



Tube drawing Stainless Steel / Aluminium

When drawing semi-finished stainless steel products (hollows) and/or extruded aluminium tubes or sheet coil tubes (longitudinally welded sheet coil material) or extruded aluminium into complex cross-sections, exact inside and outside diameters are a must. Principally comparable with wire drawing, the "inside and outside" aspect here additionally needs to be taken into account for selecting the optimal lubrication system.

With stainless steel, these lubrication systems are usually applied on top of an oxalate coating, whereas aluminate is occasionally used as a base layer for aluminium.

The lubricants continue to be predominantly soaps, but polymers can also replace them to good effect, depending on the application. Solid lubricants are generally not suitable for tube drawing because of the high friction coefficients.

ZWEZ is one of the world's most innovative manufacturers with a broad range of products. Experienced experts are available for technical support of your application.

	Stainless steel		Aluminium	
■ = standard □ = alternative ◆ = as required	Seamless or welded tubes (also hollow profiles). Drawing of hollow bodies (tube processing)	SLS process <u>without</u> oxalate	Seamless or welded tubes (also hollow profiles). Drawing of hollow bodies (tube processing)	SLS process <u>without</u> aluminate
ZWEZ-Clean Cleaning/degreasing	◆	■	■	■
ZWEZ-Acid Pickling	◆		◆	
ZWEZ-Coat Oxalate	■			
ZWEZ-Coat Aluminate			■	
ZWEZ-Rinse Neutralizing	■			
ZWEZ-Lube Soap lubricant Polymer lubricant	■ □	■	■ □	■