

WS 5050

WS 5050 is water-soluble oil, enriched with extreme pressure additives to offer excellent tool life and long life in heavy duty machining operations of all ferrous and its alloy metals. Product WS 5050 formulated with refined naphthenic base oil, corrosion inhibitor package, good performance extreme pressure additives and biocides. WS5050 is designed to give good flushing property besides its excellent tool life and more sump life as compared to the conventional coolants.



Features and benefits

- Extreme pressure additives offer good tool life.
- Corrosion inhibitor package protects the job and machine from rusting.
- Reduced machine down time.
- Reduced disposal and labor costs
- No hazardous ingredients as per OSHA – Hazard material classification

Directions for use

WS 5050 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.

Typical properties

Attributes	Ref. Method	Specifications
Appearance	Visual	Blue clear liquid
Odor		Mild odor
Specific gravity @ 27 Deg C	ASTM D 1298	0.94+/-0.01
Viscosity @ 37.8 Deg C	ASTM D 445	55 +/- 3.0 CST
Emulsion type	Visual	Bluish opaque
Emulsion stability test 5% in 400 ppm for 24 hours	Internal	Passes
PH of 5% solution	Internal	9.0 – 10.0
Foam depression in secs	IP 312/74	30 secs Max
Cast iron corrosion test (5% in 200ppm)	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

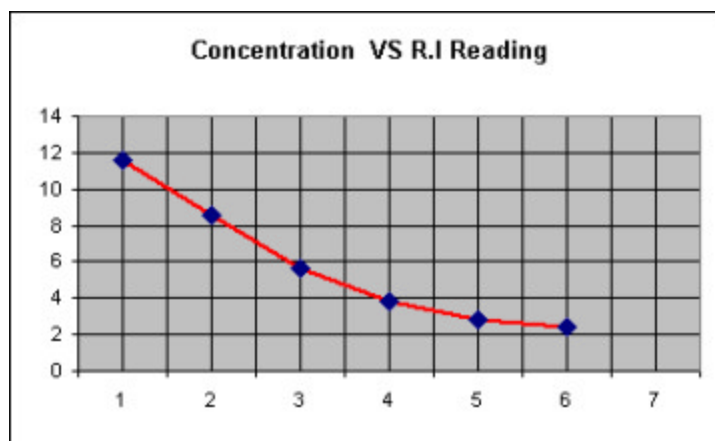
Metal Compatibility

Operation

Concentration

Ferrous	Yes	Drilling	1: 15
Aluminum	Yes	Broaching	1: 10
Brass/copper	Yes	Grinding	1: 20
Titanium	No	Tapping	1: 10
Magnesium	No	Milling	1: 25
		Boring	1: 15

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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