

r.rhenus XF 61 P

r.rhenus XF 61 P is a water-miscible extreme pressure metal working fluid based on ester oil free of amines and boric acid. A product of high performance and best working protection for man and machine.

Application

r.rhenus XF 61 P is a high performance EP-coolant with sulphur additives used for heavy duty machining operations of high tensile steels and aluminium alloys. The product has also been approved for stamping and drawing operations.

Properties

- maximum machining performance
- very high lubricating effect
- long tool life
- finely dispersed, good rinsing effect
- good protection against corrosion
- good skin tolerance
- high long life stability
- Reichert test at 5 %: 15 mm²

Technical Data

Concentrate		Emulsion	
Viscosity 20 °C (mm ² /s)	Content of ester oil %	pH-value at 5 %	Corrosion protection (DIN 51360/2)
approx. 210	approx. 52	9,1	at 5 % 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 ratios

Machining of aluminium alloys and steels	from 6 %
Stamping and drawing	5 to 30 %

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 metalworking fluids are free from chlororganic substances, nitrite and secondary amines. They 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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