

Smoothkut FS 6100

Synthetic Long Life Water Based Grinding Fluid



YOUR BENEFITS

- ✦ Excellent lubricating property.
- ✦ Offers very good protection against rusting and corrosion.
- ✦ Clear product to aid work piece visibility.
- ✦ Significant reduction in machine down time.
- ✦ Reduces extra load on grinding wheels thereby ensuring maximum performance.
- ✦ Ultra low foaming tendency.
- ✦ HSE compliant and product is free of heavy metals.
- ✦ Make a solution before adding.

APPLICATION

- ✦ Suitable for low to high hardness waters typically 150 to 500 ppm of salts.
- ✦ Product well suited for high and low water pressure CNC systems.
- ✦ Cylindrical Grinding & Surface Grinding.

RECOMMENDED DILUTION RATIO

- ✦ Recommended dilutions may vary marginally depending upon the severity of the operations, water hardness and work-piece material.
- ✦ Sump should be thoroughly cleaned before charging.
- ✦ Concentration level should be checked periodically and maintained.
- ✦ Recommended to add oil to water and not vice versa. Do not add oil directly to the sump.

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CHARACTERISTICS	TEST METHOD	UNIT	TECHNICAL VALUES
Concentrate Parameters:			
Appearance	Visual	-	Fluorescent Yellow
Density @ 29.5°C	ASTM D 1298	gms/cc	1.05 -1.15
Emulsion Parameters:			
Emulsion type	Visual	-	Fluorescent Green
Emulsion stability test – 5% in Ro water	*CTM	-	Stable
pH of 5% Solution	*CTM	-	9.2 - 9.8
Foam Depression Test in 5% in Ro water	IP 312/74	Secs	< 10
Cast Iron Corrosion Protection	IP 287	%	2.5 BP
Refractometer Factor (1:20)	*CTM	-	2.2 ± 0.2
R.I Factor	*CTM	-	2.5

*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:

18 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.

