

SmoothKut SS 1105

Water Miscible Metal Working Fluid



DESCRIPTION

SmoothKut SS 1105 is a water-miscible metal working fluid for various machining and grinding operations.

YOUR BENEFITS

- ✔ Good emulsion, bio stability and cleanliness in hard water.
- ✔ Strong rust and corrosion protection under hard water conditions
- ✔ Excellent foam control
- ✔ Efficient tramp oil rejection
- ✔ No scum or sludge residue formation.
- ✔ Highly economical.
- ✔ Improves surface finish.
- ✔ Extends lubricity and provides extended tool life.
- ✔ HSE Compliant product free of heavy metals.

APPLICATION

- ✔ General cutting operations.
- ✔ Most suitable for Sawing, Turning, Drilling, Boring, Milling, and grinding operations.
- ✔ Suitable for Reaming, Tapping operations.
- ✔ Not recommended for Broaching, BTA Drilling, and Gun Drilling operations.

MATERIAL COMPATIBILITY

- ✔ Cast Iron, carbon steel, and ferrous alloys
- ✔ Mild Steel, Stainless Steel, Low-medium- High Tensile Steel.

RECOMMENDED CONCENTRATION

- ✔ Normal Operation: 5-7%
- ✔ Difficult operation: 8-10%

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INSTRUCTIONS FOR USE:

- Product designed for low and high-pressure CNC systems.
- Most suitable for 150 ppm to 1000 ppm hardness water of calcium carbonates.
- Sump should be thoroughly cleaned before charging preferably using our system cleaner package.
- Concentration and pH levels should be checked periodically and maintained.
- Recommended to add oil to water and not vice versa. Do not add oil directly to the sump. Make emulsion before adding.
- Recommended chloride level <30 ppm in water.
- For additional information refer Coolant Management Guidelines available with Molygraph® Regional Application / Service Engineers.

CHARACTERISTICS	TEST METHOD	UNIT	TECHNICAL VALUES
Concentrate Parameters:			
Appearance	Visual	-	Clear Yellow liquid
Density @29.5°C	*CTM	gms/cc	1.0 ± 0.05
Emulsion Parameters :			
Emulsion type	Visual	-	Translucent
Emulsion stability test – 5% in 50 ppm water	*CTM	-	Stable
pH @5% in deionized water	*CTM	-	9.70
Foam Depression in 5% 50 ppm Water	IP 312/74	Secs	< 15
Cast Iron Corrosion Protection	IP 287	%	3 % BP
Refractometer Reading (1:20)	*CTM	-	3.2 ± 0.2
R. I. Factor	*CTM	-	1.56

*CTM: - Corporate Test Method

The values quoted above are typical and do not constitute a specification.

INDUSTRY:

Metal Cutting & Forming

PACK SIZE:

30 Ltrs. / 210 Ltrs.

SHELF LIFE:

12 Months

Marginal variation in shade can be expected from batch to batch. The color has no effect on the lubricating properties of the product.

MSDS available on request. Due to continual upgradation of products above data is subject to change without notice.

This supersedes our previously issued data sheets.

Information and data given herein is offered in good faith as accurate, but without guarantee. Conditions of use and suitability of a product for a particular use is beyond our control; all risks of use of the product are assumed by the user and WE EXPRESSLY DISCLAIM ALL WARRANTIES OF EVERY KIND AND NATURE.

