



WS 600N 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, natural emulsifiers, corrosion inhibitor package and biocides.



Features and benefits

- Good aroma and user friendly.
- Reduces wheel loading and dressing frequency
- Reduces machine down time.
- Reduces disposal and labor costs

Directions for use

WS 600N 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 helps 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 | Amber clear liquid |
| Odor | | Pleasant odor |
| Specific gravity @ 27 Deg C | ASTM D 1298 | 0.89+/-0.01 |
| Viscosity @ 37.8 Deg C | ASTM D 445 | 40+/-3.0 CST |
| Emulsion type | Visual | Milky white emulsion |
| Emulsion stability test 5% in 400 ppm water | Internal | Passes |
| PH of 5% solution | Internal | 9.0 – 10.0 |
| Foam depression in secs | IP 312/74 | 45 SECS Max |
| Cast iron corrosion test 5% IN 200 PPM Water | IP 287 | Less than 5% |
| Hand Refractometer reading | Internal | 5.8 (+/- 0.20) |
| Oil content | | 70 % Minimum |
| HMIS Rating | | |
| Health: 1 | Reactivity: 1 | Flammability: 1 |

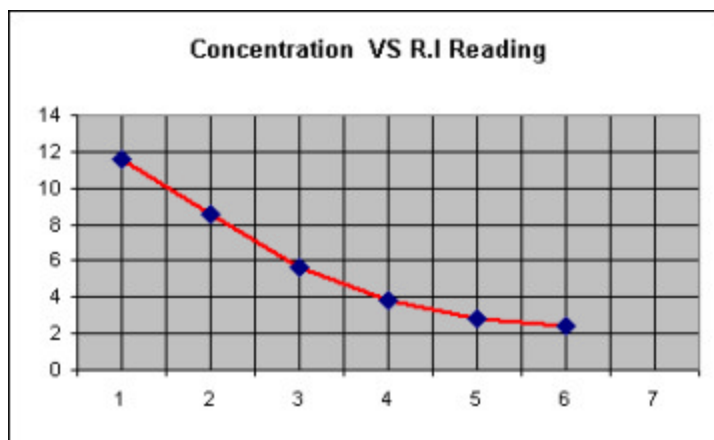
Metal Compatibility

Operation

Concentration

| | | | |
|--------------|-----|-----------|-------|
| Ferrous | Yes | Drilling | 1:15 |
| Aluminum | Yes | Broaching | 1: 10 |
| Brass/Copper | Yes | Tapping | 1: 10 |
| Magnesium | No | Milling | 1: 25 |
| Titanium | No | | |

| 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 |
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| | |
| | |



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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PDS NO: 05/IC/MF; Rev date: 10/01/06