

r.rhenus FU 70 W

r.rhenus FU 70 W is a water-miscible EP metalworking fluid based on mineral oil. As a product of the second generation of metal working fluids which are free of amines and boric acid, it offers a wide range of machining applications and maximum protection for operator.

Application

r.rhenus FU 70 W is suitable to use for all heavy-duty machining operations on aluminium alloys and steel. The excellent lubricating effect guarantees excellent surface quality and a long tool-life.

Properties

- whitish, finely dispersed
- high stability
- good cooling and lubricating effect
- good sump life of emulsion
- low foaming
- good skin tolerance due to low pH value (7,5 -8.8)
- free of chlorine
- free of amines and boric acid

Technical Data

Concentrate		Emulsion	
Viscosity 20 °C (mm ² /s)	Content of mineral oil %	pH-value (fresh preparation) at 5 %	Corrosion protection (DIN 51360/1)
approx. 150	approx. 33	approx. 9,0	at 2 % RO-SO

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 ratios:

Machining of aluminium alloys, steel and cast iron from 6 %
Machining of alloyed steels from 6 %

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

1,0

Rhenus water-miscible coolants are free from chlororganic substances, nitrites and secondary amines. These products contain natural raw materials. Therefore, different shades 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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