

# r. rhenus FU 60

**r. rhenus FU 60** is a water-miscible EP metalworking fluid on synthetic ester basis free of mineral oil offering high performance and maximum protection for operator and machine.

## Application

**r. rhenus FU 60** is a multi-purpose coolant suitable for heavy machining operations of aluminium alloys, high tensile steels and special materials. Excellent results are also achieved for non cutting forming operations.

## Properties

- very finely dispersed, good flushing effect
- good protection against corrosion
- good skin tolerance
- no chlorine, no nitrite, no mineral oil
- resistant to micro-organisms
- high oxidation stability
- good residual properties
- EP effect (Reichert) at 5 %: 22 mm<sup>2</sup>
- water hazardous class 1

## Technical data

Concentrate		Emulsion	
Viscosity at 20 °C (mm <sup>2</sup> /s)	Ester oil content %	pH value fresh prep. at 5%	Corrosion protection (DIN 51360/2)
180	approx. 44	9,0	at 4 % grade 0

## Remarks

To prepare operating emulsion slowly add the coolant concentrate to drinking quality water assuring thorough mixing. Mixing can also be done by means of an automatic mixer.

Recommended mixing ratio:

Machining of aluminium alloys and steels: 5 - 10 %

Punching and drawing 10 - 20 %

The concentration of the operating emulsion can be determined by means of a pocket refractometer. The °Brix value multiplied by the refractometer value equals the concentration in %. Sometimes reading of scale is more difficult with older emulsions because of the more coarse dispersivity.

## Refractometer factor

1,1

Rhenus metal working fluids are free of chlororganic substances, nitrite and secondary amines. They contain natural raw materials. Therefore, slight degradations of colour and appearance are possible, however, quality and function of the product are not affected at all.

Subject to modification of the technical data. Please refer to the material safety data sheet for additional information or contact our application engineers.

## Edition

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