



COOLING AND LUBRICATING FLUID

R-7674-W

PRODUCT DEFINITION

R-7674-W is a bio-stable, chlorine free EP-cooling fluid, containing a high degree of mineral oil for chip removal of tenaciously hard steels, malleable cast iron and aluminum alloys. The chip removing as well as sawing of high material strength is ensured by the particularly high activation and satisfies the German standard TRGS-611. This product produces little foam and is best suited for NC- and CNC-centers. Due to its high mineral oil content this product satisfies the requirements of the machine tool manufacturers.

APPLICATION

Mixing occurs by a slow pouring in potable water and simultaneous thorough stirring or by using an automatic mixer.

Mixing suggestion

Chip removal of steels	1:20 to 1:30
Grinding	1:30 to 1:50

Concentration determination

Die concentration control of the emulsion can be performed using a refractometer.

TECHNICAL DATA

Color	yellowish	
Viscosity at 20°C	ca. 250 mm ² /s	DIN 51562
pH-value of an emulsion 1:20 with standard water	approx. 9.2	DIN 51369
Refractometer factor	1.3 (scale value = concentration)	

EP = extreme pressure
NC = numerical control
CNC = computer numerical control