

rhenus FU 60

rhenus FU 60 is a water-miscible EP metalworking fluid on synthetic ester basis free of mineral oil offering high performance and maximum protection for operator and machine.

Application

rhenus FU 60 is a multi-purpose coolant suitable for heavy machining operations of aluminium alloys, high tensile steels, titanium alloys and special materials. Excellent results are also achieved for non cutting forming operations.

Properties

- very finely dispersed, good flushing effect
- good protection against corrosion
- good skin tolerance
- no chlorine, no nitrite, no mineral oil
- resistant to micro-organisms
- high oxidation stability
- good residual properties
- EP effect (Reichert) at 5 %: 22 mm²
- water hazardous class 1

Technical data

Concentrate		Emulsion	
Viscosity at 20 °C (mm ² /s)	Ester oil content %	pH value fresh prep. at 5%	Corrosion protection (DIN 51360/2) at 4 % grade 0
180	approx. 44	9,0	

Remarks

rhenus FU 60 is approved for applications in the aircraft industry from Airbus and Rolls-Royce.

rhenus FU 60 does not contain ingredients commonly known as "silicon". **rhenus FU 60** contains polysiloxanes modified with polyethers which demonstrably can be removed with usual cleaning methods and which do not have any influence on the subsequent surface treatment.

To prepare operating emulsion slowly add the coolant concentrate to drinking quality water assuring thorough mixing. Mixing can also be done by means of an automatic mixer.

Recommended mixing ratio:

Machining of aluminium alloys and steels:	5 - 10 %
Machining of Titanium alloys:	7 - 10 %
Punching and drawing	10 - 20 %

The concentration of the operating emulsion can be determined by means of a pocket refractometer. The Brix value multiplied by the refractometer value equals the concentration in %. Sometimes reading of scale is more difficult with older emulsions because of the more coarse dispersity.

Refractometer factor

1.1

Rhenus metal working fluids are free of chlororganic substances, nitrite and secondary amines. They contain natural raw materials. Therefore, slight degradations of colour and appearance are possible, however, quality and function of the product are not affected at all.

Subject to modification of the technical data. Please refer to the material safety data sheet for additional information or contact our application engineers.

Edition

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