

Adrana A 3601.04

Water miscible metalworking fluid

DESCRIPTION

Adrana A 3601.04 is recommended for heavy-duty machining operations on low silicon content aluminum and is free of amines, boric acid, nitrite, chlorine and formaldehyde releasers.

APPLICATION

Adrana A 3601.04 is suitable for heavy-duty machining operations on aluminium alloys (especially low silicon content aluminium alloys), low & high alloyed ferrous metals, and stainless steels in individual machines and central systems.

RECOMMENDATIONS FOR USE

General machining	6 – 8 %
Severe cutting operations	8 – 12 %

TYPICAL PHYSICAL PROPERTIES

TEST	TYPICAL VALUE	TEST METHOD
Mineral Oil content %	61	
Specific gravity @ 20 °C	0.940	ASTM D 1298
Viscosity @ 20 °C, mm ² /s	180 - 230	ASTM D 445
pH of emulsion @ 5%	9,1	DIN 51396
Min. Anti-Corr. Protection limit (0–0, %)	6	DIN 51360/2
Refractometer factor	0,9	
Acid split factor	1,05	

ADVANTAGES

- ❑ Good cooling properties that provide sufficient tool life and part geometry
- ❑ Very good corrosion protection – due to presence of specific anti-corrosion inhibitors; resulting in lower reject rate and lower maintenance costs
- ❑ Low foam – in water of medium hardness, guaranteeing problem free working operations and allowing high pump pressures and flow rates
- ❑ Environmental compliance – free of chlorine, amines, formaldehyde releasers, boron and nitrite
- ❑ High lubricity resulting in prolonged tool life and enhanced surface finish

STORAGE

Product should be stored under cover in clean, dry conditions and protected from frost. Recommended storage temperature is between 5°C and 35°C. Use stock in delivery rotation. A shelf life of twelve months can be anticipated.

HEALTH AND SAFETY

Health and Safety Data Sheets are supplied to customers to comply with Section 6 of the Health and Safety at Work Act 1974, and should be closely studied prior to handling or use of the product. Copies are available from your Technical Health and Safety Officer. Various other advisory publications are available from the Health and Safety Executive and Her Majesty's Stationery Office.

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All data given in this Product Data Sheet are typical of this material. It does not however constitute a specification. We reserve the right to modify products without prior notice. All products, services and information supplied are provided upon the terms of our standard Conditions of Sale from time to time in force.

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