



SAFKOOL 6420

METALWORKING FLUID FOR CUTTING AND GRINDING
SEMI SYNTHETIC COOLANT

DESCRIPTION

SAFKOOL 6420 is a water emulsifiable 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 compliant with several OEM specifications for parts machining :
- **SAFRAN** Pr-6300 for 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 bio stability
- Good separation of tramp oils
- Reduction of tools wear
- Excellent lubricating & cooling properties
- Good emulsion stability, even in hard waters
- Operator friendly
- Cleanliness of working environment

**TECHNICAL INFORMATION**

TECHNICAL CHARACTERISTICS	UNITS	METHOD	SAFKOOL 6420
Aspect	-		Limpide
Density	-		1,024.0
pH	-	NFT 60.193	9.4 at 5 %
Break Point Corrosion	%	IP 287	2
Refractometer Factor	-		1.7
Water Hardness range	ppm		50-800

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

RECOMMENDED CONCENTRATIONS OF USE

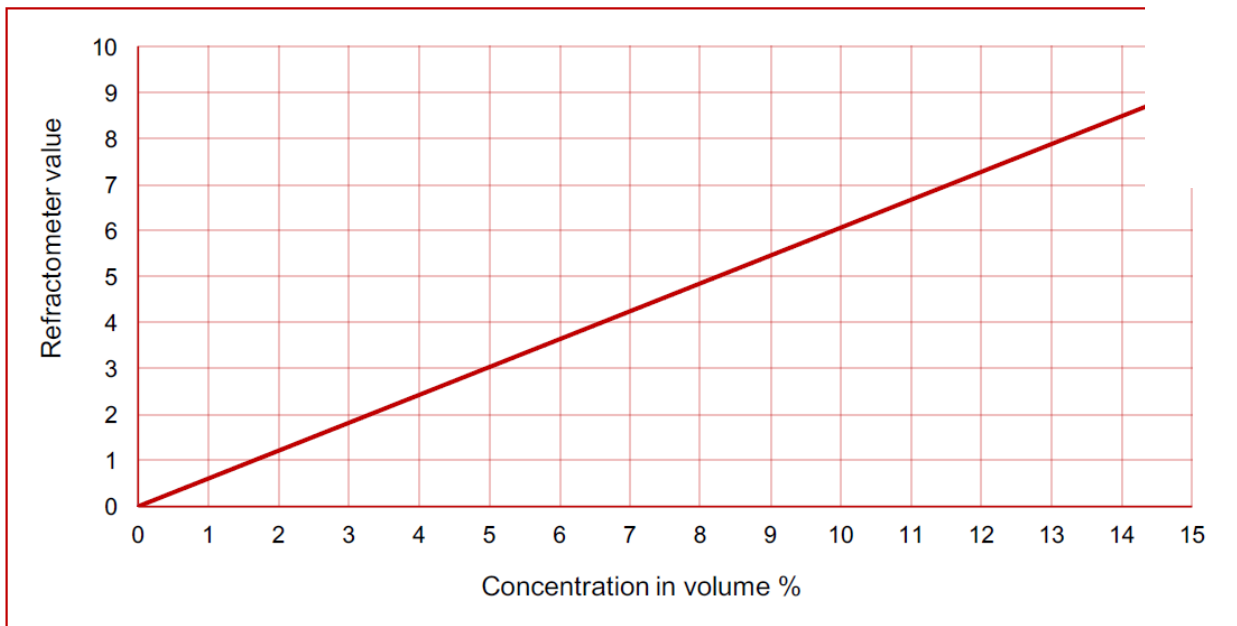
- General machining of iron and steel: 4-6%
- General machining of aluminium: 6-8%
- Tapping / Threading / Reaming: 8-12%
- Machining of titanium and nickel alloys: 8-15%
- Grinding: 3-6%

HEALTH AND SAFETY

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



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.



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. The safety data sheet is available on www.motul.com.

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.