

HOSMAC - S 818

Mineral Oil Based Metal Working Fluid Concentrate

Product Information

HOSMAC - S 818, a high performance metal working fluid is designed for the machining of steel, especially stainless steel. It is successfully used in turning, milling, broaching, gundrilling and forming operations.

HOSMAC - S 818 contains severely hydro treated base oils with low aromatic content. Natural fatty components and synthetic esters provide lubrication and reduce wear. High-performance additive combination allows superior surface quality and precision of the work piece.

Organic corrosion preventives protect machines, tools and work piece. Selected anionic and non-ionic emulsifiers create milky emulsions with superior stability.

The recommended concentration depends on the demands of the material and the machining operation. In most cases, 4 – 6% for medium operations, 5 – 8% for heavy machining and 7 – 12% for drawing and stamping operations will provide excellent results. To produce a stable emulsion, the concentrate will slowly be added to the necessary amount of tap water and stirred thoroughly. Automatic mixing devices should preferably be used.

Work piece produced with **HOSMAC - S 818** can easily be degreased with conventional alkaline industrial cleaners. For best results, please refer to our PURGON industrial cleaner product line.

Physical Properties

Concentrate

| | |
|-----------------------|----------------------------|
| Appearance | brown, high viscous liquid |
| Specific gravity 20°C | 990 kg/m ³ |
| Viscosity 20°C | 330 mm ² /s |

Emulsion

| | |
|------------------|-----------|
| Appearance | milky |
| pH-Value 2 – 10% | 9.0 – 9.4 |

Factor to determine the concentration

| | |
|---|------|
| Emulsion breaker | 1.3 |
| Refractometer | 1.0 |
| Titration (unitech test procedure 206A) | 0.37 |

Storage

During storage **HOSMAC - S 818** should not be exposed to temperatures below 0°C or above 40°C. Large temperature fluctuation also has to be avoided. It should be brought to room temperature prior to usage.

Health and Safety

Please refer to the Material Safety Data Sheet for complete information.

Disclaimer

All statements, technical information and recommendations contained in this Product Information, tests and data unitech believes to be reliable, but the accuracy or completeness is not guaranteed.

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