

SAFKOOL 6420

MULTIPURPOSE MICRO-EMULSION FOR MACHINING

Semi synthetic fluid

DESCRIPTION

SAFKOOL 6420 is a water emulsifiable metalworking fluid concentrate dedicated for all grinding and machining operations that require high cooling and high lubricating properties.

SAFKOOL 6420 is recommended for the machining of ferrous and non-ferrous alloys, including aerospace Titanium alloys

SAFKOOL 6420 is homologated by SAFRAN for Titanium machining

Based on a very specific chemistry, **SAFKOOL 6420** is suitable for dilution in both soft and hard water.

BENEFITS

- Excellent non foaming properties
- High pressure compatible (up to 70 bars)
- HSM compatible
- Excellent lubricating & cooling properties
- Reduction of tools wear
- Good separation of tramp oils
- Good emulsion stability, even in hard waters
- Excellent bio stability
- Operator friendly
- Cleanliness of working environment

HEALTH & SAFETY

- Formaldehydes & formaldehydes releasers free
- Nitrites, glycol ether and DEA free, without chlorinated or sulfur additives
- Operator friendly: good dermatological behavior and easy to use

RECOMMENDED APPLICATIONS & DILUTIONS OF USE

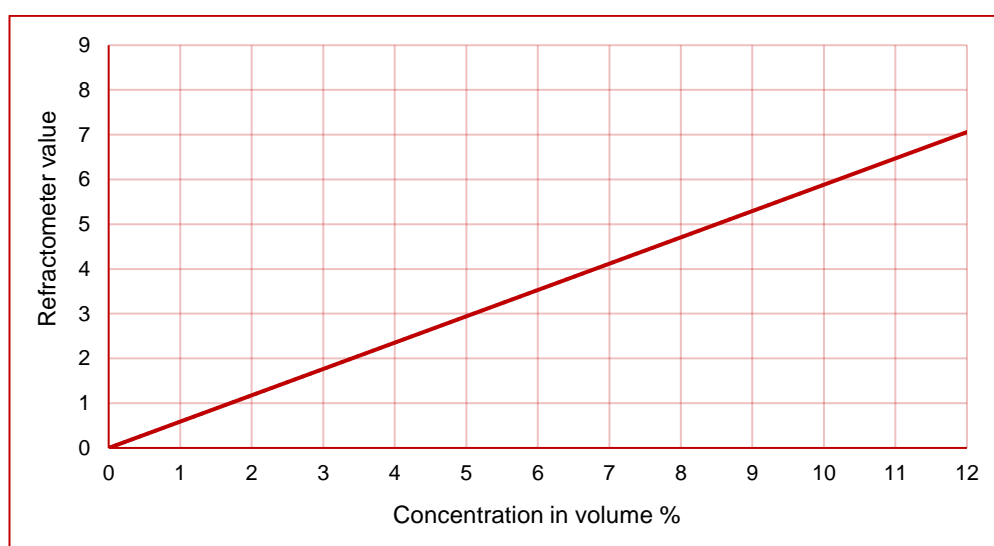
- General machining of iron and steel: 4-6%
- General machining of aluminium: 6-8%
- Tapping/ Threading/ Reaming: 8-12%
- Machining of titanium and nickel alloys: 8-15%
- Grinding: 3-6%

The refractometer reading must be multiplied by the refractometer factor to arrive at the real concentration.

SAFKOOL 6420 can be used for machining of most aluminium and copper alloys. However, we recommend to check the tendency of the alloy to stain before use.

TECHNICAL INFORMATION

TYPICAL CHARACTERISTICS	UNITS	METHOD	SAFKOOL 6420
Appearance			Clear yellow-orange
Density at 20°C		ISO 12.185	1.024
pH at 5%		NFT 60.193	9.4
Break Point Corrosion	%	IP 287	2
Water Hardness range recommended	ppm		50 - 800
Refractometer Factor			1.7



INSTRUCTIONS

Before first fill, thoroughly clean the installation with an antiseptic such as **Contram CB3**. Drain and rinse the system with water.

If no volumetric mixing system is available, slowly pour **SAFKOOL 6420** into water while stirring continuously to achieve a correct preparation of the emulsion.

To ensure the best quality of emulsion and maximize the fluid efficiency, consult the **Good Practices Handbook - Metalworking Soluble Fluids**.

SERVICE AND EQUIPMENT

In addition to its product ranges, MotulTech can provide tools and services for the maintenance and in-use monitoring of your lubricants. Please contact your technical sales representative

IMPORTANT NOTICE

All information and rules about health, safety and the environment are mentioned on the safety data sheet. It provides information about risks, safety procedures and first aid emergency rules. It clarifies all procedures to implement in the case of an accidental spillage, and for the disposal of the product and its effects on the environment.

Our product contains natural additives which are likely to modify the colour of the concentrates without altering its performance. The specifications of our products are definite only at the time of order, and are subject to our general sale and guarantee conditions. To give our customers the latest technical developments, the general characteristics of our products may vary. The safety data sheet of this product is available at www.motul.com