

Smoothkut SO 7100

Water Soluble Metal Working Fluid



DESCRIPTION

Smoothkut SO 7100 is a water-soluble metal working fluid. It is specially designed for machining aluminium alloys. The product can be used for the general machining of ferrous and non-ferrous metals where there is a need for a high degree of oiliness for achieving excellent residual lubrication.

YOUR BENEFITS

- High oil content.
- Fully soluble in water with milky white emulsion.
- Extended service life.
- Reduction on wheel loading.
- Reduced frequency of wheel dressing due to good load carrying capacity of oil.
- Reduces machine down time.
- Offers excellent rust and corrosion protection on tools, components and machines.
- Eco-friendly as it does not contain ozone depleting substances, free from coloring dyes, boron additives, silicone oil defoamers, sodium nitrite, triazine biocides, sulphurized or chlorinated EP additives, phenolic couplers, nonyl phenol and np ethoxylates.
- Low foaming characteristics.
- High economical due to reduced labor cost.
- Product conforms to IS 1115

APPLICATION

- General Machining
- Aluminum material
- Ferrous metals and ferrous alloys

TYPICAL APPLICATIONS WITH WATER RATIOS:

- General Machining : 1:16 to 1:20
- Threading : 1:12 to 1:16
- Deep Drilling Operation : 1:12 to 1:16
- Reaming : 1:10 to 1:12
- Grinding : 1:20 to 1:30



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MATERIAL COMPATIBILITY

- Ferrous alloys.
- Aluminum alloys.
- Copper and yellow metal alloys.
- Oil-resistant plastics and other non-metallic materials.

INSTRUCTIONS FOR USE:

- Recommended dilutions may vary marginally depending upon the severity of the operations, water hardness and work-piece material.
- Suitable for low to high hardness waters typically 150 to 500 ppm of salts.
- Product suited for high and low pressures CNC systems.
- Sump should be thoroughly cleaned before charging.
- Concentration 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 a solution before adding.
- For additional information refer Coolant Management Guidelines available with Molygraph® Regional Application / Service Engineers.

CHARACTERISTICS	TEST METHOD	UNIT	TECHNICAL VALUES
Concentrate Parameters:			
Appearance	Visual	–	Amber Fluid
Specific Gravity @27°C	*CTM	–	0.89
Mineral Oil Content	-	%	80
Solution Parameters:			
Appearance	Visual	-	Milky
Cast Iron Corrosion Test	IP 287	%	5.0
Foam Depression Test	IP 312	-	Nil in 60 secs
pH of 5% Solution	*CTM	-	9.3
Refractometer Factor	*CTM	-	1.0

*CTM: - Corporate Test Method

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

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.

INDUSTRY:

Metal Cutting
& Forming

PACK SIZE:

30 Ltrs. / 210 Ltrs.

SHELF LIFE:

18 Months

