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TECHNICAL DATA SHEET



SILICONI

PRODUCTION SINCE 1957

ROCUT 200

SEMISYNTHETIC EMULSIONABLE FLUID FOR CUTTING AND METAL ADJUSTMENT

TECHNICAL FEATURES

Aspect:	clear light liquid
Viscosity at 40°C:	10-30 cSt
Slippage point:	- 18°C
Specific gravity:	1,0 g/cm ³
Dilution (water):	it creates a translucent emulsion
pH (5% emulsion):	9,5
Antirust test (DIN 51360/2):	it goes over 3%

NATURE:

The cutting emulsion is a water dispersed oil. Since the natural trend of the oil is to divide from water, the dispersion is made possible and stable through the presence of builders.

DESCRIPTION:

ROCUT 200 is a emulsionable, biostable, lubri-coolant semysintetic fluid born by a brand new conception. It's exempt from nitrites, phenols, PCB sulfur, PCT. The product is easy to mix with water and creates a translucent and emulsion with excellent stability even in tough water (40 Fr degrees). ROCUT 200, by being stable, keep the biological stability of the emulsion preventing the bacteria and fungi proliferation for long time. The product presents excellent antirust and anticorrosion characteristics even at low concentration to get a better protection of the working machines and of the manufactured products.

APPLICATION

ROCUT 200 is recommended in conventional works as metal cutting or adjustment in low concentration working plants (central systems, welded tubes making) and in hard working as drilling, milling cutting, tapping, threads, jigsaw cutting, and every other working where water-based lubricants can be used. The product is suitable for every treatment of iron materials and most of half-easy working alloys and particularly indicated for cast-iron working.

WATER:

Water is an essential component.

Avoid the use of tainted or superficially dirty water; it should be at least potable water.

Pay attention to the water tough that must be included between 15 and 40° FF (french degrees)

Ph must be around 7.

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EMULSION PREPARATION AND CONSERVATION:

Use clean containers

Pour always the oil in the water and not the opposite; the oil must be added gradually shaking the resulting emulsion in a steady and effective way.

It is advise against the use of too cold water, especially if a lower temperature than the oil.

The concentration control (contained in the emulsion oil) must be done daily through a specific device (refractometer). The value of the concentration must never be lower than the minimum indicated in the technical data sheet of the product and must never be too high. Approximately the percentage will be included between 3 and 6.

See the concentration value suggested in the table below:

It is expedient verify every few days the PH value that must never be lower than 8.

STORAGE:

Being complex and delicate mixtures, the emulsifying oil should be moved and stored with the apposite care:

Avoid off-hand jolts of temperature

Store in a closed and covered place.

Keep between 0°C and + 40 °C

Avoid longer than 6 months storage

PACKAGE

5Lt –25Lt –200Lt –1000Lt

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