



TECHNICAL DATA SHEET

WS-500A

Water-Soluble Oil Metalworking Fluid Concentrate

DESCRIPTION

WS-500A is a quality moderate-duty, water-soluble oil with non-chlorinated extreme-pressure additives that are ideal suited for machining titanium. It has lubricity for extended tool life and offers great corrosion protection.

APPLICATIONS

- Light to moderate-duty operations
- General machining

MATERIALS COMPATIBILITY

- Recommended for ferrous metals, aluminum, and titanium
- Limited use for brass, bronze, and copper

PHYSICAL PROPERTIES

<i>Concentrate Color</i>	Dark brown
<i>Dilute Color</i>	Milky white
<i>pH at 10%</i>	9.2
<i>Specific Gravity</i>	0.93
<i>Density</i>	7.8 lbs/gal (934 kg/m ³)
<i>Flash Point</i>	320°F (160°C)
<i>Boiling Point</i>	212°F (100°C)
<i>Chlorine</i>	None
<i>Mineral Oil</i>	74%
<i>Refractometer Readings</i>	10:1 = 11.0 20:1 = 5.6 30:1 = 3.1

DILUTION RATIOS

- Milling, drilling, boring, turning, threading, broaching 10:1 – 20:1
- Form grinding..... 10:1 – 15:1
- Centerless grinding..... 25:1 – 30:1

AVAILABLE IN

5 gal.....	74055
55 gal.....	74555

HEALTH AND SAFETY

Refer to MSDS (Material Safety Data Sheet) for complete information on health and safety on our web site at www.rocolnorthamerica.com.

For additional information please contact our Customer Service Department at 800-452-5823 ext. 2.

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