Data sheet

CUTTING FLUID LABRIA

PHYSICAL PROPERTIES

	LABRIA-1	LABRIA-2	LABRIA-3
Appearance	Transparent low-viscosity oil fluid brown-colored		Transparent fluid bright blue colored
Mineral oil	80	70	0
Density	0,9	0,9	1,1
PH with concentration no less than 2%	8	9	9-10
Corrosion effect	no	no	no

TRIBOLOGICAL PROPERTIES OF LABRIA SOLUTIONS

Characteristic	**LABRIA-1** *water diluting 1:30*	**LABRIA-2** *water diluting 1:50*	**LABRIA-3** *Concentrate*
Critical load, kgs	80	80	56
Welding load, kgs	100	100	150
Scar diameter, mm	0,75	0,70	0,61

RECOMMENDED CONCENTRATIONS

The concentration varies depending on the type of machining operation, the water hardness, and the required corrosion protection.

Cutting fluid type	Blade treatment (ferrous, nonferrous)				Hot metal treatment under pressure		Polishing during bearings manufacturing
	threading	drilling	Milling, cutting	Polishing	Die casting	Hot stamping	Steel for bearings
LABRIA-1	5%	5%	5%	2-5%	-	-	-
LABRIA-2	-	-	-	-	5-10%	20-50%	-
LABRIA-3	-	-	-	-	-	-	3-4%