

# DOILLCUT 100

## Metal Working Fluid Mineral

### Usage

15 Kg | T244692768  
20 L | T244692774  
180 Kg | T244692791  
850 Kg | T244692798

**DOILLCUT 100** is a multi-purpose metalworking fluid used by mixing 5%-10% with water in the processing of various metals (cutting and grinding). It is very suitable as a lubricant and coolant in light and heavy machining operations of metals such as aluminum and copper alloys, mild steel and cast iron (machining) and hot drawing of aluminum bars (chipless manufacturing). It cools perfectly. Warning: Adding oil to the water in emulsion preparation should be done slowly while the water in the tank is circulating. Water should never be added to oil. The tank must be completely emptied and cleaned before preparing new emulsion. Plain water should never be used for emulsion additions. Necessary additions should be made with emulsion of appropriate concentration prepared in a separate tank.

**DOILLCUT 100** should be added gradually into the full volume of water - **never the reverse**, and gentle agitation maintained until all the oil has been added and a uniform emulsion obtained. Use lower concentration for top-up to achieve recommended mix-ratios.

**Applications:** General Machining, Grinding, Aluminium Machining.

**Materials:** Low to medium tensile steels, Aluminium, copper and their alloys.

**Storage:** The product should be stored under cover. Avoid extremes of temperature and protect from frost. Packages should be kept sealed when not in use.

	DOILLCUT 100
Product Features	
Kinematic Viscosity @ 40 C, mm <sup>2</sup> /s, ASTM D445	30,7
Density 15 °C, kg/litre ASTM D4052	1B
Refraktif İndeks ASTM D1218	1
Emulsion pH 20 °C (5% mixture with deionized water)	8,6

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