

**WS 500N** is economical and environment- friendly, long life water-soluble oil, suitable for all moderate machining and grinding operations on all ferrous and non-ferrous metals except titanium and magnesium. Formulated with refined naphthenic base oil, corrosion inhibitor package and biocides, WS 500N is designed to give at least two times more sump life as compared to the conventional coolants. Excellent flushing ability of the product enhances the cooling and chip removal ability.



### **Features and benefits**

- Special biocide package enhances the sump life.
- Good flushing property.
- Corrosion inhibitor package protects the job and machine from rusting.
- Reduces wheel loading and dressing frequency.
- Reduces machine down time.
- Reduces disposal and labor costs.
- No Hazardous ingredients as per OSHA Hazardous standards.

### **Directions for use**

**WS 500N** should be diluted with water in the range of 10:1 to 60:1 depending upon the severity of the operation, work piece material and water hardness. The following practices help in achieving the full benefits of the product.

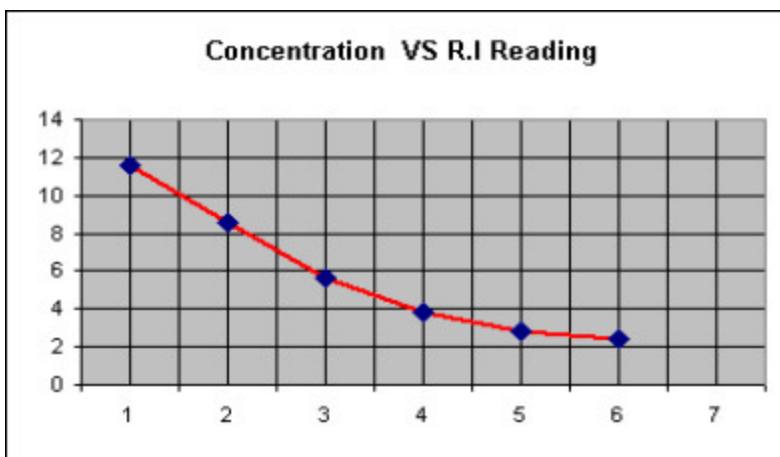
- Always add oil to water and never the other way.
- Usage of low hardness (< 100 PPM), Low chlorides (< 30 PPM) water.
- Never add product directly to the sump. Add in the emulsion form.
- Always clean the sump thoroughly before a fresh charge.

Metal Compatibility	Operation	Concentration
Ferrous	Yes	Drilling
Aluminum	Yes	Broaching
Brass/Copper	Yes	Grinding
Titanium	No	Tapping
Magnesium	No	Milling
		Boring

## Typical properties

Attributes	Ref. Method	Specifications
Appearance	Visual	Blue clear liquid
Odor		Mild odor
Specific gravity @ 27 Deg C	ASTM D 1298	0.91+/-0.01
Viscosity @ 37.8 Deg C	ASTM D 445	45+/-0.30 CST
Emulsion type	Visual	Bluish opaque
Emulsion stability test 5% in 400 ppm hard water	Internal	Passes
PH of 5% solution	Internal	9.0 – 10.0
Foam depression in secs 5% in D.M Water	IP 312/74	30 secs Max
Cast iron corrosion test 5% 200 ppm water	IP 287	Less than 1%
Refractometer reading (1: 20)	Internal	5.8 +/-0.2
Oil content		70 % Minimum
HMIS Rating		
Health: 1	Reactivity: 1	Flammability 1

X-Axis	Y-axis
Concentration	R.I reading
1) 1:10	11.6
2) 1:15	8.6
3) 1:20	5.8
4) 1:30	3.8
5) 1:40	2.8
6) 1:50	2.4



**Pack size:** Available in 20 & 205 liter drums.

*Note: For more details on storage and disposal please refer to material safety data sheet*

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