

ROCUT 200

SEMISYNTHETIC EMULSIONABLE FLUID FOR CUTTING AND METAL GRINDING

CHARACTERISTICS

Appearance:	Clear light liquid
Viscosity at 40°C:	10-30 cSt
Slippage point:	- 18°C
Specific gravity:	1,0 g/cm ³
Dilution (water):	it creates a white emulsion
pH (5% emulsion):	9,5
Antirust test (DIN 51360/2):	over 3%



APPLICATIONS

ROCUT 200 is an emulsifier, bio stable, lubri-coolant semy-sintetic fluid borned from a brand new conception. It is exempt from nitrites, phenols, PCB sulfur and PCT. The product is easy to mix with water and creates a translucent emulsion with excellent stability even in tough water (40 Fr degrees). ROCUT 200, by being stable, keeps the biological stability of the emulsion preventing the bacteria and fungi proliferation for long time. The product presents excellent antirust and anticorrosion characteristics even at low concentration to get a better protection of the working machines and of the manufactured products.

PROPERTIES

- Forms a compact and resistant film
- It maintains its characteristics up to 150 °C

DESCRIPTION

ROCUT 200 is recommended in conventional works as metal cutting or grinding in low concentration working plants (central systems, welded tubes making) and in hard working as drilling, milling cutting, tapping, threads, jigsaw cutting, and every other work where water-based lubricants can be used. The product is suitable for every treatment of iron materials and most of half-easy working alloys and particularly indicated for cast-iron working.

WATER:

Water is an essential component. Avoid to use tainted or dirty water on surface; it should be at least potable water. Pay attention to tough water that must be included between 15 and 40° FF (french degrees) Ph must be around 7.

INSTRUCTIONS OF USE

Use clean containers. Pour the oil in the water, not the opposite; the oil must be added gradually shaking the resulting emulsion in a steady and effective way. It is not suitable the use of cold water, especially if it has a lower temperature than the oil. It is better to verify every few days the pH value that must never be lower than 8. The concentration control (contained in the emulsion oil) must be done daily through a specific device (refract meter). The value of the concentration must never be lower than the minimum indicated in the technical data sheet of the product and must never be too high. Approximately the percentage will be included between 3 and 6. See the concentration value suggested in the table below:

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Kind of process	Percentage of use
Drigging	2-5%
Turning Mill – finish drilling	3-5%
Tapping – boring – thread	4-6%
Jigsaw cutting – blanking	6-8%

STORAGE

The emulsifier oil should be moved and stored with the opposite care because is a complex and delicate mixtures: Avoid off-hand jolts of temperature Store in a closed and covered place. Keep between 0°C and + 40 °C Avoid longer storage than 6 months

PACKAGING

Drum of 5-25-200 lt
Product Code13050/50 P

Revision date 01.02.2019

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