%

### Advantages

- Excellent lubrication and cooling properties enable high tube surface quality
- Extended inter-operational corrosion protection
- Remains stable in both hard and soft water
- Tramp oil and fines separate easily, resulting in a clean running system
- Demonstrates superior resistance to microbial attack for longer product life and safer working environment

### Typical Characteristics

Description	Test Method	Unit	Value
Concentrate			
Appearance of Concentrate	Visual	-	Clear colourless - light yellow liquid
Density @ 15 °C	NFT 60-172	g/ml	1.08
Dilution			
Appearance of Dilution (5% in DI water)	Visual	-	transparent liquid
pH of Dilution (5% in DI-water)	NFT 60-193	-	9.1
Refractometer Factor	-	-	2.0

## Concentration Control

BY REFRACTOMETER:

The concentration of the Iloform TRS 104 can be easily measured on site with a hand held refractometer. It is important to realise that refractometer readings are dependent upon the type of refractometer and water used.

Certain rules should be observed:

- The sample should be clean and filtered, if necessary
- The refractometer must be zeroed
- Concentration Iloform TRS 104 in % = refractometer reading x factor **2,0**.

(It is recommended to verify this on new standard solutions made at several concentrations with the water used to prepare the bath).

## Storage

To avoid product deterioration always keep the container/drum tightly sealed. Store the product in a cool, dry place away from direct sunlight. Prevent exposure to frost and avoid water ingress. For optimum product stability, it is preferable to store the product indoors between 5°C and 45 °C / 41°F and 113°F.

For more details, please refer the product safety data sheet.

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