

**Topic : Water-soluble metal working fluid milky-type for good rust protection in use cutting ferrous and non-ferrous.**

98Oils Products	RANDOCUT 500
Applications	Metal Working Fluid
Customer /Location	SF/ Samutsakhon, Thailand
Previous Lube/Fluids	Local Lubricants Oil
Materials	Brass
Process/Machines	Tapping / Tapping Machine
Customer Requirements	Quality improvement

### Issue/Problems :

- Have white stain on the workpiece.

### Solutions :

- Tapping process
  - ✓ Material : Brass
  - ✓ Concentration : 5%Brix
- Tapping Machine
  - ✓ Speed : 1450 RPM.



### Summary :

- Good rust on the workpiece.
- Forms stable emulsion excellent emulsion even with hard water.
- Good lubricity.
- User do not have allergies.

