

LINELUBE FS2603 CUTTING FLUID

FS2603 is a high performance general-purpose biostable emulsion type cutting fluid concentrate designed for more arduous machining operations including CNC reaming, drilling and tapping.

APPLICATION

FS2603 has been specifically designed with a blend of surface active and hydrodynamic lubrication additives and can be used on ferrous, non-ferrous, and materials such as stainless steels and nimonic alloys. FS2603 is capable of replacing the use of neat oils in multi-spindle and automatic machining centres where machine design permits the use of water based fluids. Long sump life can be expected due to the modern bio-stability chemistry

Machining applications range from light duty grinding to high speed CNC milling and turning, concentrations will be variable dependant on severity of application.

BENEFITS:

- ✓ *Suitable for a wide range of materials*
- ✓ *Excellent rancidity control*
- ✓ *Permits higher cutting speeds*
- ✓ *Advanced design giving good lubrication*
- ✓ *EP additives reduce tool wear*
- ✓ *Offers versatility for mixed machining operations, can replace neat oils*
- ✓ *Long sump life*
- ✓ *Excellent corrosion control*
- ✓ *Stable in harder water areas*
- ✓ *Low foaming / Low misting*
- ✓ *Clean and pleasant to use*
- ✓ *Triazine free*

RECOMMENDED STARTING CONCENTRATIONS

Grinding	3 - 5%
Light - Medium Duty Machining	4 - 6%
Medium - Heavy Duty Machining	6 - 8%
Extremely Heavy applications or as a replacement for neat oils	8 - 12%

Top up Concentrations should always be made with a diluted mix of concentrate and water to maintain the recommended strength in the machine.

CONCENTRATION ANALYSIS

To check and maintain concentration a refractometer is recommended, the resulting reading multiplied by a factor of 1.4 will give concentration strength.

TYPICAL PHYSICAL CHARACTERISTICS

Concentrate:

Appearance **Translucent**
Specific Gravity @20°C **1.010**

Emulsion @5%

Appearance **Opaque**
Odour **Bland**
pH (in use) **8.8 ~ 9.5**