

Topic: Metal Working Fluids for Hard Water/Milky-Type

98Oils Products	RANDOCUT 600
Applications	Milling for Mold and Die
Customer /Location	STS/ Nakhon Ratchasima, Thailand
Previous Lube/Fluids	Local Lubricants Oil
Materials	Steel (M200)
Process/Machines	Milling / CNC Machine
Customer Requirements	Quality of lubricants product

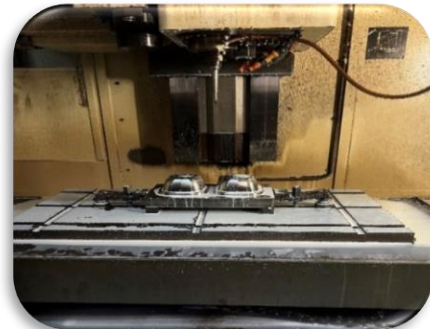
Issue/Problems:

- Poor water solubility
- Damage seals and paint of machine



Solutions:

- Randocut600 is a hard water-soluble metal working fluid milky type. The maximum hardness of water can be used is 500 ppm and good lubricity.
- Milling Process
 - ✓ Concentration: 4%-5%Brix
- CNC Machine
 - ✓ Brand: KITAMURA
 - ✓ Speed: 10000 RPM.



Summary:

- Good rust protection of machine parts and workpiece.
- Stable emulsion even with hard water.
- Long sump life, good ability to control bacterial growth and rancid odors.
- The surface of workpiece bright and clean.

