

Technical Data Sheet

Coolant 65XEP

Multipurpose, high oil, high performance water soluble cutting fluid. It is a long life fluid, formulated for high performance on difficult machining operations with low staining characteristics on aluminium alloys, designed to give low foam performance.

Chlorine-free.

Coolant 65XEP is a modern, EP watermix cutting fluid used for Turning, milling, drilling, threading, boring, deep hole drilling, reaming (including Maple reaming) and creep feed grinding.

Key Benefits

- Good Sump Life
- Improved Tool Life
- Excellent surface finish
- Excellent visibility
- Operator Friendly
- Excellent Corrosion Protection
- Low Foam in soft water.
- Reduced Sticky Deposits
- Less Product Loss due to Draw-Out

Typical Applications

- | | |
|---------------------------------------|--------|
| • General Machining | 4-6% |
| • Deep hole drilling, boring, tapping | 6-8% |
| • Mapal reaming | 8-10% |
| • Creep feed grinding | 5-10% |
| • Gear hobbing and cutting | 10-20% |

Typical Data

<u>Concentrate</u>	
Appearance	Amber Fluid
Specific Gravity	0.91
Oily Content %	65

<u>Emulsion</u>	
Appearance	Pink Milky
pH at 5%	9.2
IP287 pass at %	2.0
Refractometer Factor	1.0

Emulsion Type

- Milky emulsion
- Medium/High Oil Content
- Lubricity additives.

Compatibility

- Ferrous metals including stainless steel.
- Aluminium alloys
- Inconel and other high spec alloys
- Titanium alloys
- Plastics

General Compatibility

- Waters from 50ppm to 450ppm (Calcium hardness)
- Low foaming tendency
- Suitable for high pressure applications
- Suitable for low pressure applications

Health and Safety

Full health and safety data sheet is available on request.

Storage

- Store indoors
- Store between 4 °C and 34°C
- Shelf life is 6 months from date of supply
- Store undercover or if outdoors on its side.

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