

Syn-C-100 is high performance environment- friendly, long life synthetic metal working fluid, suitable for grinding operations of all ferrous and its alloy metals. Formulated with high performance, corrosion inhibitor package Syn-C-100 is designed to give good sump life with good finish.



Features and benefits

- No hazardous materials like Chromates, nitrites, phosphates, sulphates and chlorides.
- Corrosion inhibitor package protects the job and machine from rusting.
- Reduces wheel loading and dressing frequency
- Reduces machine down time.

Directions for use

Syn-C- 100 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.

- Usage of low hardness (< 100 PPM), Low chlorides (< 30 PPM) water.
- Always clean the sump thoroughly before a fresh charge.
- Maintain the concentration

Typical properties

Attributes	Ref. Method	Specifications
Appearance	Visual	Orange clear liquid
Odor		Mild odor
Specific gravity @ 27 Deg C	ASTM D 1298	1.03+/-0.02
Viscosity @ 37.8 Deg C	ASTM D 445	3.0 +/- 1.0 CST
Emulsion type	Visual	Green Transparent liquid
Emulsion stability test 5% in 400 ppm hard water	Internal	Passes
PH of 5% solution	Internal	9.7 – 10.5
Foam depression in secs	IP 312/74	20 secs
Cast Iron corrosion test 3% 200 ppm water	IP 287	Less than 1%
Refractometer reading (1: 20)	Internal	1.6 +/- 0. 20
Oil content		Nil
HMIS Rating		
Health: 1	Reactivity: 1	Flammability:0

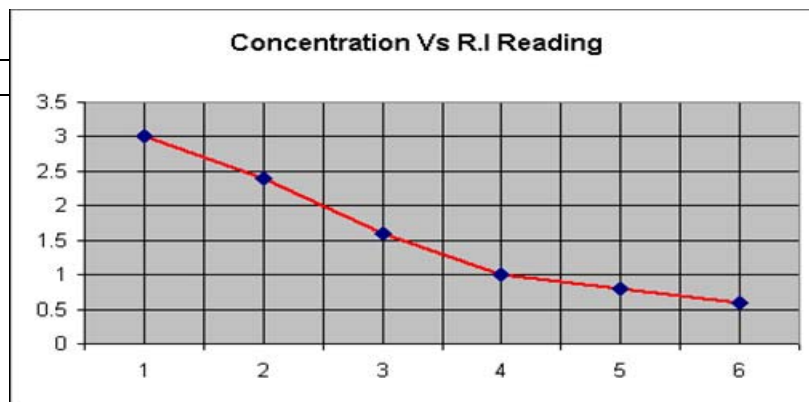
Metal Compatibility

Operation

Concentration

Ferrous	Yes	Drilling	1: 15
Aluminum	Yes	Broaching	Not established
Brass/ Copper	Yes	Grinding	1: 25
Titanium	No	Tapping	Not established
Magnesium	No	Milling	1: 25
		Boring	Not established

X-Axis	Y-axis
Concentration	R.I reading
1) 1:10	3
2) 1:15	2.4
3) 1:20	1.6
4) 1:30	1
5) 1:40	0.8
6) 1:50	0.6



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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