

INSTRUCTIONS FOR THE CORRECT COOLANT EMULSION MIX

It is necessary to create a well-dispersed fine coolant emulsion at the recommended dilution in order to ensure the benefits of optimum blade life and good surface finish with consistent straight cuts.

IN ORDER TO ACHIEVE THIS ALWAYS **ADD THE OIL CONCENTRATE** (AS SUPPLIED) **TO THE WATER** OR TO THE EXISTING CUTTING OIL MIX.

Begin with ensuring some adequate means of checking coolant strength (Ideally with a refractometer) and see that good mixing is achieved by stirring in vigorously the oil concentrate, gradually building up to the recommended dilution.

The recommended dilution is 10% and this is desirable to make use of the extreme pressure (E.P.) Additives which are present in the oil concentrate. To go outside the mix parameters of 8% or up to 12% means not making effective use of the benefits of the E.P. Additives.

Prepared emulsions can then be diluted with water, or alternatively oil concentrate can be added, provided good mixing procedure is followed.

Finally, care should be taken to ensure that the oil concentrate containers are stored at temperatures above freezing (0° C) and preferably in an upright condition

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