

## Smoothkut SS 5200

*Water miscible High Oil Metal Working Fluid*



### DESCRIPTION

SmoothKut SS 5200 is a water miscible metal working fluid for multi metal, medium to heavy duty machining. Ideally suitable for hard water conditions.

### YOUR BENEFITS

- EP additives provide excellent cutting performance.
- High oil content ensures stable water mix fluid.
- Very good tramp oil rejection and extended sump life.
- Stable emulsion in hard water.
- Excellent rust & Corrosion protection.
- No scum or sludge residue formation.
- HSE compliant and product is free of heavy materials.

### APPLICATION

- General cutting operations.
- Most suitable for Sawing, Turning, Drilling, Boring, Milling, Reaming and Tapping operations.
- Suitable for broaching, cylindrical and surface grinding.

### MATERIAL COMPATIBILITY

- Aluminium material.

### RECOMMENDED CONCENTRATION

- Normal Operation: 5-8%.
- Difficult operation: 7-12%.

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### INSTRUCTIONS FOR USE:

- Suggested dilution ratios may vary marginally depending upon the severity of the operations, water hardness, and work piece material.
- 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 an emulsion before adding.
- Readily forms a milky stable emulsion with varying water qualities. Suitable for water quality typically 150 500 ppm of calcium carbonate.
- Recommended chloride level <30 ppm in water.
- For additional information refer to Coolant Management Guidelines available with Molygraph® Regional Application / Service Engineers.

CHARACTERISTICS	TEST METHOD	UNIT	TECHNICAL VALUES
<b>Concentrate Parameters:</b>			
Appearance	Visual	-	Amber Fluid
Density @29.5°C	ASTM D 1298	-	9.50 ± 0.5
<b>Emulsion Parameters :</b>			
Emulsion type	Visual	-	Milky Translucent
Emulsion stability test – 5% in 200 ppm hard water	CTM 88	-	Passes
pH of 5% Solution in deionized water	ASTM D 1287	-	9 – 10
Foam Depression in 5% 200 ppm Water	IP 312/74	Secs	< 15
Cast Iron Corrosion Protection	IP 287	%	3% BP
Refractometer Reading (1:20)	CTM 65	-	5.2 + 0.2
R. I. Factor	*CTM	-	1.0

\*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.

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