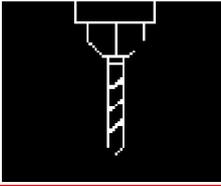


LACTUCA 3000 IN



Metalworking

Long life water soluble cutting Fluid

PRODUCT PROFILE



Lactuca 3000 IN is made out of specialty esters, rust inhibitors, biocides and EP additives. The superior anti-wear characteristic ensures quick swarf removal, thereby increasing tool life and productivity.

APPLICATIONS

- Lactuca 3000 IN is designed for use in most production engineering application which includes both individual and centralized machining system.
- Recommended for ferrous and non ferrous metal machining operations.

ADVANTAGES

- Excellent emulsion stability helps in achieving longer coolant life
- Extreme pressure property helps in improving productivity
- Reduces wheel dressing and improves tool life by avoiding welding of metals.
- Improves shelf life of machined components due to higher degree of corrosion protection.
- Extremely low foaming nature helps in better component visibility and continued lubrication
- Free from malodours reduces down time and operational cost
- Operator and environment friendly as it is chemically stable and non toxic.

TOTAL LUBRICANTS INDIA LTD.

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Date 01/09

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Typical Characteristics	Reference Method	LACTUCA 3000 IN
Colour	Visual	Light brown liquid
Density at 29.5°	ASTM D 1298	0.88
Flash point PMCC, C	ASTM D 93	155
pH of 5 % soln	ASTM D 70	8.9
Emulsion stability	IS 1115	Passes
Cast iron corrosion test	IS 1115	0/0/1
Refract meter correction factor	Internal	0.86

RECOMMENDED DILUTION CHART

Operation	Cast Iron	Stainless Steel	Non Ferrous
Turning	3- 4 %	4- 5 %	4- 5 %
Drilling	3- 4 %	4- 5 %	4- 5 %
Boring	3- 4 %	4- 5 %	4- 5 %
Milling	3- 4 %	4- 5 %	4- 5 %
Tapping	4- 5 %	5- 7 %	6- 8 %
Grinding	3- 4 %	3- 4 %	2- 3 %
Sawing	4- 6 %	5- 7 %	6- 8 %
Screw cutting	4- 6 %	5- 7 %	6- 8 %

To attain best results, the following procedure is suggested

A) PRE SYSTEM CLEANING :

Prior to the charge of fresh coolant/emulsion ensure the whole system is thoroughly cleaned. The following steps are recommended for effective cleaning.

1. Circulate the old coolant in the system with 1- 3% of cleaner for at least 24 Hrs prior to coolant change over.
2. Drain/discharge the coolant and clean the tank manually.
3. Charge the sump with water (which would be used for preparing emulsion) and circulate it for 2 hours, then drain it.
4. Recharge the system with 0.5% of proposed coolant and circulate it for 2 Hrs. Drain the coolant completely.

B) Coolant preparation :

1. Always add oil to water under agitation. Make sure that only clean container is used for mixing.
2. Do not use galvanized container.
3. Do not mix in machine sumps.

REMEMBER A GOOD MIXING ENSURES LONGER COOLANT LIFE .

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