

SAFKOOL 6420

Micro-Emulsion for Machining

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 aluminum alloys, nickel and titanium.

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

APPLICATIONS

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.

ADVANTAGES

- SNECMA approval on aluminum and titanium (following document n °455-201-0-00 index B).
- 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.

TECHNICAL INFORMATION

NAME	UNITS	METHOD	SAFKOOL 6420
Color	-	Visual	Yellow
Aspect	-		Liquid
Density at 20°C (68°F)	-	ISO 12.185	1.025
Refractometer Factor	-		1.6
Water Hardness range recommended	ppm		50-800
Break Point Corrosion	%	IP 287	2
pH	-	NFT 60.193	9.6 at 5 %

These characteristics are given only for information and can be updated over time.

HEALTH & SAFETY

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

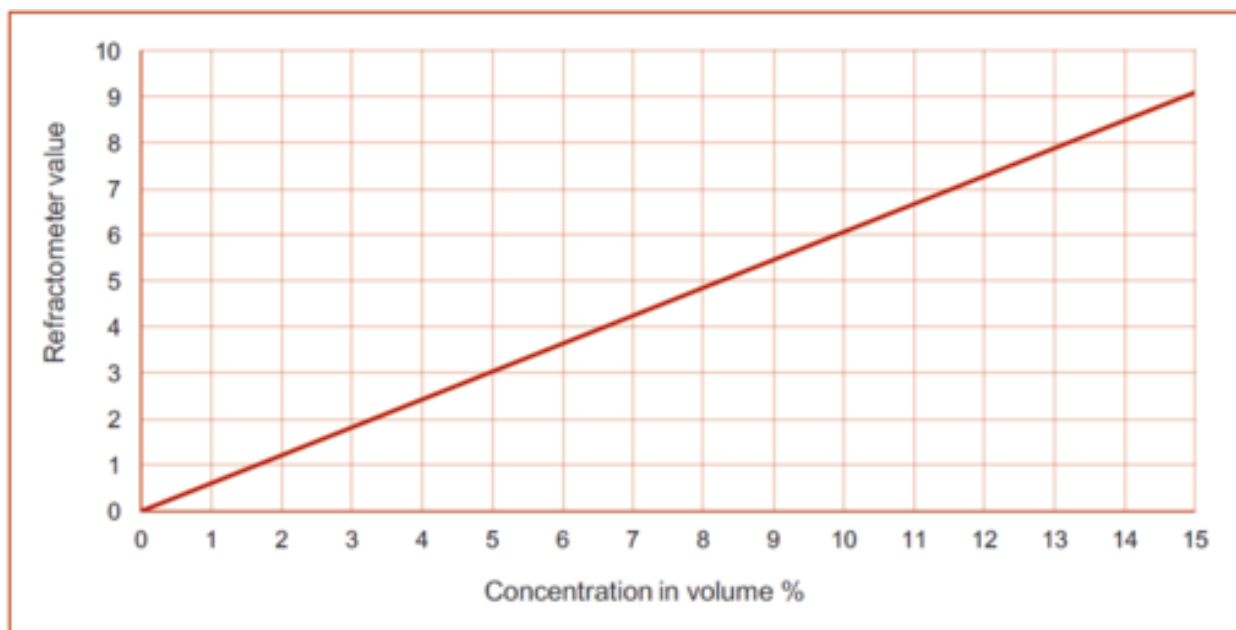
RECOMMENDED CONCENTRATIONS OF USE

- 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.



REFRACTOMETER CURVE



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**.

SERVICES AND EQUIPMENT

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