

LUBRO SEMISINT M

Semi-synthetic cooling lubricant for high finishes on iron and aluminum

FEATURES

The LUBRO SEMISINT M is a semi-synthetic lubricant with special lubricating additives, anti-rust and preservatives for operations in the removal of chips from products made of iron, steel and aluminum alloys.

The product works very well to obtain high finishes, both on ferrous materials and on aluminum, for machining of the type: boring, threading, drilling, milling, tapping, internal grinding, turning and parting off.

The oil base consists of light naphthenic distillates subjected to severe hydrogenation treatments in order to eliminate the **IPA** compounds (polycyclic aromatic hydrocarbons) known to be harmful to the health of the operators.

For a long duration of the **Lubro Semisint M** emulsions it is recommended to systematically follow the pH, salinity, CBT and corrosion resistance values according to the indications given in the table below.

CHEMICAL/PHYSICAL DATA

- Aspect: liquid, viscous
- pH(sol.3%): 8,6
- Density(20°C): 0,97 Kg/lit
- Refractometric factor: 1.75

HOW TO USE

Shake the contents of the drum, add the quantity of oil to water under stirring or use the suitably calibrated mixer to the desired percentage.

The concentrations of use will be the following:

	generic	severe
Carbon steel	6%	8%
Hard alloyed	8%	10%
Aluminium alloys	4%	6%

For a good emulsion maintenance it is recommended to periodically measure the CBT with the MINIKIT SLIDE kit and to separate the lubricating oil that falls into the emulsion.

Don't mix with other types of lubricating-cooling emulsions.

Parameters	Unit of measure	Guide values	Verification period	Maintenance	
				ordinary	extraord.
Water hardness	°F	30 – 80	Before preparing the emulsion	-	-
Emulsion hardness	°F	< 65	In activity	> 65	> 75
Water salinity	µS/cm	< 1000	Before preparing the emulsion	-	-
Salinity emulsion	µS/cm	< 5000	In activity	> 5000	> 5500
pH of the emulsion	-	> 8,6	In activity	< 8,6	< 8,0
% max of oil separated in the emulsion		< 0,5	In activity	1	> 1