

# Mabanol Stamp 91 AS

Neat Oil for heavy-duty forming work

## Application

Mabanol Stamp 91 AS is a chlorine-free, mineral oil-based metalworking fluid with EP additives and lubricating components that ensure an excellent surface finish and low tool wear. Mabanol Stamp 91 AS is used undiluted for general to very heavy forming and stamping work, for fine blanking and deep drawing as well as for cold massive forming of alloyed and unalloyed steels.

In addition, Mabanol Stamp 91 AS is also suitable for cold forging in dual-cycle machines.

## Properties

Mabanol Stamp 91 AS offers a high level of lubrication, with the remaining oil film serving as corrosion protection. The product is used undiluted and can be applied by dipping, spraying, rolling or by hand.

## Remarks

Due to the selected raw materials, slight differences in color and appearance may be possible, but these have no influence on the functionality of the product.

The product is a water polluting liquid (WGK 1 - self-classification) and must not get into open water or sewage systems.

## Cleaning / degreasing

We recommend using industrial cleaners from our Mabanol Clean range to clean the workpieces from the remaining forming oil residues.

## Data

	Unit	Value
Density at 15°C	g/cm <sup>3</sup>	0,975
Kin. Viscosity at 40°C	mm <sup>2</sup> /s	90
Flash point	°C	171
Copper corrosion (3h/100°C)		4c (corrosion)

## Shelf life / storage conditions

Stable for 24 months when stored at a temperature of 5 °C to 40 °C in unopened containers.

The above values may vary within the commercial limits.  
Updated in March 2023