

ORACOOOL 400

DESCRIPTION

Orapi is a multi-purpose EP Nitrite free emulsifiable metal working / cutting fluid containing a highly sophisticated system of extreme pressure additives, anti-foam, anti-rust and anti-bacterial agents which forms a stable milky white emulsion *when added to water*.

ANTI-FOAM ADDITIVE

The anti-foam additive is a **non-silicone, non-ionic, mineral hydrocarbon** based foam control agent. Because of its chemical nature and resistance to 'plating out', the additive produces long term stability both in the concentrate and the resultant fluids. The absence of silicone eliminates the possibility of 'fish eyeing' in subsequent processes such as painting, anodizing and powder coating.

EP ADDITIVE

The SP additive is chlorine based branched chain, near pure compound. The additive is not genotoxic, resulting in its acceptance by General Motors (international) for use in its plants.

APPLICATION

Basically, water soluble emulsions are used in operations where the necessity for good cooling outweighs the need for lubrication. Other effects such as economy, corrosion inhibition, disposal of spent coolant, etc. must be considered and may have a decisive effect on the choice of cutting fluid. An intrinsic characteristic of Oracool 400 is its inbuilt protection against bacteria. This is more effective and longer lasting than the proteos offered by added bactericides.

To produce a homogeneous emulsion, Oracool 400 should **always be added to water** (with agitation). **DO NOT** add water to the oil.

DILUTION RATES:

General machining operations	5%
Stainless and High tensile steels	10%
Machining Cast Iron	4%

Note: The above ratios are intended as a guide only. Variations in machining operations may require alterations to oil content required. In isolated cases, emulsions may be found to be unsuitable for some operations.

STANDARD PACKAGING 20 litre.

Victoria Lub Pty Ltd cannot know about every application for which the products are used nor their conditions of use. Victoria Lub Pty Ltd cannot be held responsible for the suitability of the products for a given use or a specific purpose. The information contained here can on no account be a substitute for the preliminary tests which are essential and which must be carried out in order to check the suitability of the product to each specific case.