

r. rhenus XT 40 MG

Special coolant for magnesium operations

r. rhenus XT 40 MG is a water-miscible EP metalworking fluid based on mineral oil. As special product for latest machining technologies, it offers high technical performances and maximum protection for operator and machine.

Application

r. rhenus XT 40 MG has especially been developed to meet the special demands of operations on magnesium alloys. It is also very well suitable for aluminium alloys. On individual machines it can also be used for the operation on iron and steel.

Properties

- low formation of hydrogen on magnesium processing
- High emulsion stability even at high concentrations of Mg-ions.
- relative pH-constancy at Mg absorption
- no attack or staining of magnesium alloys
- low drag out losses, long emulsion life
- good demulsifying properties towards Rhenus slideway oils Nor SLA and SLB
- very low foaming at different water qualities
- favourable process costs
- water hazardous class 1

Technical Data

Concentrate		Emulsion	
Viscosity 20 °C (mm ² /s)	Content of mineral oil %	pH-value fresh preparation 5 %	Corrosion- protection (DIN 51360/1)
approx. 160	approx. 35	9,1	4 % RO-SO

Remarks

The preparation of the operating should only be done by means of an automatic mixer.

Recommended mixing ratios:

Machining of magnesium alloys from 5 %

Machining of aluminium alloys and steel 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. A more exact determination can be achieved by means of the KON-TEST set.

Refractometer factor

1,0

Rhenus coolants 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 products 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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