

SOLUBLE METAL WORKING OIL ADDITIVE

Introduction

AC 5020 is a base additive system formulated to emulsify paraffinic mineral oils in a viscosity range of 22-32 cst at 40°C. It is a carefully balanced formula containing emulsifiers and anti-corrosion agents to provide exceptional emulsification, low foaming and rust protection.

Typical Characteristics.

| | |
|-------------------------|----------------------|
| Appearance | Brown Viscous Liquid |
| Specific Gravity @ 85°F | 0.891 |
| Viscosity @ 40°C | 38-40 |
| pH value (1% in D.W) | 9.5-10.5 |

Recommended Dosage Rates

AC 5020 can be used at a concentration between 18% to 20% for soluble oils in SN-150 or SN-100 base oils. Better results are achieved if naphthenic base oils of same ISO VG range are used due to their low aniline points and high VGC.

Features and Benefits

- Outstanding oil-in-water emulsion stability.
- Excellent corrosion inhibition.
- Hard water tolerance.
- Low foam profile.
- Stable soluble oil concentrates.
- Easily forms highly dense white emulsion.

Typical Characteristics for Blended oils

Oils formulated with AC 5020 have following usual characteristics.

| | |
|-------------------------|--------------------------|
| Color (ASTM D1500) | 2.5 |
| Specific Gravity @ 60°F | 0.869 |
| Specific Gravity @ 85°F | 0.860 |
| pH value 5% Emulsion | 8.0-9.0 |
| Emulsion Stability | Milky for 72 hrs @ 30°C |
| Rust Preventive Test | Break point at 9% IP 287 |

Use Dilutions

Typical dilutions for various applications are as follows

| | |
|----------------------------|-------|
| Grinding | 2-5% |
| Milling, Drilling, Turning | 5-8% |
| Reaming, Tapping | 8-10% |

Storage and Handling

AC 5020 can be stored satisfactorily in dry, mild steel drum below 30°C, out of direct sun-light and rain fall. Avoid skin and eye contact.

Packaging.

200 LTR drum
Bulk ISO

