



HD Semi-Synthetic Soluble Cutting Fluid

DESCRIPTION

Lube Fusion Heavy Duty Soluble Cutting Oil is a premium quality, relatively low cost general purpose semi-synthetic water extendable fluid for use on ferrous and non-ferrous metals (including aluminium). It is low foaming, provides excellent corrosion protection, and has a high degree of lubricity with exceptional wetting and cooling properties.

APPLICATION

- Milling
- Tapping
- Metal forming
- Broaching
- Thread cutting
- Drilling
- Turning
- Grinding

PERFORMANCE

Meets or exceeds:

- ISO MAF

ADVANTAGES

- Does **NOT** contain chlorine, nitrites or phenols.
- Since it is based on succinate emulsifier chemistry, it does not contain sulfur and therefore, is less susceptible to developing unpleasant odors that result from sulfur reducing bacteria.
- Contains no diethanolamine.
- Extended tool life
- Good surface finish
- Prevents rust on machine and machined parts
- Free of boron and secondary amines

TYPICAL PHYSICAL CHARACTERISTICS

Property	Unit	Result	Method
Density @ 20°C	kg/cm	1.1	ISO 3675
Colour (Neat)		Clear medium amber liquid	Visual
Colour (Diluted)		Clear transparent	Visual
pH neat	N/A	9.7	

RECOMMENDED MIXTURE RATIOS

Application	Steels	Alloy steels	Brasses	Bronzes	Aluminium & Alloys
Cold Sawing	20:1	25:1	30:1	15:1	8:1
Drilling	20:1	15:1	30:1	15:1	10:1
Milling	20:1	15:1	30:1	20:1	10:1
Reaming	20:1	10:1	30:1	20:1	10:1
Tapping	20:1	10:1	30:1	20:1	10:1

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