SO-COOL MM PLUS CUTTING FLUID

Multifunctional, water miscible cutting fluid

APPLICATION

SO-COOL MM PLUS is suitable for the machining of cast iron, modular iron, steel and all other popular aluminum alloys. When used with critical aluminum alloys we recommmend a compatibility test is carried out.

The use of special amines, help it to achieve good skin compatability even with high pH values.

The product is low foaming within the commonly used mixtures, low misting and has an excellent settling out for milling abrasion.

Because of special additives with high pressure absorbing capacity SO-COOL MM PLUS is suitable for turning, drilling, milling and grinding – especially high-performance grinding operations with high quality surfaces and economical wheel durability.

ADVANTAGES / BENEFITS

- **Free of secondary alkanolamines/amides**
- **Reduced grinding burns with special additives**
- **Reduced grinding wheel consumption**
- **Increased grinding wheel life**
- **Produces outstanding surface finish**
- **Optimum wetting, cooling and flushing performance**
- **Good washing effect - keeps machines clean**
- **Low foaming**
- **Good filterability**
- **Low-misting**
- **Universally applicable for machining and grinding**

MACHINE CLEANING

To optimise service life, the machine should be flushed thoroughly using a system cleaning fluid prior to recharging with fresh fluid.

STORAGE

Soluble oil concentrates may be damaged by frost. Store indoors at ambient temperatures.

FLUID MONITORING

As with all modern cutting fluids, concentration control is of paramount importance, therefore regular check by use of a refractometer is recommended for this product. It should be noted that the individual product refractometer correction factor should always be used to ensure accuracy.

COMPONENT PROTECTION

Following manufacturing operations Cromwell recommends the use of our fully compatible cleaners and corrosion preventives to clean and protect your components. Please refer to data sheets, or contact your local Cromwell Area Manager to discuss your requirements.

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APPLICATION CONCENTRATION

To ensure the optimum corrosion protection, and lifetime of the emulsion, we recommend a concentration of at least ≥ 6%.

However, the ultimate concentration must also be compatible with the materials involved and the machining operation.

MIXING TEMPERATURE

The optimum mixing temperature for water and concentrate is 15 – 20°C.

Our Application Specialists will be pleased to advise you regarding specific applications.

Changes in colour and slight sedimentations in the water-miscible cutting fluid concentrate have no adversely effect on the quality or the performance of the product.

TECHNICAL DATA

Characteristics	Unit	Result	Test Method
Density at 15°C	g/ml	1.01	DIN 51 757
Kinematic viscosity at 40°C	mm^2/s	35	DIN 51 562-1
Corrosion test emulsion ≥ 4%	Degree of corrosion	0 – 0	DIN 51 360-2
pH value, 5% emulsion		9.6	DIN 51 369
Refractometer correction factor		2.1	

Note: Refractometer Reading x Correction Factor = Actual Concentration

AVAILABLE PACK SIZES

Grade Name	Pack Size	Part Number
SO-COOL MM PLUS CUTTING FLUID	20ltr	SOL-740-5332F
	205ltr	SOL-740-5333M

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